

**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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006913**Date Inspected:** 30-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 Mr. Wai Pau, was present during the times noted above for observations relative to the work being performed.

**Bay #10 South and North Tower Shop**

South Tower Lift #3:- Caltrans QA Inspector observed five ZPMC workers in process fit up for 111.67m, 105.5m and 109m elevation interior diaphragms on skin plate A of south tower lift #3. After the diaphragms have been secured, a numerous temporary supply angle bars have been welded attach to the diaphragms by two ZPMC welders. Base on Caltrans observation, no discrepancies were noted.

North tower lift#1:- Caltrans QA Inspector observed six ZPMC welders in process FCAW process on interior diaphragms of skin plate D. The interior diaphragms located at the elevation 53m to 80.75m. The minimum preheat and maximum interpass temperature requirements for FCAW process 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.

North tower lift#2:- Caltrans QA Inspector observed six ZPMC welders in process FCAW process on interior diaphragms of skin plate D. The interior diaphragms located at the elevation 53m to 80.75m. The minimum preheat and maximum interpass temperature requirements for FCAW process 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.

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# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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## Bay #11 East and West Tower Shop

East Tower Lift #2:- Caltrans QA Inspector observed five welders performed FCAW root pass process on triangle plate that connected to diaphragms and skin plate B to C and C to D. The triangle plates are located at elevation 53m, 65m and 77m diaphragm sections. The FCAW root pass was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

West tower lift#2:- Caltrans QA Inspector observed five ZPMC welders performed FCAW process on fit lugs that connected to diaphragms of skin plate D. The fit lugs are located at elevation 53m to 80.76 diaphragm section. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

East Tower Lift #3:-Caltrans QA Inspector observed five ZPMC workers in process fit up for 92.5m and 109m elevation interior diaphragms on skin plate A of east tower lift #3. After the diaphragms have been secured, a numerous temporary supply angle bars have been welded attach to the diaphragms by two ZPMC welders. Base on Caltrans observation, 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.

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<b>Inspected By:</b>	Pau,Wai	Quality Assurance Inspector
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<b>Reviewed By:</b>	Clifford,William	QA Reviewer
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