

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-006917**Date Inspected:** 16-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

North Tower Lift #2:-Caltrans QA Inspector observed four ZPMC workers performed grinding process on the fig lug welds and diaphragm welds. The fig lug welds and diaphragm welds are located at elevation 53m to 80.75 m interior diaphragm that connected to skin plate E. The grinding processes are removing weld profile of the fillet welds that have been rejected by ZPMC VT inspection. Base on Caltrans observation, no discrepancies were noted.

North Tower Lift #2:-Caltrans QA Inspector observed four welders performed FCAW process on the corner triangle plates that connected skin plate A and E. The corner triangle plates are located at elevation 53m to 80.75 diaphragm sections. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

Bay #11 South and North Tower Shop

Shear Plate A25:- 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 A25. The fit up and SMAW tack welding was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

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Shear Plate A27:- Caltrans QA Inspector observed three ZPMC workers and a welder in process of grinding and FCAW repair process on the stiffeners that connected to shear plate A27. The grinding and repair process were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

West Tower Lift #3:- Caltrans QA Inspector observed six ZPMC welders in process of semi auto FCAW process on the stiffeners that connected to skin plate D of west tower lift #3. The semi auto FCAW process were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

East Tower Lift #3:-Caltrans QA Inspector observed four ZPMC welders in process SMAW tack welding on skin plate B to C and A to E of east tower lift #3. After the skin plates have been secured, a numerous temporary supply angle bars have been welded attach to the skin plate A, B, C and E. 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
