

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-008598**Date Inspected:** 02-Aug-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

North Tower Lift #3:- Caltrans QA inspector observed three ZPMC welding operators performed semi-automatic SAW on outer corner longitudinal seam weld that connected skin plate D to E of north tower lift #3. The semi-automatic SAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

North Tower Lift #3:- Caltrans QA Inspector observed two welders performed FCAW repair process on inner corner longitudinal seam weld that connected skin plate A to E. The FCAW repair welding located at elevation 92.5m to 99m diaphragm section. The FCAW repair welding was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

North Tower Lift #2:- Caltrans QA Inspector observed ZPMC six grinders and three welders performed grinding and FCAW repair process on diagonal stiffeners. The diagonal stiffeners located at the elevation 56m to 80.75m diaphragm sections that connected skin plate C and D of north tower lift #2. The grinding process and FCAW repair welding was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

Bay #11 South and North Tower Shop

East Tower Lift #3:- Caltrans QA Inspector observed two welders performed FCAW repair process on inner corner longitudinal seam weld that connected skin plate C to D. The FCAW repair welding located at elevation

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102.5m to 109m diaphragm section. The FCAW repair welding was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

East Tower lift#3:- Caltrans QA Inspector observed seven ZPMC grinders in process of grinding on fit lugs and rat holes of interior diaphragms. The fit lugs and rat holes located at the elevation 89m to 111.67m diaphragm sections that connected skin plate A and C of east tower lift #3. The grinding process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, 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 notes within 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 Sinoved 13482570045, who represents the Office of Structural Materials for your project.

Inspected By:	Pau,Wai	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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