

**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-007542**Date Inspected:** 25-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 in operation and that milling was being performed simultaneously on Skin Plates A through E on the upper elevation of Lift 1 East Tower Shaft and Skin Plates A through E on the lower elevation of Lift 2 East Tower Shaft.

The QA Inspector randomly observed that no contract work was being performed in the interior or on the exterior of or Lift 2 East Tower Shaft. The attached photographs provide additional detail.

The QA Inspector randomly observed 3 ZPMC Production personnel utilizing hand held cutting torches to cut the bevels on the longitudinal stiffeners and outside stiffeners on Lift 1 East Tower Shaft.

**Blast Shop:**

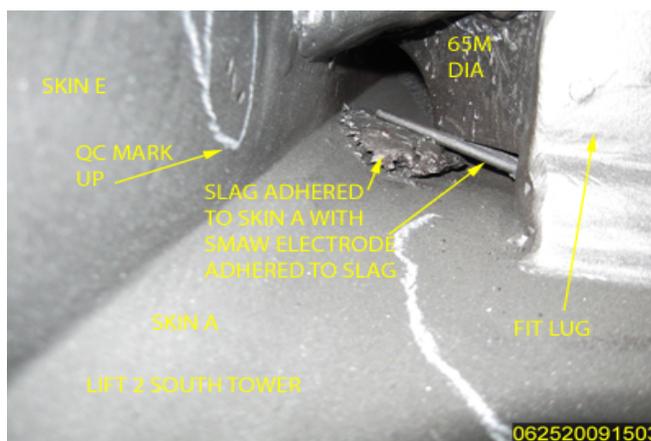
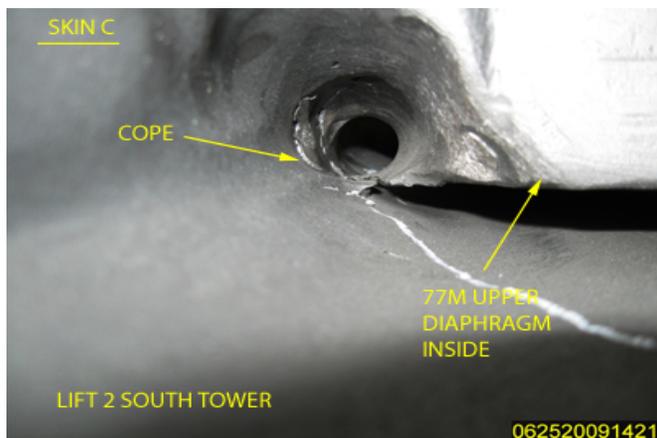
The QA Inspector was notified by ZPMC Quality Control (QC) personnel that Lift 2 South Tower Shaft would be ready for an after blast inspection from the bottom of the lift at elevation 83 M to 65 M Upper Diaphragm. The QA Inspector was at the blast shop at 1255 and randomly observed several ZPMC personnel vacuuming the

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interior of Lift 2 South from 83 M to 65 M. There were no QC personnel in the area at this time. The QA Inspector observed 6 QC personnel enter Lift 2 East Tower Shaft at 1325 to begin their after blast Visual Inspection (VT). The QA Inspector waited until the 6 QC personnel finished their VT Inspection from elevation 83 M to 80.75 M and then entered Lift 2 South Tower Shaft to begin his after blast VT Inspection. By the time the QA Inspector reached the top of the inside of 77 M Double Diaphragm, the 6 QC personnel had finished their VT Inspection from elevation 83 M to 65 M Upper Diaphragm and began to exit lift 2 South Tower Shaft. The QA Inspector began his after blast VT Inspection on the outside of 77 M Lower Diaphragm as the last of the 6 QC personnel exited the tower shaft. Once all of the QC Inspectors were out of the tower shaft several ZPMC production personnel entered and began grinding areas that had been marked up by QC personnel and the QA Inspector. The QA Inspector continued his after blast VT Inspection with ZPMC production personnel grinding all around his person. The QA Inspector marked up several areas for re-work which were missed by QC, completed his after blast VT Inspection and exited Lift 2 South Tower Shaft. The attached photographs provide additional detail.

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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