

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016351**Date Inspected:** 05-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Mr. Qiu Wen/ Mr. Zhao Chen Sun	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes No N/A	Approved WPS:	Yes	No N/A
		Delayed / Cancelled:	Yes	No N/A
Bridge No:	34-0006	Component:	Tower	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance(QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay no. 11

1. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 046704 perform SMAW welding on; Lift 5, interior splice plate and the weld joint is identified as ESD1-SPSA5-17-2A. ZPMC CWI Identified as Mr. Yu Dong Ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3211-TC-U5B-1. (Photo attached)

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 054460 perform SMAW welding on; Lift 5, interior splice plate and the weld joint is identified as WSD1-SPSA5-17-1A. ZPMC CWI Identified as Mr. Yu Dong Ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3211-TC-U5B-1.

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040656 perform SMAW welding on; Lift 5, interior splice plate and the weld joint is identified as WSD1-SPSA5-7-3B. ZPMC CWI Identified as Mr. Yu Dong Ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3211-TC-U5B-1.

4. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 046709

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

perform SMAW welding on; East shaft, Lift 5, Grillage plate to intersection diaphragm plate and the weld joint is identified as ESD1-TL5-2 F/F-9B. ZPMC CWI Identified as Mr. Fu Guo Gang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3213-TC-U5b.

5.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040610 perform SMAW welding on; East shaft, Lift 5, Grillage plate to intersection diaphragm plate and the weld joint is identified as ESD1-TL5-2 B/F-13. ZPMC CWI Identified as Mr. Fu Guo Gang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3213-TC-U5b.

6.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 066401/037996 perform SMAW welding on; West shaft, Lift 5, Grillage plate to intersection diaphragm plate and the weld joint is identified as WSD1-TL5-4 B/F-29A/B. ZPMC CWI Identified as Mr. Fu Guo Gang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3213-TC-U5b.

Bay no.10

7.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040273/057259 perform SMAW welding on; South shaft, Lift 5, intersection diaphragm plate to inside Skin C and the weld joint is identified as SSD1-TL5-1 B/F-12. ZPMC CWI Identified as Mr. Qiu Wen. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3213-TC-U5b.

8.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040581 perform SMAW welding on; Base plate of Façade plate and the Façade plate is identified as SFSA4-322. ZPMC CWI Identified as Mr. Qiu Wen. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-2G (2F)-Repair.

9.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 053870 perform FCAW welding on; Lift 13 Components, Bike path and the weld joint is identified as BK 004 A6-027-15, 16. ZPMC CWI Identified as Mr. Qiu Wen. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2133.

Heavy Dock Jetty

10. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 050038 perform SMAW Repair welding on; Temporavary attachment removal areas surface repair on North shaft, Lift 2 and the area identified as Skin B, of approx. 82 mtr. elevation. ZPMC CWI Identified as Mr. Zhao Chen Sun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-2G (2F)-Repair. (Photo attached)

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Micheal Ng (15921845703), who represents the Office of Structural Materials for your project.

Inspected By: Baskar, Govindarajan

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer