

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-013684**Date Inspected:** 17-Feb-2010**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:** 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.

Caltrans QA inspector observed twenty ZPMC workers in process of temporary bolting to the struts and 90 degree angle plates which connected to tower skin plate A, B, C, D and E. The struts located at elevation 43m and 23m of north, south, east and west tower lift #1. The ZPMC will install only 25% bolts on each strut. During observation, some of temporary bolts do not have properly length after installed into the struts and 90 degree angle plates. This issue has been discovered by Caltrans QA inspector on Feb-7-10. The elevation 43m and 23m have not been completed 25% temporary bolting. It'll be schedule continue tomorrow.

West tower lift #1: - Caltrans QA inspector performed final QA dry MT and UT test on few corner seams welds section. The weld sections are connected the skin plate B to C and C to D of west tower lift #1. The ZPMC inspection request number is 005211 and 005212. The seam weld sections ID are WSD1-A423B/H-7, WSD1-A423B/H-138, WSD1-A423B/H-23, WSD1-A423B/H-139, WSD1-A423B/H-6, WSD1-A423B/H-140, WSD1-A423B/H-141 and WSD1-A423B/H-24 for MT test. WSD1-A423B/H-23 and WSD1-A423B/H-24 is for UT test. The weld sections for dry MT and UT test have been accepted by ZPMC prior Caltrans QA inspection. Base on Caltrans MT inspection, the welds appeared to be in compliance with requirements of AWS D1.5 2002 and Caltrans contract documents.

CLOSING STATEMENT

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

Summary of Conversations:

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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 Skyler Guest 15000422360, 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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