

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-016500**Date Inspected:** 21-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. Xu Le Feng**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 040759/046706 perform FCAW welding on; OBG Edge plate and the weld joint is identified as EP 3030A-001-9, 10. ZPMC CWI Identified as Mr. Xu Le Feng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132. (Photo attached)

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040655 perform SMAW welding on; East shaft, Lift 5, Intersection diaphragm plate to Skin E and the weld joint is identified as ESD1-TL5-2B/F-6B. ZPMC CWI Identified as Mr. Xu Le Feng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3213-TC-U4C. (Photo attached)

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 046769 perform SMAW welding on; East shaft, Lift 5, Skin A to Grillage plate and the weld joint is identified as ESD1-TL5-2B/F-2A. ZPMC CWI Identified as Mr. Xu Le Feng. 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 067611 perform SMAW welding on; West shaft, Lift 5, interior splice plate to Skin E and the weld joint is identified as WSD1-TL5-4E/F-32A. ZPMC CWI Identified as Mr. Xu Le Feng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3211-TC-U5B.

Bay no.10

5. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 042336 perform SMAW welding on; South shaft, Lift 5, Intersection diaphragm plate to Grillage plate and the weld joint is identified as SSD1-TL5-1B/F-20. ZPMC CWI Identified as Mr. Xu Le Feng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3213-TC-U4c.

6. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 066038 perform SMAW welding on; North shaft, Lift 5, Intersection diaphragm plate to Skin A -Outside and the weld joint is identified as NSD1-TL5-3B/F-20B. ZPMC CWI Identified as Mr. Xu Le Feng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3213-TC-U5b.

7. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 053870 perform FCAW welding on; Façade seal angle and the weld joint is identified as ND1-SFSA4-348- 15, 16. ZPMC CWI Identified as Mr. Xu le Feng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2132.

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 Lift 13, OBG Bike path plates (Notification no. 06450).The weld designation reviewed is as follows:

BK004A3-017 - Jt. nos – 12,14,13,63,64,69,70,71,72 –Bike path-8A

BK004A6-017 - Jt. nos – 53,54,150,22,21,17,18 –Bike path-8C

BK004A4-017 - Jt. nos – 84,01,02,35,36,172,173,27,28 –Bike path-10A

BK004A6-017 - Jt. nos – 44,94,41,190,186,191,187,42,43,188,189 –Bike path-9C

BK004A6-017 - Jt. nos – 112,53,54,51,52,210,211 –Bike path-9A

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 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
