

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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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-007532**Date Inspected:** 24-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, Yu Dong Ping**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 the vertical mill was idle and that there was no milling being performed on the skin plates on Lift 1 East Tower Shaft or Lift 2 East Tower Shaft at this time.

The QA Inspector randomly observed that no contract work was being performed in the interiors or on the exteriors of Lift 1 East Tower Shaft or Lift 2 East Tower Shaft.

**Heavy Equipment Shop Bay 11:**

The QA Inspector performed a 100% Visual Testing (VT) Inspection of the fit lugs on Skin D to 13M Diaphragm at Weld Joint (WJ) Numbers WSD1-SA423E/H-124 through 131 and 133 through 140, and 15M Diaphragm at WJ's WSD1-SA423F/H-1 through 8 and the 13M Diaphragm to Skin D at WJ WSD1-SA423E/H-132 and 15M Diaphragm to Skin D at WJ WSD1-SA423F/H-71 and 77 for Lift 1 West per ZPMC NDT Notification Sheet 003502. There was an area in a cope on the 13M Diaphragm that required some grinding. A ZPMC helper utilized a pencil grinder to re-work the area. There appeared to be no indications after the re-work and the QA Inspector accepted the above listed welds.

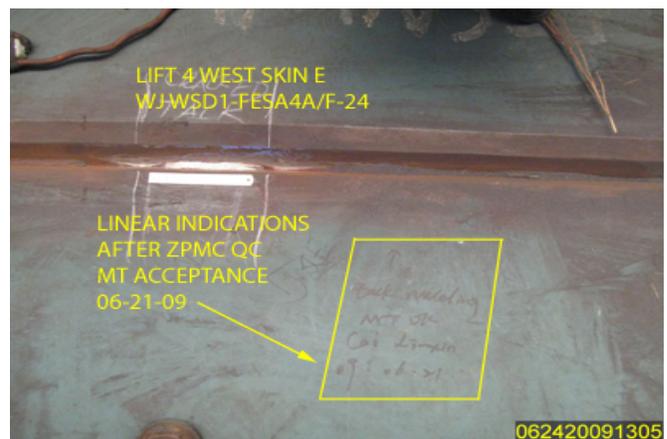
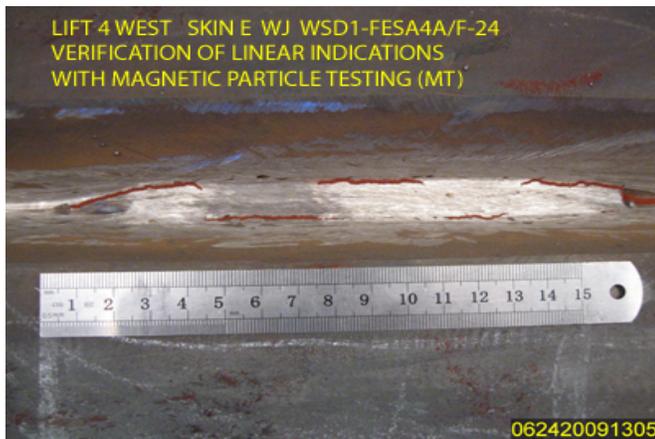
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The QA Inspector randomly observed visually, several tack welds in the root of Lift 4 West Skin E at Weld Joint (WJ) Numbers WSD1-FESA4A/F-24 and WSD1-FESA4A/F-3A with several linear indications in each tack weld. The QA Inspector verified the linear indications with MT and informed ZPMC Quality Control (QC) personnel. ZPMC production personnel began immediately to remove the tack welds containing the linear indications with angle grinders. The QA Inspector randomly observed that all of the tack welds had been previously accepted by MT by ZPMC QC personnel. The QA Inspector generated a TL-15 for the tack welds on Lift 4 West Skin E at Weld Joint (WJ) Numbers WSD1-FESA4A/F-24 and WSD1-FESA4A/F-3A. The attached photographs provide additional detail.

The QA Inspector performed a 100% VT Inspection 15% Magnetic Particle Testing (MT) Verification of the corner seam weld between Skin Plate C and B of Lift 2 West at WJ SSD1-TL6B/L-4 per ZPMC NDT Notification Sheet 003505. There appeared to be no and the QA Inspector accepted the above listed welds. The QA Inspector also signed the Green Tag Documentation for Green Tag Number 8222.

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



## Summary of Conversations:

No relevant conversations.

## Comments

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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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<b>Inspected By:</b>	Franco,Charlie	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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