

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-006533**Date Inspected:** 14-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

South Tower Lift #1:- Caltrans QA Inspector observed two welder performed FCAW R2 repair process on outer corner longitudinal seam weld that connected skin plate A and E. The R2 repair weld area have been repair by ZPMC UT test and located at elevation 43m to 47.6m diaphragm section. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

North tower lift#1:- Caltrans QA Inspector observed two welders performed SMAW process on outer corner longitudinal seam weld that connected skin plate B to C. The SMAW welding is one meter length areas are located two roller installing surface. 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.

South Tower Lift #2:- Caltrans QA Inspector observed four ZPMC welders in process fit up and SMAW process on six triangle cover plates that connected to double diaphragm and skin plate E. The seven triangle cover plates located at elevation 53m, 65m and 77m. The SMAW welding was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

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South Tower Lift#2:- Caltrans QA Inspector observed four grinders and two welders performed grinding and FCAW repair process on rat holes of diaphragm that connected skin plate E. The rat holes are located at elevation 9m to 47.6m diaphragm section. The grinding and FCAW welding process are removing and repair the PJP welds that have been rejected by VT inspection. Base on Caltrans observation, no discrepancies were noted.

South tower lift #1:- Caltrans QA inspector performed final VT and dry MT inspection on the PJP and CJP welds of corner diagonal stiffener that connected skin plate C to D and B to C. The corner diagonal stiffener plates are located at elevation 9m to 47.6m diaphragm section. All the PJP and CJP welds have been inspected and accepted by ZPMC and ABF QC prior Caltrans QA inspection. Base on Caltrans inspection, the PJP and CJP welds on the corner diagonal stiffener plates 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#3:- Caltrans QA Inspector observed two workers performed SAW process on two stiffeners to skin plate D of east tower lift #3. The two stiffeners has been cut prior welding due to the exceed length has been found by Caltrans QA Inspector two day ago. The two stiffeners number is ESD1-FDSA3-2B/C-56 A/B and 54 A/B. The SAW was monitored and recorded by ZPMC and ABF QC inspector. Base on Caltrans observation, 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
Reviewed By:	Clifford, William	QA Reviewer
