

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-005862**Date Inspected:** 29-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**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

South tower lift#1:- Caltrans QA Inspector observed five welders performed FCAW process on CJP weld for corner diagonal stiffener that connected skin plate C to D. The welding located at elevation 9m, 13m, 15m, 18m and 38m. The minimum preheat and maximum interpass temperature requirements for FCAW CJP weld are 110C degree and 230 C degree. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

North tower lift#1:- Caltrans QA Inspector observed two welders performed SMAW process on inner corner longitudinal seam weld that connected skin plate C to D. The weld number is NDS1-A112B/H-2A and NSD1-A112B/H-1B. The welding located at elevation 18m to 28m. The minimum preheat and maximum interpass temperature requirements for SMAW longitudinal seam weld are 110C degree and 230 C degree. The SMAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

Bay #11 East and West Tower Shop

West tower lift#1:- Caltrans QA Inspector observed two welders performed FCAW process on inner corner longitudinal seam weld that connected skin plate A to B and B to C. The welding located at elevation 23m to 33m and 18m to 23m. The minimum preheat and maximum interpass temperature requirements for SMAW longitudinal

East tower lift #2:- Caltrans QA inspector performed final VT inspection on the fit lug and diaphragm welds of skin plate B and C for east tower lift #2. The fit lug and diaphragm located at elevation 77m Base on Caltrans inspection, the fit lug and diaphragm welds appeared to be in compliance with requirements of AWS D1.5 2002

WELDING INSPECTION REPORT

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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
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Reviewed By:	Clifford, William	QA Reviewer
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