

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-016941**Date Inspected:** 20-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.

Heavy Dock Jetty

1. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040610 perform SMAW Repair welding on; Cross Bracing Gusset and Back fill plate on Skin A of East shaft, Lift 3, in 89 mtr. elevation and the weld joint is identified as ESD1-FASA3-2 C/E-19. 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-4G (4F)-FCM-Repair-2. (Photo attached).

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 044511 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-345+485-SMAW-2G (2F)-FCM-Repair-2. The Welding Repair Report (WRR) found to be T-WR-3632.

3. 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

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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)-FCM-Repair-2. The Welding Repair Report (WRR) found to be T-WR-3633.

4. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 050038 perform SMAW Repair 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. 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)-FCM-Repair-2. The CWR for the repair found to be T-CWR-686.

Bay no. 11

5. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040759 perform FCAW welding on; OBG bike path components and the weld joint is identified as BK 004A1-017-005. 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-2232-TC-U4C-F.

6. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 053316 perform FCAW welding on; OBG bike path components and the weld joint is identified as BK 004A1-017-008. 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-2232-B-U2F.

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



Summary of Conversations:

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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
