

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-012473**Date Inspected:** 21-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	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 and OBG Components	

Summary of Items Observed:

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

Bays 10 and 11

No welding related work was observed being performed in either Bay 10 or Bay 11.

OBG Trial Assembly Area

This QA Inspector randomly observed the following work in progress in the OBG Trial Assembly Area:

No welding related work was observed being performed in the OBG Trial Assembly Area. However, five ABF technicians were performing magnetic particle testing (MT) inside OBG section 6AE/crossbeam 5, at the holdback welds of stiffeners to bottom, sides, and deck near the bolted joint of FL3 to crossbeam.

Bay 10 - MT

This QA Inspector performed random visual testing (VT) and then MT of approximately 15% of the tack welds of the welds noted below. This inspection was performed on an informational basis and no TL-6028 report was generated for this date. The member is identified as outside north tower, lift 5, skins A/E corner, skins D/E corner, and skins C/D corner. The weld designations reviewed were NSD1-TL5-3B-F-22A, 40A on the skins A/E corner, NSD1-TL5-3B-F-1A, 79B on the skins D/E corner, NSD1-TL5-3B-F-8A, 37A on the skins C/D corner. No

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apparent indications were observed. However, this QA Inspector observed the top 1.8M of welds 40A, 79B, 37A were not tack welded. This QA Inspector also observed 2 arc strikes on skin D near weld NSD1-TL5-3B-F-37A and clearly marked the arc strikes, including the date and this QA Inspector's Caltrans lot number.

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

Summary of Conversations:

No significant 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 Skyler Guest, 150-0042-2360, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet,George	Quality Assurance Inspector
Reviewed By:	Dawson,Paul	QA Reviewer
