

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-016683**Date Inspected:** 07-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. Yu Dong Ping /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.

Heavy Dock Jetty

1. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 046769 perform SMAW welding on; Cross Bracing Gusset and Back fill plate on Skin A of East shaft, Lift 3, in 99 mtr. elevation and the weld joint is identified as ESD1-FASA3-2 B/E-26. 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-4214-TC-U4C-4.
2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 057266 perform SMAW welding on; Cross Bracing Gusset and Back fill plate on Skin A of South shaft, Lift 3, in 99 mtr. elevation and the weld joint is identified as SSD1-FASA3-1 B/E-21. 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-3212-B-U2a-2.
3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040582 perform SMAW welding on; Cross Bracing Gusset and Back fill plate on Skin A of West shaft, Lift 3, in 99 mtr. elevation and the weld joint is identified as WSD1-FASA3-2 B/E-23. ZPMC CWI Identified as Mr. Zhao Chen Sun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance

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with WPS-B-T-4214-TC-U4C-4. (Photo attached)

4. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 044511 perform SMAW welding on; Cross Bracing Gusset and Back fill plate on Skin A of North shaft, Lift 3, in 89 mtr. elevation and the weld joint is identified as NSD1-FASA3-1 C/E-18, 19. 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-4212-TC-U4C.

5. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 052930 perform SMAW welding on; Cross Bracing Gusset and Back fill plate on Skin A of South shaft, Lift 3, in 89 mtr. elevation and the weld joint is identified as SSD1-FASA3-1 C/E-22, 23. 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-4212-TC-U4C.(Photo attached)

6. 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-23. 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-4212-TC-U4C.

Bay no. 11

7. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 049220 perform FCAW welding on; Lift 14, OBG Components, Bottom plate and the weld joint is identified as BP 3093-001-013, 014. 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-2132.

Bay no. 10

8. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 056200 perform SMAW welding on; South shaft, Lift 5, Skin E to Intersection diaphragm plate and the weld joint is identified as SSD1-TL5-1 B/F-33A. 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.

9. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 052493 perform SMAW Repair welding on; South shaft, Lift 5, Grillage plate to Intersection diaphragm plate and the weld joint is identified as SSD1-TL5-1 F/F-4A. 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-485-SMAW-3G (3F)-Repair.

Visual Inspection Testing:

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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 Final tension verification of Skin B, Manhole opening in East, West, South and North shafts, Lift 2 at Tower trial assembly, Heavy Dock Jetty (Notification no. 00477). Photo attached with this report. The weld designations reviewed are as follows:

- Skin B Manhole cover – East shaft
- Skin B Manhole cover – West shaft
- Skin B Manhole cover – South shaft
- Skin B Manhole cover – North shaft

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



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