

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-016505**Date Inspected:** 26-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. 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.

Heavy Dock Jetty

1. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040365 perform SMAW welding on; Cross Bracing Gusset and Skin E of North shaft, Lift 3, in 89 mtr. elevation and the weld joint is identified as WD1-GUSA3-3-89 mtr.-N-4B. 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-B-P-2214-TC-U5B-FCM. (Photo attached)

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 052910 perform SMAW welding on; Cross Bracing Gusset and Skin E of South shaft, Lift 3, in 89 mtr. elevation and the weld joint is identified as WD1-GUSA3-3-89 mtr.-S-4B. 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-B-P-2214-TC-U5B-FCM.

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040690 perform SMAW welding on; Cross Bracing Gusset and Skin E of East shaft, Lift 3, in 109 mtr. elevation and the weld joint is identified as WD1-GUSA3-3-109 mtr.-E-4A. 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

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

WPS-B-P-2212-TC-U5B-FCM. (Photo attached)

4. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 058026 perform SMAW welding on; Cross Bracing Gusset and Skin A of West shaft, Lift 3, in 109 mtr. elevation and the weld joint is identified as WD1-GUSA3-3-109 mtr.-W-3A. 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-B-P-2212-TC-U5B-FCM

Bay no.10

5. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 066422 perform SMAW welding on; North shaft, Lift 5, Intersection diaphragm plate to Grillage plate and the weld joint is identified as NSD1-TL5-3 F/F-15. ZPMC CWI Identified as Mr. Ye Yong Jun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3313-TC-P5.

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 North shaft, Lift 2 –External and Internal pre blast after repair inspection (Notification no. 06485).The weld designation reviewed is as follows:

Skin CArc gouge – 68 mtr.-North shaft, Lift 2-After Blasting
Skin EArc gouge – 3880 from Bottom.-North shaft, Lift 2-After Blasting
NSD1-TL5 C/L –Jt. no. 195 –Porosity - North shaft, Lift 2-After Blasting
NSD1-TL5 C/L –Jt. no. 201 –Flame cut - North shaft, Lift 2-After Blasting
NSD1-TL8 F/L –Jt. no. 195 –A/E Corner - North shaft, Lift 2-After Blasting

Visual Inspection Testing:

This QA inspector performed Visual Inspection (VT) of 100% of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as North shaft, Lift 2 –External and Internal pre blast after repair inspection (Notification no. 06485). The weld designations reviewed are as follows:

Skin A Notch – 5 mm from Top-North shaft, Lift 2-After Blasting
Skin A Flame cut – 58 mtr.-North shaft, Lift 2-After Blasting
Skin D Notch – 200 mm from Top-North shaft, Lift 2-After Blasting
Skin E Stiffener – Porosity @59 mtr.-North shaft, Lift 2-After Blasting
NSD1-TL8F/L – Jt. no. 114-Skin B-North shaft, Lift 2-After Blasting

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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



Summary of Conversations:

No relevent 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
