

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-005856**Date Inspected:** 22-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1830**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:** SAS tower**Summary of Items Observed:**

Bay #10 South and North Tower Shop

North Tower Lift #1:-Caltrans QA Inspector observed four welders performed FCAW build up weld metal welding on stiffeners which located at exterior bottom tower of skin plate C and D. The buildup metal welding has been approved by Caltrans with file #CWR-00087. The metal buildup on skin plate C is 50mm to 60mm thick and skin plate D is 25mm to 30mm thick. The SMAW was monitored and recorded by ZPMC and ABF QC inspector. Base on Caltrans observation, no discrepancies were noted.

South Tower Lift #2:-Caltrans QA Inspector observed three welders performed FCAW repair process on inner corner longitudinal seam weld that connected skin plate C and D. and the weld number is SSD1-TL5B/L-4B. All the excavated weld areas have been MT test prior repair welding. The FCAW repair welding was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

South Tower Lift #2:-Caltrans QA Inspector observed two welder performed FCAW fillet weld repair process on fit lugs of south tower lift #2. The fit lugs located at elevation 53m to 63m. The FCAW repair welding was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

South Tower Lift #1:-Caltrans QA Inspector observed six welders in process of grinding on fillet welds that attached fit lugs. The grinding purpose is remove the weld profile which have been rejected by QC that exceeding AWS D1.5 code limitations. The fit lugs located at elevation 9m to 47.6m on skin plate D. Based on Caltrans QA inspector observations, no discrepancies were noted.

Bay #11 East and West Tower Shop

WELDING INSPECTION REPORT

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West Tower Lift #2:- Caltrans QA Inspector observed seven ZPMC welders in process fit up and SMAW tack welding on skin plate D of west tower lift 2. A numerous temporary tack welds have been welded attach to the skin plate B and skin plate A after the skin plate B has been secured. Base on Caltrans observation, no discrepancies were noted.

East Tower Lift #2:- Caltrans QA Inspector observed six ZPMC welders in process FCAW repair welding on the fit lug welds of east tower lift #2. The fit lug welds located at elevation 74m 77m and 79m of skin plate B, C and E. The FCAW repair welding was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

Summary of Conversations:

As noted within the 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 , who represents the Office of Structural Materials for your project.

Inspected By:	Pau,Wai	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
