

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-006529**Date Inspected:** 21-Apr-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:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Wai Pau, was present during the times noted above for observations relative to the work being performed.

Bay #10 South and North Tower Shop

Shear Plate A28:-Caltrans QA Inspector performed QA UT test on the four CJP weld #WD1-A28A/B-35, 39, 41 & 43 of shear plate A28. All the CJP welds have been accepted by ZPMC prior Caltrans QA inspection. Base on Caltrans UT inspection, the four CJP welds appeared to be in compliance with requirements of AWS D1.5 2002 and Caltrans contract documents.

Shear Plate A22:-Caltrans QA Inspector performed QA UT test on the six CJP weld #WD1-A22A/B-27, 29, 31, 33, 35 & 37 of shear plate A22. All the CJP welds have been accepted by ZPMC prior Caltrans QA inspection. Base on Caltrans UT inspection, the four CJP welds appeared to be in compliance with requirements of AWS D1.5 2002 and Caltrans contract documents.

South Tower Lift #3:- Caltrans QA Inspector observed four welders performed semi-auto FCAW process on four stiffeners D1, D2, D3 and D4 that connected to of skin plate D for south tower lift #3. The semi-auto FCAW was monitored and recorded by ZPMC and ABF QC inspector. 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 four welders performed FCAW process on fit lug welds of diaphragm that connected skin plate C. The fit lug welds are located at elevation 53m to 80.7m diaphragm section. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

West Tower Lift#1:- Caltrans QA Inspector observed four welders performed FCAW process on diaphragm that connected skin plate C. The diaphragms are located at elevation 9m to 47.6 diaphragm section. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

East Tower Lift #3:- Caltrans QA Inspector observed two welders performed SAW process on CJP weld on the skin plate D of east tower lift #3. The CJP weld number is ESD1-FDSA3-2B/C-27, 34, 41 and 48. The SAW welding was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable 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 Serge Sinevod 13482570045, 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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