

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-005857**Date Inspected:** 23-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 two welder performed FCAW fillet weld repair process on fit lugs of south tower lift #2. The fit lugs located at elevation 62m to 74m. 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 performed final VT inspection on the fit lug welds and diaphragm welds of skin plate D and E. Those weld connected to diaphragms, fit lugs and skin plate D and E. The fit lug welds and diaphragm welds located at elevation 9m to 47.6m. All the welds have been VT accepted by ZPMC and ABF QC prior Caltrans QA inspection. Base on Caltrans inspection, the diaphragm welds appeared to be in compliance with requirements of AWS D1.5 2002 and Caltrans contract documents.

Bay #11 East and West Tower Shop

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.

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East tower lift #1:- Caltrans QA inspector performed final VT inspection on the fit lug welds and diaphragm welds of skin plate C and D. Those weld connected to diaphragms, fit lugs and skin plate C and D. The fit lug welds and diaphragm welds located at elevation 13m, 15m, 18m, and 23m. All the welds have been VT accepted by ZPMC and ABF QC prior Caltrans QA inspection. Base on Caltrans inspection, the diaphragm welds appeared to be in compliance with requirements of AWS D1.5 2002 and Caltrans contract documents.

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
