

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-007129**Date Inspected:** 20-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Wei / Sun Bo**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:** OBG Components**Summary of Items Observed:**

The Caltrans (CT) Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Tower and Orthotropic Box Girders (OBG).

Heavy Equipment Shop Bay 10:

The QA Inspector attempted to perform a follow up 100% Visual Inspection (VT) and 15% Magnetic Particle Testing (MT) of the welds attaching the Fit Lugs to Diaphragms 53M through 80.75M and Diaphragms 53M through 80.75M to Skin Plate C in Lift 2 South Tower. Repairs were still in progress and the welds attaching the Fit Lugs to Diaphragms 53M through 80.75M and Diaphragms 53M through 80.75M to Skin Plate C in Lift 2 South Tower, were still not ready for inspection.

Heavy Equipment Shop Bay 11:

The QA Inspector attempted to perform a 100% Visual Inspection (VT) and 15% Magnetic Particle Testing (MT) of the welds attaching the Longitudinal Stiffeners to Diaphragms 18M through 47.6M Diaphragms on Skin Plate A in Lift 1 East Tower. There were 12 areas that would require weld repair and 2 others that would require grinding. Most of these areas are located in the copes. These areas appeared to have been overlooked by Quality Control (QC). The QA Inspector informed QC that these areas would have to be repaired and that the welds attaching the Longitudinal Stiffeners to Diaphragms 18M through 47.6M Diaphragms on Skin Plate A in Lift 1 East Tower were not ready for inspection at this time and that a new notification sheet would have to be generated.

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Heavy Equipment Shop Bay 12:

The QA Inspector randomly observed ZPMC welder Lu Liang, utilizing the Flux Cored Arc Welding (FCAW) Process in the 2F (Horizontal Fillet) Position with ZPMC Weld Procedure Specification (WPS) WPS-B-T-2132-2, to fit up and tack weld stiffeners to elevation 53M Tower Façade ED1-189. The QA Inspector randomly observed ZPMC QC monitoring weld parameters. Weld parameters appeared to comply with contract requirements.

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

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 Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Franco,Charlie	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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