

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-006921**Date Inspected:** 24-May-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.

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South Tower Lift #3:- Caltrans QA Inspector observed five ZPMC welders in process SMAW root pass process on interior diaphragms of skin plate A, B, and E. The interior diaphragms located at elevation 82.25m to 111.67m section. The SMAW repair process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

South Tower Lift #3:- Caltrans QA Inspector observed three welders performed FCAW process on inner corner longitudinal seam weld that connected skin plate A to B, B to C, and A to E. The FCAW welding located at elevation 99m to 105.5m diaphragm section. The FCAW welding was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

North Tower lift#1:- Caltrans QA Inspector observed four ZPMC welders and three grinders in process of grinding and FCAW repair process on fit lugs and rat holes of interior diaphragms. The fit lugs and rat holes located at the elevation 53m to 80.75m diaphragm sections that connected skin plate D. The FCAW repair process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

North Tower Lift #1:- Caltrans QA inspector observed three ZPMC welding operators performed semi-automatic

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SAW on outer corner longitudinal seam weld that connected skin plate B to C of north tower lift #1. The semi-automatic SAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

Shear Plate ED1-A27:- Caltrans QA Inspector observed two ZPMC welders in process FCAW process on the stiffeners that connected to shear plate A27. The FCAW welding was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

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Shear Plate ND1-A25:- Caltrans QA Inspector observed two ZPMC welders in process FCAW process on the connection plates that connected to the stiffeners of shear plate A25. The FCAW welding was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

West Tower Lift #1:- Caltrans QA inspector observed two ZPMC welding operators performed semi-automatic SAW on outer corner longitudinal seam weld that connected skin plate C to D of west tower lift #1. The semi-automatic SAW 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 seven ZPMC welders in process SMAW root pass process on interior diaphragms of skin plate A thru E The interior diaphragms located at elevation 82.25m to 111.67m section. The SMAW repair process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

West Tower Lift #3:- Caltrans QA inspector performed final VT and dry MT inspection on brace plate and weld #WSD1-FBSA3-2B/C-8,9, 10, 13, 14, 15, 16. The brace plate is connected to stiffener and skin plate B of west tower lift #3. The welds for VT and MT inspection have been accepted by ZPMC and ABF QC prior Caltrans QA inspection. Base on Caltrans inspection, the fillet welds on the connection plates appeared to be in compliance with requirements of AWS D1.5 2002 and Caltrans contract documents.

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
