

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-004274**Date Inspected:** 22-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

Tower Shop Bay 2

ZPMC continues to work inside 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 ZPMC employee's badges posted as working inside the area on fabrication, 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.

Caltrans Ultrasonic 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 ESD1-SA388 C/D-21, 22, 23 and 24 and WSD1-SA225-A/H-7 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.

Caltrans Magnetic Particle Verification

This Caltrans QA Inspectors performed random 10% MT; QA verification for tower components after ZPMC had completed and accepted the weldments. Weld numbers ESD1-SA388 C/D-21, 23, 4 and 34 were completed for the QA verification. Caltrans QA Inspector performed the QA verification for tower components after ZPMC had completed and accepted the weldments. At the time of the QA review the weld appeared to be within compliance. A TL-6028 shall be generated for these locations.

Caltrans QA inspectors received notification of witness for inspection number 1257 for tower skin D SSD1-SA40 C/E 18~25, SSD1-SA180 A/E 1~40 and SSD1-SA180 B/E 7~14 upon arrival of the QA inspectors it was noted

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that ZPMC was still in process of weld repairs for the grade 345 to 485 material PJP weldments. It was noted that areas that had been marked previously by Caltrans QA Inspectors on 10-20-08 and turned back over to ABF due to welds not in compliance had not been addressed. This being a 485 to 345 grade steel according to AWS D1.5 section 12 and the special provisions section 10 the wait time for 485 Gr. after the completion of welding and before inspection is 24 to 48 hrs pending thickness of steel.

Summary of Conversations:

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

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