

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-004757**Date Inspected:** 07-Nov-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:	Sun Bo			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/ OBG		

Summary of Items Observed:

OBG/ Tower Bay 4

This QA inspector received notification from ZPMC for ABF green tagging of SSD1-lift 1 9M diaphragm. Upon arrival at this location it was noted that ZPMC had completed their MT and VT inspection of the 6mm fillet welds. This QA Inspector performed VT and 10% MT verification for the welds that ZPMC had tested and accepted. At the time of review the welds appeared to be within compliance. The weld numbers for this component were as follows; SSD1-SA9- 1,3,5,7,and 9, SSD1-SA64-1,3,5,7,9,11,13,15,and17, SSD1-SA63-1, SSD1-SA62-1, SSD1-SA59-1,3,5 and 7, SSD1-SA58-1,3,5,7,9,11,13,15,17,,19,21,and23 , SSD1-SA29-1,3,5,7,9,and11, SSD1-SA28-1,3,5,7,9,11,13,15,17,19,21,23,25 and27, SSD1-SA25-1,3,5,7,9,11,13,15,17,19,21,23,25and27, SSD1-SA23,3,5,7,9,11,13,15,17,19,21,23,25 and 27, SSD1-SA20-1~20. The 9M diaphragm requires A325 high strength bolts in accordance with RCSC June 2000 edition. Due to the un-clarity of this procedure in relation to the bolting sequence vs. welding sequence (install A325 high strength bolts prior to welding , or change them from temporary bolts to High strength bolts after welding is completed of the 6mm fillet welds). The Tower SMR was to inform design of this question and get clarification of this sequence. This Caltrans QA inspector was informed by the task leader that for the ABF green tagging system to not sign it at this time until will have clarification on the bolting to welding sequence. Once the sequence is identified and is within the scope of work performed then this QA Inspector will sign the green tag by ABF.

OBG Bay 3 UT and RT

This Caltrans QA Inspector received notification from ZPMC for the UT testing and reviews of the CJP butt splice welds for bottom plates BP069-001-061, BP096-001-061, BP148-001-067 and BP040-001-067. These welds were tested with ultrasonic testing by this QA inspector for 10% of the total weld lengths and at the time of review the

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weld appeared to be within compliance. This QA inspector also received notification that the welds listed above needed to be identified for RT by Caltrans QA so ZPMC could grind these areas where they would perform RT as outlined in the special provisions. The 300mm areas were identified and marked by this Caltrans QA inspector.

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
