

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-017497**Date Inspected:** 26-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**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 057266/057180 perform FCAW welding on; OBG bike path components and the weld joint is identified as BK 004A3-029-051, 052. 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 053116/054069 perform FCAW welding on; OBG bike path components and the weld joint is identified as BK 004A7-029-013, 014. 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.

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040268 perform SMAW welding on; Tower Façade plate assembly components and the weld joint is identified as SD1-SFSA3-22- 3,4 and SD1-SFSA5- 9, 10. ZPMC CWI Identified as Mr. Zhang Huang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-p-2114. (Photo attached)

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Bay no. 11

4. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 046769/041271 perform SMAW welding on; Tower Lift 5 Bracket components and the weld joint is identified as SD1-BRSA5-1- 9A, 13A. 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-3213-TC-U4B.

5. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 044541/054460 perform SMAW welding on; Tower Lift 5 Bracket components and the weld joint is identified as SD1-BRSA5-2- 10B, 14B. 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-3213-TC-U4B.

6. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040723 perform FCAW welding on; OBG bike path components and the weld joint is identified as BK 004A1-021-008. 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-P-2214-B-U2.

7. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040723 perform FCAW welding on; OBG bike path components and the weld joint is identified as BK 004A5-021-134. 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-P-2212-B-U2.

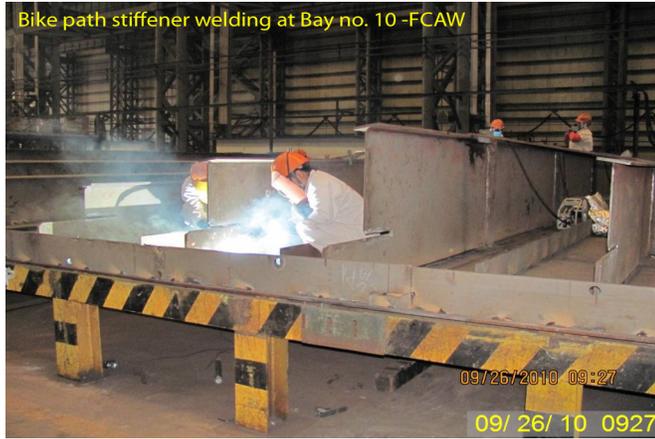
Bay no. 12

8. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 059403 perform FCAW welding on; OBG Splice plate sub assembly channels and the weld joint is identified as SA31114-018-001, 002. ZPMC CWI Identified as Mr. Yang Bai Qiang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-TC-U4B-F.

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