

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-007543**Date Inspected:** 26-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 and track mounted cutting torches to cut the bevels on the longitudinal stiffeners, outside stiffeners on Lift 1 East Tower Shaft Skins B, C and D; and the edge of Skin B.

The QA Inspector performed a 100% Final Visual Testing (VT) Inspection of the inside of Weld Joint (WJ) ESD1-A167G/H-141 between the fill plate and 18 M Upper Diaphragm on Skin A per ZPMC NDT Notification Sheet 003518 and ZPMC NCR-0252. There appeared to be no indications and the QA Inspector accepted the above listed weld. During the above listed VT of WJ ESD1-A167G/H-141, the QA Inspector randomly observed an area at the end of the weld attaching the web of 18M Diaphragm to Skin A, that contained a large void and

WELDING INSPECTION REPORT

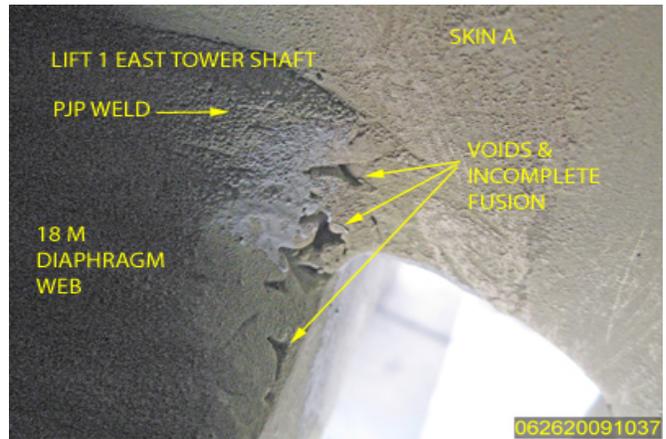
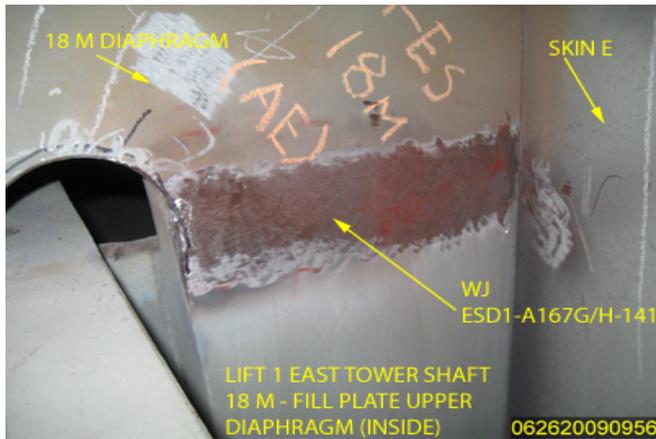
(Continued Page 2 of 2)

incomplete fusion. The QA Inspector informed ZPMC Quality Control (QC). ZPMC QC informed the QA Inspector that the area would be repaired and that ZPMC would notify the QA Inspector when repairs were completed. The attached photographs provide additional detail of the initial VT of WJ ESD1-A167G/H-141 and of the anomaly 18M Diaphragm Web to Skin A weld.

Heavy Equipment Shop Bay 10:

The QA Inspector performed a 100% VT Inspection 15% Magnetic Particle Testing (MT) Verification of the welds attaching the doubler plates to Skin Plate B of Lift 1 North at per ZPMC NDT Notification Sheet 003523. There appeared to be no indications and the QA Inspector accepted the above listed welds. The QA Inspector also signed the Green Tag Documentation for Green Tag Number 8380.

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.

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