

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016680**Date Inspected:** 01-Sep-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/Mr. Qiu Wen			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 040656 perform SMAW welding on; Interior splice plate, Lift 5 and the weld joint is identified as WSD1-SPSA5-7-2A. 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-3211-TC-U5B-1.

Bay no. 10

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 052930/057220 perform SMAW welding on; South shaft, Lift 5, Skin C to Grillage plate and the weld joint is identified as SSD1-TL5-1 B/F-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-3213-TC-U4c. (Photo attached)

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-TL5-3 B/F-10. ZPMC CWI Identified as Mr. Qiu Wen. The welding parameters as

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measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3213-TC-U4c.

4. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 037743 perform SMAW welding on; North shaft, Lift 5, Skin D to Grillage plate and the weld joint is identified as NSD1-TL5-3 B/F-4. 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.

5. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 053870 perform FCAW welding on; Lift 14, OBG Components, Bottom plate and the weld joint is identified as BP 3089-001-001. 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-2231-B-U2-F.

6. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 050360 perform SAW welding on; Lift 14, OBG Components, Bottom plate and the weld joint is identified as BP 3089-001-001. 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-2221-B-U2C-S-2.

Heavy Dock Jetty

7. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 052910 perform SMAW welding on; Cross Bracing Gusset and Back fill plate on Skin A of North shaft, Lift 3, in 109 mtr. elevation and the weld joint is identified as NSD1-FASA3-1 B/E-29, 30. 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-T-4212-TC-U4C-4. (Photo attached)

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 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
