

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016937**Date Inspected:** 14-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**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 & ZPMC Ware house

1. " 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. On Saturday, 11th Sep. 2010, ZPMC representative Lai Tau refused to provide this QA Inspector or the Lead Inspector for (Doubler plate to Face B skin -M24 X 130 -64 nos) with the location of the container. These Bolts (M24 X 130 -64 nos) were offered for inspection today, This QA inspector observed that at warehouse of ZPMC, these bolts are the same which have found in paper boxes at Bay no. 11. The Rocop no. found to be DHGM240025." (Photo attached)

Heavy Dock Jetty

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040614 perform SMAW welding in; Cross Bracing Gusset and Back fill plate on Skin A of West shaft, Lift 3, in 109 mtr. elevation and the weld joint is identified as WSD1-FASA3-2 B/E-21, 28. 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. (Photo of Preheating is attached)

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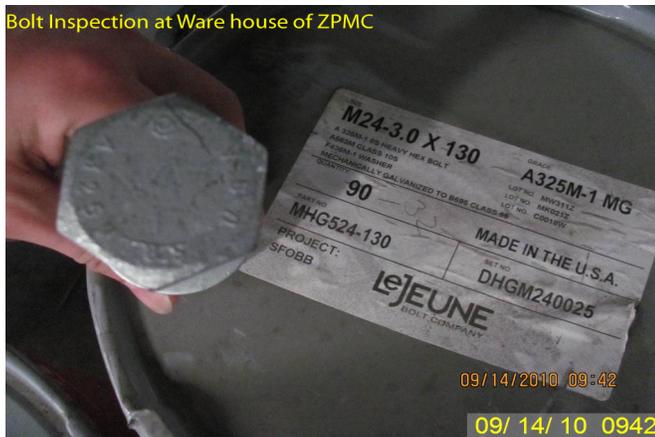
3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 046769 perform SMAW welding on; Cross Bracing Gusset and Back fill plate on Skin A of East shaft, Lift 3, in 109 mtr. elevation and the weld joint is identified as ESD1-FASA3-2 B/E-27, 34. ZPMC CWI Identified 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. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040365 perform SMAW Repair welding on; Cross Bracing Gusset and Back fill plate on Skin A of North shaft, Lift 3, in 99 mtr. elevation and the weld joint is identified as NSD1-FASA3-1 B/E-28. 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-345+485-SMAW-2G (2F)-Repair. The Welding Repair Report (WRR) found to be WR-3587.

5. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 052910 perform SMAW Repair 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-485-SMAW-2G (2F)-Repair. The Welding Repair Report (WRR) found to be WR-3588.

6. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 052910 perform SMAW Repair 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-28. 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-485-SMAW-2G (2F)-Repair. The Welding Repair Report (WRR) found to be WR-3589.

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
