

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-007318**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:** Sun Wei / Sun Bo**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:** TOWER**Summary of Items Observed:**

The Caltrans (CT) Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Tower and Orthotropic Box Girders (OBG).

Outside Yard at Vertical Mill:

The QA Inspector randomly observed that ZPMC milling machine operator utilizing the vertical mill to mill the upper areas of the longitudinal stiffeners and skin plates on Lift 1 South Tower Shaft. The QA Inspector randomly observed that no other contract was being performed on the interior or exterior of Lift 1 South Tower Shaft.

Blast Shop:

The QA Inspector randomly observed that a primer coat on the full length of the exterior of Lift 1 East Tower Shaft. The QA Inspector was informed by ABF representative Don Lawton that there were 20 outstanding items on the punch list which included some Magnetic Particle Testing (MT) and weld repair.

Heavy Equipment Shop Bay 11:

The QA Inspector randomly observed ZPMC welders Yang Gui Long ID 068919, utilizing the FCAW Process with ZPMC WPS WPS-B-T-2332-TC-P4-F in the 2G/2F (Horizontal Groove/ Horizontal Fillet) Positions, to weld the manway doubler plate Lift 2 East Tower Skin A at WJ's ESD1-SA300B/F-11. The QA Inspector randomly

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observed ZPMC QC monitoring weld parameters. Weld parameters appeared to comply with contract requirements. The attached photograph provides additional detail.

The QA Inspector randomly observed ZPMC welder Wang Ru Jia ID 066882, utilizing the Flux Cored Arc Welding (FCAW) Process with ZPMC Weld Procedure Specification (WPS) WPS-B-T-2332-TC-P4-F in the 2F (Horizontal Fillet) Positions, to weld the small doubler plates Lift 2 East Tower Skin A at WJ's ESD1-SA300B/F-7 and 10. The QA Inspector randomly observed ZPMC QC monitoring weld parameters. Weld parameters appeared to comply with contract requirements. The attached photograph provides additional detail.

The QA Inspector randomly observed 5 helpers utilizing angle grinders to clean out slag from Lift 1 West Tower long seam weld between Skin Plate B and Skin Plate C at WJ WSD1-SA115E/J-90A after Carbon Air Arc Back Gouging (CAAG) operations.

The QA Inspector randomly observed 4 helpers utilizing angle grinders to clean out slag from Lift 1 West Tower long seam weld between Skin Plate B and Skin Plate A at WJ WSD1-SA115E/J-70A after Carbon Air Arc Back Gouging (CAAG) operations.

The QA Inspector randomly observed 2 welders utilizing the CAAG Process to back gouge an area at the lower elevation of Lift 1 West Tower long seam weld between Skin Plate B and Skin Plate A at WJ WSD1-SA115E/J-90A.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

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.

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Inspected By:	Franco,Charlie	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
