

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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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-016357**Date Inspected:** 15-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

<b>CWI Name:</b>	Mr. Qiu Wen	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	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.10

1. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040582 perform SMAW welding on; South shaft, Lift 5, Intersection diaphragm plate to Skin D and the weld joint is identified as SSD1-TL5-1B/F-18. 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. (Photo attached)

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 050289 perform SMAW welding on; South shaft, Lift 5, Intersection diaphragm plate to Skin A and the weld joint is identified as SSD1-TL5-1B/F-10. 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-U4C.

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 037932 perform SMAW welding on; North shaft, Lift 5, Intersection diaphragm plate to Grillage plate and the weld joint is identified as NSD1-TL5-3B/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.

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4. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040581 perform FCAW welding on; Lift 13 Component, Bike path and the weld joint is identified as BK 004A6 -031-113. 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-2131.

5. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040581 perform SMAW welding on; South shaft, Lift 4, Mounting plate on Skin A and the weld joint is identified as CAMPA-4-4,5,6. 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-P-2113 and WPS-B-P-2112.

Bay no. 11

6. This QA inspector, Baskar Govindarajan, performed, Overall length, Flange to flange distance, stiffener to stiffener distance, 1:1 slope between Flange to Web CJP weld and distance between Flange to web weld toe and stiffener end weld measurements of Spare tower strut no. WD1-STSA4-119mtr. -1 and WD1-STSA4-123 mtr.-1. This measurement of distance was carried out along with QA Inspector Mr. Shailesh Gaikwad whose lot no. is B 295. All the reading taken has handed over to Task Leader.

### Magnetic Particle Testing:

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report for this date. The member is identified as OBG Side panel plate (Notification no. 06404), and Tower Strut (Notification no. 06403). One longitudinal Linear indication discovered in weld no. SP3113-001-050 OF Side panel no. SP3113A. Incident report rose for the same. Photo attached with this report. The weld designations reviewed are as follows:

SP 3113-001 - Jt. nos – 39,40,41,42,55,56,47,48,49,50,51,52,53,54,61,62,91,89,101,102 –Side panel

WD1-STSA4-119m-1 - Jt. nos – 47A,47B,48A,48B,24,26,28,7A,45 –Tower strut

WD1-STSA4-123m-1 - Jt. nos – 5A,5B,46,9,10,6A,6B,42 –Tower strut

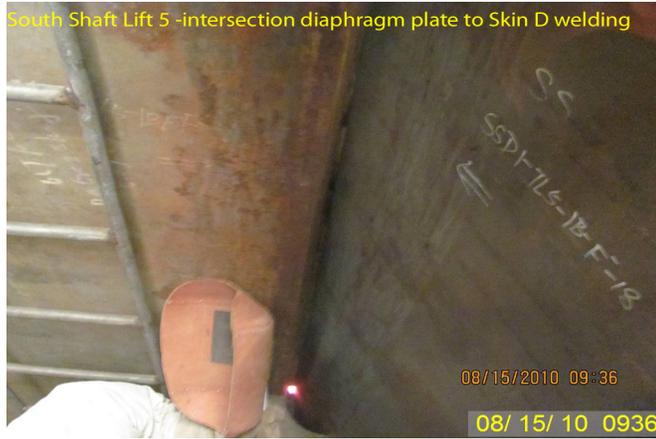
Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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## Summary of Conversations:

No Relevent Conversation

## 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.

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**Inspected By:** Baskar, Govindarajan

Quality Assurance Inspector

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**Reviewed By:** Clifford, William

QA Reviewer