

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-010261**Date Inspected:** 21-Oct-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:** Wang Chuan Qing.**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 observed the following work in progress:

Bay10, South Tower, Lift 4, Skin A, Temporary Attachment Area.

During random visual inspection at South Shaft, Lift 4, Skin A (Temporary Attachment Area near Corner Seam A/E) this Caltrans Quality Assurance (QA) Inspector observed "Crack Like" indications at the removed Temporary attachment Weld area. The indications were shown to ZPMC and ABF QC Inspectors. No Incident Report has been written on this issue. The attached photographs provide additional detail.

Bay10, South Tower, Lift 4, Skin A,

During random visual inspection at South Shaft, Lift 4, Skin A (small Doubler Plate-tack welds) this Caltrans Quality Assurance (QA) Inspector observed "Crack Like" indications at the tack weld for weld joint identified as SSD1-FASA4-1A/E-3. The indications were shown to ZPMC and ABF QC Inspectors. No Incident Report has been written on this issue. The attached photographs provide additional detail.

Bay 10, South tower, Interior Splice Plate.

FCAW Repair welding of weld joint SSD1-SPSA3-56-4B(WRR # TEMPORARY WRR NO NUMBER); located on Bay 10, South tower. Welders are identified as 040365; ZPMC Quality Control Inspector (QC) is identified as Wang Chuan Qing. The welding variables recorded by Quality Control Inspector (QC) appeared to

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

comply with the Applicable WPS: WPS-345-FCAW-2G(2F)-REPAIR.

This QA Inspector carried out NDE on following
Bay 10, North Tower, Skin D, Connection Plate.

This QA inspector performs Random Visual Testing (VT), Magnetic Particle Testing (MT) of approximately 15% area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report (TL-6028) for this date. The members are identified as NSD1-FDSA4-3C/D-41 TO 44, 49 TO 56, 61 TO 68, 73 TO 80.(28 NOS.)

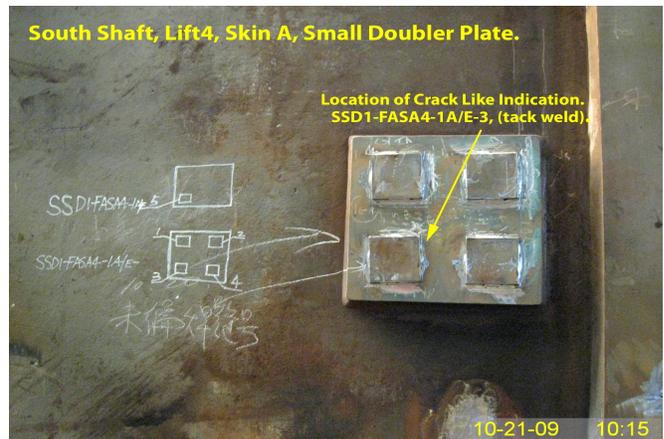
GREEN TAG # 10675.

Bay 11, West Tower, Strut.

This QA inspector performs Random Visual Testing (VT), Magnetic Particle Testing (MT) of approximately 15% area & Random Ultrasonic Testing (UT) of approximately 10% area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT & UT report (TL-6028 & TL-6027) for this date. The members are identified as WD1-A6001-5.

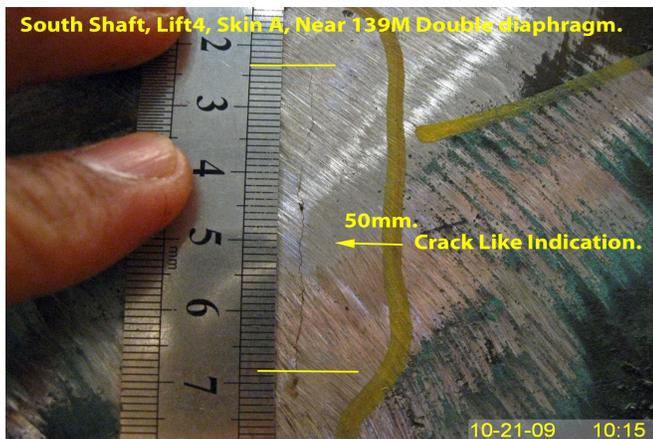
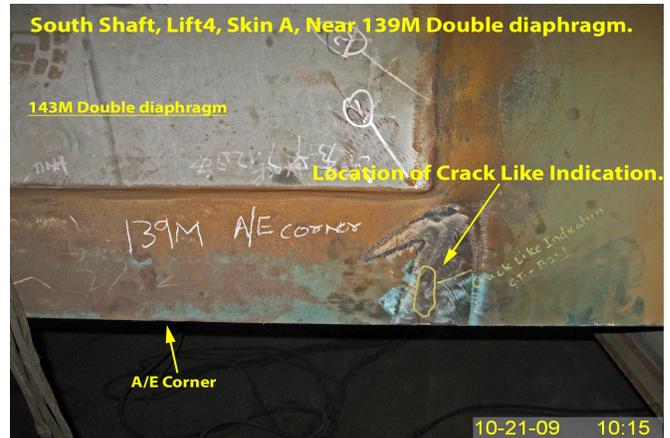
GREEN TAG #9280.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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

Reviewed By: Clifford,William

QA Reviewer