

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-008415**Date Inspected:** 09-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** CX2228.**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 Components**Summary of Items Observed:**

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

This QA Inspector carried out NDE on following:

OBG Trial Assembly Yard.

This QA inspector Witness the Final Tightening of approximately 10% previously tested and accepted by ZPMC Quality Control personnel. The members are identified as Counter Weight from PP22 TO PP22(M22*70-DHGM220004) of Lift 3 (West). (Average torque for the bolts 453 Nm).

OBG Trial Assembly Yard.

This QA inspector Witness the Final Tightening previously tested and accepted by ZPMC Quality Control personnel. The members are identified as Angles Inside Lower Chevron(X3D, M22*65) of Lift 2(west)on PP15 Both sides.

OBG Trial Assembly Yard.

This QA inspector Witness the Final Tightening previously tested and accepted by ZPMC Quality Control personnel. The members are identified as Angles Inside Lower Chevron(X3D, M22*65) of Lift 1(west).

Bay 11, Skirt Plates.

This QA inspector performs Ultrasonic Testing (UT) of approximately 10% area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report (TL-6027) for this date.

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The members are identified as

- 1) ED1-A435A/C-1A/B.
- 2) WD1-A597A/C-27A/B.
- 3) ED1-A435A/C-3A/B.
- 4) ED1-A65A/C-1A/B.

Bay 11, West Tower, Lift 2.

This QA inspector performs Random Visual Testing (VT) of area previously tested and accepted by ZPMC Quality Control personnel, FOR GREEN TAG. The members are identified as

- 1) WSD1-TL6C/L-6, 7, 15, 16, 97, 98. Diaphragm Web Plate to Skin A&E only(53M).
- 2) WSD1-TL6E/L-119, 120, 129, 130, 101, 102. Diaphragm Web Plate to Skin A&E only(65M).
- 3) WSD1-TL6H/L-7, 8, 17, 18, 91, 90. Diaphragm Web Plate to Skin A&E only(77M).

Notification # 003900. West shaft , Lift 2, 53M. (Diaphragm Web Plate to Skin E). Arc Strike Found near Inspection Area. ZPMC Q.C. will remove Arc strike & carry out M.T. on the same area. ZPMC will call C.T. Q.A. for Inspection. Weld joint number not provided so, No Document has been signed for the Inspection. 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: Juvekar,Amit

Quality Assurance Inspector

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Reviewed By: Clifford, William

QA Reviewer