

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-006915**Date Inspected:** 02-May-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 Mr. 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 #2:- Caltrans QA Inspector observed five welders performed FCAW root pass process on CJP weld for corner diagonal stiffener that connected skin plate C to D and B to C. The welding located at elevation 53m to 80.76m diaphragm. 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 six ZPMC welders in process FCAW process on fit lugs and interior diaphragms. The fit lugs and interior diaphragms are located at the elevation 53m to 80.75m diaphragm sections of skin plate D. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

North tower lift#2:- Caltrans QA Inspector observed six ZPMC welders in process FCAW process on interior diaphragms of skin plate D. The interior diaphragms located at the elevation 53m to 80.75m. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

Shear Plate A22:- Caltrans QA Inspector observed two ZPMC welders in process fit up and SMAW tack welding on the connected plate that attached to stiffeners of shear plate A22. The fit up and SMAW tack welding was

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monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

Bay #11 South and North Tower Shop

East Tower Lift #3:-Caltrans QA Inspector observed five ZPMC workers in process fit up for 111.67m and 99m elevation interior diaphragms on skin plate A of east tower lift #3. After the diaphragms have been secured, a numerous temporary supply angle bars have been welded attach to the diaphragms by two ZPMC welders. Base on Caltrans observation, no discrepancies were noted.

East Tower Lift #2:- Caltrans QA Inspector observed six welders performed FCAW process on CJP weld for corner diagonal stiffener that connected skin plate C to D and B to C. The welding located at elevation 53m to 80.76m diaphragm. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

West tower lift#2:- Caltrans QA Inspector observed five ZPMC grinders performed grinding process on fit lugs and rat holes of diaphragm that connected skin plate D. The fit lugs and rat holes are located at elevation 53m to 80.76 diaphragm section. The grinding process is removing the fillet welds that have been exceed by AWS D1.5 limited. 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
