

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-005866**Date Inspected:** 30-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

North tower lift#1:- Caltrans QA Inspector observed three ZPMC workers performed grinding process on root pass of interior diaphragm that connected skin plate A to B. The welding located at elevation 33m, 38m and 43m. The grinding propose is removed the weld profile on the root pass prior FCAW welding. Based on Caltrans QAI observations, no discrepancies were noted.

North Tower Lift #2:- Caltrans QA Inspector observed five ZPMC welders in process SMAW tack welding on skin plate A to E and support plates of north tower lift 2. A numerous temporary tack welds have been welded attach to the skin plates after the skin plates has been secured. Base on Caltrans observation, no discrepancies were noted.

South Tower Lift #2:- Caltrans QA Inspector observed four ZPMC workers performed grinding process on the fillet weld of fig lugs. The fig lugs are located at elevation 59m to 68m interior diaphragm of south tower lift #2. The grinding process is removing the weld profiles that have been rejected by VT inspection. Base on Caltrans observation, no discrepancies were noted.

South Tower Lift #1:- Caltrans QA Inspector observed six ZPMC workers installed corner diagonal stiffeners on the skin plates C to D. During observation ZPMC QC, ABF CWI informed to Caltrans QAI that two corner diagonal stiffeners P1243 and P88 have been found misalignment and not complied with the approved drawing. The stiffeners located elevation between 28m to 33m diaphragm section. The approved drawing showed two stiffeners have length of bevel with 399m. However, the field measurement for P1243 has length of bevel with 410m and P88 has length of bevel with 385m. After Caltrans QAI discussed with ZPMC Engineer, QC and ABF CWI, the installation of the two stiffeners with hold by ZPMC to further information.

South tower lift #3:- Caltrans QA inspector performed final dry MT inspection on the CJP weld of skin plate E.

WELDING INSPECTION REPORT

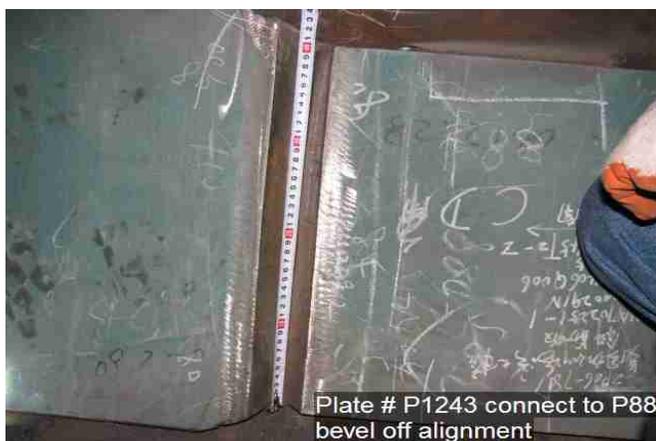
(Continued Page 2 of 3)

The CJP weld number #SSD1-FESA3-1A/D-16, 19, 22, 10A/B, SSD1-FESA3-1A/D-13A/B-(2), SSD1-FESA3-1A/D-8,9,11,12,14,15, 17, 18, 20, 21, 23,24 AND SSD1-FESA3-1A/D-13A/B-(1). Base on Caltrans inspection, the CJP welds of skin plate E appeared to be in compliance with requirements of AWS D1.5 2002 and Caltrans contract documents.

North tower lift #3:- Caltrans QA inspector performed final dry MT inspection on the CJP weld of skin plate A. The CJP weld number #NSD1-FASA3-1A/E-1A/B. Base on Caltrans inspection, the CJP weld of skin plate A appeared to be in compliance with requirements of AWS D1.5 2002 and Caltrans contract documents.

Bay #11 East and West Tower Shop

East tower lift #2:- Caltrans QA inspector performed final VT inspection on the fit lug welds and diaphragm welds of skin plate A to D for east tower lift #2. The fit lug welds and diaphragm located at elevation 68m to 77m. Base on Caltrans inspection, the fit lug welds and 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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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