

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-016934**Date Inspected:** 11-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. 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. 10

1. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 044473/052075 perform FCAW welding on; Lift 14, OBG Components, Bottom plate and the weld joint is identified as BP 3090-001-149, 150. 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-2132. (Photo attached)

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 052493 perform SMAW Repair welding on; Skin A to Intersection diaphragm plate in South shaft, Lift 5 and the weld joint is identified as SSD1-TL5-1 B/F-7 A/B. 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.

Bay no. 11

3." This QA Inspector was instructed by Lead Inspector Albert Carreon to request that ZPMC personnel allow him to inspect the container that supplier LeJuen bolts originally shipped to ZPMC in order to ensure traceability of the bolts in question. ZPMC representative Lai Tau refused to provide this QA Inspector or the Lead Inspector for

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(Doubler plate to Face B skin –M24 X 130 -64 nos) with the location of the container." Other Bolts, 1.Tower Skirt ring beam –M27 X120 -40 nos, M27 X130 -350 nos, M27X 150 -120 nos, 2. Doubler plate to Face B skin –M24 X 130 -64 nos and 3. Doubler plate to Face E skin –M24 X 150 -64 nos found in order in terms of quantity, Sizes and Rocap nos. These Bolts found in Metal cans except Doubler plate to Face B skin –M24 X 130 -64 nos. (Photo attached)

4. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 046706 / 205649 perform FCAW welding on; Lift 14, OBG Components, Bottom plate and the weld joint is identified as BP 3092-001-015, 016. 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.

Heavy Dock Jetty

5. 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-24. 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.

Ultrasonic Testing:

This QA inspector, Baskar Govindarajan, performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted at Tower components by ZPMC Quality Control personnel. This QA Inspector generated a TL-6027 UT report for this date. The member is identified as South shaft, Lift 5, Grillage plate welds at Bay no. 10. (Notification no. 006647). The weld designation reviewed is as follows:

SSD1- TL5-1 F/F – Jt. nos – 13, 16, 25, 28 A/B –South shaft, Lift 5

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