

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-014084**Date Inspected:** 02-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1800**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 four ZPMC welders in process FCAW process on temporary exterior support plates for skin A/B/C/D of all tower lift #2. The material used for temporary exterior support plates were reported by ZPMC QC as ASTM a 709M-345 plate with 20mm wall thickness. The weld is designed PJP weld with welded in 3G position. The FCAW process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

Caltrans QA inspector observed fifteen ZPMC workers installed the cross bracing on tower lift #1. The cross bracing is located at elevation 47.6M of East/West/South/North tower #lift 1. The four eyes holes of cross bracing have been marked for holes drilling after secured by the pins. The cross bracing has been removed to ground floor after the survey completed by ZPMC. The four eyes holes will be start holes drilling tomorrow.

Caltrans QA Inspector observed four ZPMC welders in process FCAW process on four eye paths. The eye paths are located at elevation 47.6M of East/West/South/North tower #lift 1 and use for hold cross bracing. The weld is designed CJP weld with welded in 3G position. The FCAW process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

CLOSING STATEMENT

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

WELDING INSPECTION REPORT

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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 Skyler Guest 15000422360, who represents the Office of Structural Materials for your project.

Inspected By: Pau,Wai

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer
