

**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-009670**Date Inspected:** 16-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**

South Tower Lift #3:- Caltrans QA Inspector observed five ZPMC grinders and one welder in process of grinding and FCAW repair welding on fit lugs of interior diaphragms. The fit lugs located at the elevation 98m to 102.5m diaphragm sections that connected skin plate D of south tower lift #3. The grinding and FCAW repair welding process were 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 three ZPMC welding operators performed semi-automatic SAW on outer corner longitudinal seam weld that connected skin plate A 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 #2:- Caltrans QA Inspector observed four ZPMC grinders and one welder in process of grinding and FCAW repair welding on fit lugs of interior diaphragms. The fit lugs located at the elevation 98m to 102.5m diaphragm sections that connected skin plate A of north tower lift #2. The grinding and FCAW repair welding process were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

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## WELDING INSPECTION REPORT

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Bay #11 East and West Tower Shop

East Tower Lift #3:- Caltrans QA Inspector observed six ZPMC grinders and two welders in process of grinding and FCAW repair welding on fit lugs and rat holes of interior diaphragms. The fit lugs and rat holes located at the elevation 85.25 m to 111.67m diaphragm sections that connected skin plate D of north tower lift #1. The grinding and FCAW repair welding process were 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 five ZPMC grinders in process of grinding on outer corner longitudinal seam weld that connected skin plate C to D. The purpose of grinding is removed the slag, oxide film and bevel to suitable surface for welding. The grinding 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 observed five 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 85.25m to 111.67m diaphragm sections that connected skin plate B and C of west 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.

West Tower Lift #1:- Caltrans QA Inspector observed six ZPMC grinders in process of grinding on fit lugs of interior diaphragms. The fit lugs located at the elevation 9m to 47.6m diaphragm sections that connected skin plate A of west tower lift #1. 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.

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<b>Inspected By:</b>	Pau, Wai	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford, William	QA Reviewer

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