

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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006527**Date Inspected:** 23-Apr-2009**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:** ZPMC and ABF**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:** SAS tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Wai Pau, was present during the times noted above for observations relative to the work being performed.

Bay #10 South and North Tower Shop

East Tower Lift #2:- Caltrans QA Inspector observed three ZPMC workers performed grinding process on the inner corner longitudinal seam weld of skin plate B to C. The grinding weld areas are located at elevation 68m to 74m of diaphragm section. The grinding processes are removing and repair the fillet welds that have been rejected by ZPMC VT inspection. Base on Caltrans observation, no discrepancies were noted.

West Tower Lift#2:- Caltrans QA Inspector observed four welder performed FCAW process on fit lug welds of diaphragm that connected skin plate C. The fit lug welds are located at elevation 53m to 80.7m diaphragm section. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

East Tower Lift#1:- Caltrans QA Inspector observed four grinders and a welder performed grinding and FCAW repair process on fit lugs and rat holes of diaphragm that connected skin plate A. The fit lugs and rat holes are located at elevation 9m to 47.6m diaphragm section. The grinding and FCAW welding process are removing and repair the fillet welds that have been rejected by ZPMC VT inspection. Base on Caltrans observation, no discrepancies were noted.

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West tower lift#1:- Caltrans QA Inspector observed three ZPMC welders in process fit up process on fit lugs that connected to diaphragm of skin plate C. The fit lugs are located at the elevation 9m to 47.6m. The minimum preheat and maximum interpass temperature requirements for FCAW process welds are 110C degree and 230 C degree. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted within the report above.

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 Serge Sinevod 13482570045, who represents the Office of Structural Materials for your project.

Inspected By:	Pau, Wai	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
