

**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-005858**Date Inspected:** 24-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 three welders performed SMAW root pass process on inner corner longitudinal seam welds that connected skin plate A to B, A to E and B to C. The seam welds number #NSD1-A166E/J-73B, NSD1-A166E/J-52B and NSD1-A166E/J-32B. Three of root passes welding located at elevation 33m to 47.6m. The SMAW 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 five ZPMC workers in process of grinding on fit lug welds and diaphragm welds. The fit lug welds located at elevation 53m to 68m on skin plate E. The grinding purpose is remove the weld profile which have been rejected by QC that exceeding AWS D1.5 code limitations. Based on Caltrans QA inspector observations, no discrepancies were noted.

South Tower Lift #2:- Caltrans QA Inspector observed three workers performed grinding process on fit lug welds of south tower lift #2. The fit lug welds located at elevation 68m to 74m on skin D. The grinding purpose is remove the weld profile which have been rejected by QC that exceeding AWS D1.5 code limitations. Based on Caltrans QA inspector observations, no discrepancies were noted.

Bay #11 East and West Tower Shop

East Tower Lift #1:- Caltrans QA Inspector observed seven ZPMC welders in process fit up and SMAW process on seven triangle cover plates that connected to double diaphragm and skin plate. The seven triangle cover plates located at elevation 18m, 23m, 28m and 33m. The SMAW welding was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

East Tower Lift #2:- Caltrans QA Inspector observed four welder performed FCAW fillet weld repair process on fit lugs of east tower lift #2. The fit lugs located at elevation 53m, 56m, 74m and 80.76m. The FCAW repair welding

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was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector 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.

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<b>Inspected By:</b>	Pau,Wai	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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