

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-007329**Date Inspected:** 03-Jun-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:** Xu Le Feng**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 was idle and no milling work was being performed on Lift 1 South Tower Shaft or Lift 2 South Tower.

The QA Inspector randomly observed 3 ZPMC helpers utilizing angle grinders to clean up the bevel faces after CAAG operations to cut the bevels on the ends of the longitudinal stiffeners and Skin Plates on Lift 1 South Tower Shaft.

The QA Inspector randomly observed 1 ZPMC helper utilizing a hand held torch to remove pad eyes from 2 areas on Skin D on Lift 1 East Tower Shaft. The attached photograph provides additional detail.

The QA Inspector randomly observed 2 ZPMC helpers utilizing angle grinders to blend the fillet welds attaching the longitudinal stiffeners to 65M Lower Diaphragm of Lift 2 South Tower Shaft.

The QA Inspector randomly observed ZPMC welder Zhang Jin Long ID 057220, utilizing the Shielded Metal Arc Welding (SMAW) Process in the (Flat Groove) Position with ZPMC Weld Procedure Specification (WPS)

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WPS-345-SMAW-1G (1F)-Repair weld repairs to longitudinal stiffeners to Skin Plate B welds on Lift 2 South Tower between 56M Upper and 59M Lower Diaphragms. The QA Inspector randomly observed ZPMC QC monitoring weld parameters. Weld parameters appeared to comply with contract requirements.

Heavy Equipment Shop Bay 11:

The QA Inspector randomly observed ZPMC welder Wan Zhen ID 070432, utilizing the SMAW Process in the 3F (Vertical Fillet) Position with ZPMC WPS WPS-345-SMAW-3G (3F)-Repair to the welds in the copes attaching the stiffeners to the outside surface of Skin Plate B on Lift 1 West Tower. The QA Inspector randomly observed ZPMC QC monitoring weld parameters. Weld parameters appeared to comply with contract requirements.

The QA Inspector randomly observed ZPMC welder Li Shou Fu ID 066674, utilizing the Flux Cored Arc Welding (FCAW) Process in the 1G (Flat Groove) Position with ZPMC WPS WPS-B-T-2231-C-U2-F to weld out the long seam after the termination of the Submerged Arc Welding (SAW) between Skin Plate B and Skin Plate C on Lift 1 West Tower at Weld Joint (WJ) WSD1-A115E/J-90A. The QA Inspector randomly observed ZPMC QC monitoring weld parameters. Weld parameters appeared to comply with contract requirements.

The QA Inspector randomly observed ZPMC welder ID 066695, utilizing the FCAW Process in the 1G (Flat Groove) Position with ZPMC WPS WPS-B-T-2231-C-U2-F to weld out the long seam after the termination of the SAW between Skin Plate D and Skin Plate E on Lift 1 West Tower at Weld Joint (WJ) WSD1-A115E/J-90A. The QA Inspector randomly observed ZPMC QC monitoring weld parameters. Weld parameters appeared to comply with contract requirements.

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
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Reviewed By:	Clifford,William	QA Reviewer
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