

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-004272**Date Inspected:** 20-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**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	

Summary of Items Observed:

Confined Space / Hot Work

ZPMC continues to work on tower shaft ESD1-Lift 1 (east tower shaft) which has been determined as a confined space area. ZPMC does not have the required Confined space permit posted at the entry of the confined space. Caltrans QA Inspector observed approximately 8 ZPMC employee badges posted as working inside the area performing welding operations which also requires a Hot Work permit which also is not posted. With continued work being performed and no Confined Space permit this limits Caltrans QA Inspectors from monitoring the in progress work being performed inside the tower section. Digital Photo below depicts the entry into the confined space area.

Heavy Bay 1 UT Verification

This Caltrans QA Inspectors performed random 10% UT; QA verification for tower components after ZPMC had completed and accepted the CJP weldments. Weld numbers SSD1 - SA171C/D- 27, 28, 35 and 36, SSD1 - SA171A/D-4, 5, 7 and 8, SSD1 - SA61A/G - 1A/B and SSD1 - SA61A/G - 6A/B were completed for the QA verification. Caltrans QA Inspector performed the QA verification for tower components after ZPMC had completed and accepted the CJP weldments. At the time of the QA review the weld appeared to be within compliance. A TL-6027 shall be generated for these locations.

Heavy Bay 2 UT Verification

This Caltrans QA Inspectors performed random 10% UT; QA verification for tower components after ZPMC had completed and accepted the CJP weldments. Weld numbers SSD1 ESD1 - SA384B/D - 4 and ESD1-SA384 A/D-4 were completed for the QA verification. Caltrans QA Inspector performed the QA verification for tower components after ZPMC had completed and accepted the CJP weldments. At the time of the QA review the weld appeared to be within compliance. A TL-6027 shall be generated for these locations.

WELDING INSPECTION REPORT

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Summary of Conversations:

No conversations noted today.

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 Josh Ishibashi, 1-376-471-0411, who represents the Office of Structural Materials for your project.

Inspected By:	Riley, Ken	Quality Assurance Inspector
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Reviewed By:	Carreon, Albert	QA Reviewer
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