

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-007525**Date Inspected:** 14-Jun-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:** Xu Le Feng, Liu Yang**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:**

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).

Outside Yard at Vertical Mill:

The QA Inspector randomly observed ZPMC machine operators utilizing the vertical mill on the longitudinal stiffeners and skin plates on Lift 1 East. There was no milling being performed on Lift 2 East at this time.

The QA Inspector randomly observed several areas on the longitudinal stiffeners and skin plates on Lift 1 East that contained incomplete fusion, slag inclusions and porosity. ZPMC Quality Personnel informed the QA Inspector that these areas would be repaired. The attached photographs provide additional detail.

The QA Inspector randomly observed that no contract work was being performed in the interiors or on the exteriors of Lift 2 East Tower Shaft or Lift 2 South Tower Shaft.

Blast Shop:

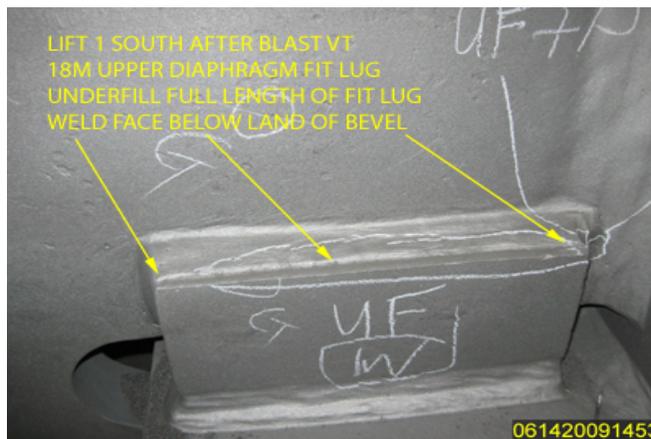
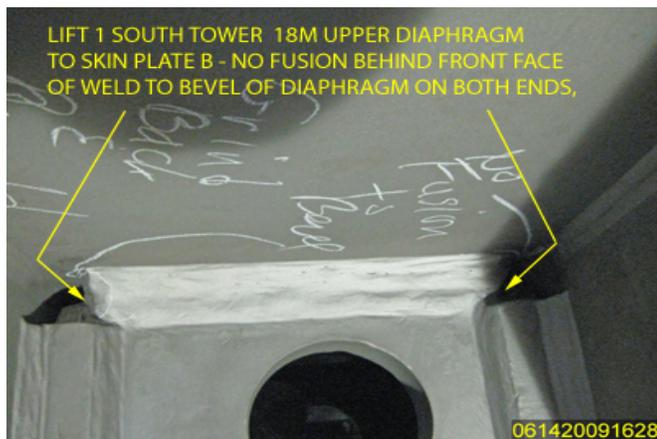
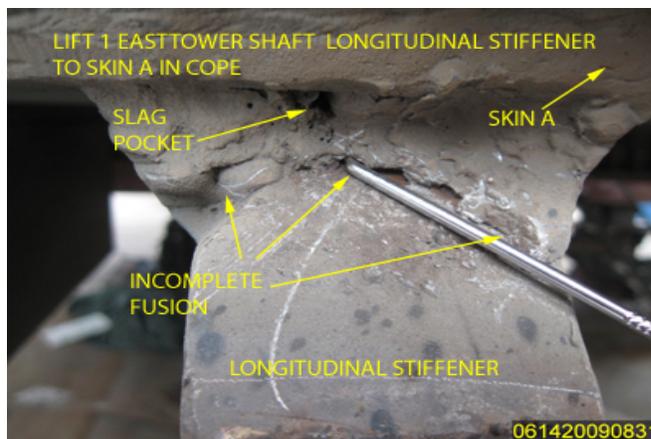
The QA Inspector performed an after blast VT Inspection in interior of Lift 1 East Tower Shaft on Skin Plates A, B, C, D and E from 38M Lower Diaphragm to 18M Upper Diaphragm after lighting had been restored. The QA

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Inspector observed several areas which require a minimum of grinding and several other areas which will require weld repair in addition to grinding. The QA Inspector randomly observed ZPMC production personnel utilizing angle and pencil grinders to re-work areas as they were being marked up. The QA Inspector recorded areas requiring welding on a separate tracking sheet for the generation of a punch list. The attached photographs provide additional detail.

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

Inspected By: Franco,Charlie

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer
