

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-007560**Date Inspected:** 03-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**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).

Heavy Equipment Shop Bay 10:

The QA Inspector performed a 100% Visual Testing (VT) Inspection and a 15% Magnetic Particle Testing (MT) Verification of the top 750 mm of the corner seam weld on Lift 4 North between Skin Plate D and Skin Plate E per ZPMC NDT Notification Sheet 003578. There appeared to be no indications and the QA Inspector accepted the above listed weld.

The QA Inspector performed a 100% VT Inspection a 15% MT Verification of the 18M Double Diaphragm gusset to web welds Weld Joint (WJ) Numbers NSD1-A166H/J-104 and 93 on Lift 1 North Skin Plate D per ZPMC NDT Notification Sheet 003578. There appeared to be no indications and the QA Inspector accepted the above listed welds.

The QA Inspector performed a 100% VT Inspection a 15% MT Verification of the 23M Double Diaphragm gusset to web welds WJ's NSD1-A166G/J-102 and 94 on Lift 1 North Skin Plate D per ZPMC NDT Notification Sheet 003578. There appeared to be no indications and the QA Inspector accepted the above listed weld.

The QA Inspector performed a 100% VT Inspection a 15% MT Verification of the 28M Double Diaphragm gusset

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

to web welds WJ's NSD1-A166F/J-103 and 95 on Lift 1 North Skin Plate D per ZPMC NDT Notification Sheet 003578. There appeared to be no indications and the QA Inspector accepted the above listed weld.

The QA Inspector performed a 100% VT Inspection a 15% MT Verification of the 33M Double Diaphragm gusset to web welds WJ's NSD1-A166E/J-110 and 99 on Lift 1 North Skin Plate D per ZPMC NDT Notification Sheet 003578. There appeared to be no indications and the QA Inspector accepted the above listed weld.

The QA Inspector performed a 100% VT Inspection a 15% MT Verification of the 38M Double Diaphragm gusset to web welds WJ's NSD1-A166D/J-117 and 104 on Lift 1 North Skin Plate D per ZPMC NDT Notification Sheet 003578. There appeared to be no indications and the QA Inspector accepted the above listed weld.

The QA Inspector performed a 100% VT Inspection a 15% MT Verification of the 43M Double Diaphragm gusset to web welds WJ's NSD1-A166C/J-114 and 106 on Lift 1 North Skin Plate D per ZPMC NDT Notification Sheet 003578. There appeared to be no indications and the QA Inspector accepted the above listed weld.

The QA Inspector performed a 100% VT Inspection a 15% MT Verification of the 47.6M Double Diaphragm gusset to web welds WJ's NSD1-A112G/H-120 and 110 on Lift 1 North Skin Plate D per ZPMC NDT Notification Sheet 003578. There appeared to be no indications and the QA Inspector accepted the above listed weld.

The QA Inspector randomly observed ZPMC production personnel utilizing hand held torches to perform heat straightening operations on Lift 4 South Tower Shaft Skin Plate A per ZPMC Heat Straightening Request HSR1(T)-9664 and HSR1(T)-9665.

Heavy Equipment Shop Bay 10:

The QA Inspector performed a 100% Visual Testing (VT) Inspection and a 15% Magnetic Particle Testing (MT) Verification of the top 750 mm of the corner seam weld on Lift 4 North between Skin Plate D and Skin Plate E per ZPMC NDT Notification Sheet 003578. There appeared to be no indications and the QA Inspector accepted the above listed weld.

The QA Inspector performed a 100% VT Inspection a 15% MT Verification of the 18M Double Diaphragm gusset to web welds Weld Joint (WJ) Numbers NSD1-A166H/J-104 and 93 on Lift 1 North Skin Plate D per ZPMC NDT Notification Sheet 003578. There appeared to be no indications and the QA Inspector accepted the above listed welds.

The QA Inspector performed a 100% VT Inspection a 15% MT Verification of the 23M Double Diaphragm gusset to web welds WJ's NSD1-A166G/J-102 and 94 on Lift 1 North Skin Plate D per ZPMC NDT Notification Sheet 003578. There appeared to be no indications and the QA Inspector accepted the above listed weld.

The QA Inspector performed a 100% VT Inspection a 15% MT Verification of the 28M Double Diaphragm gusset to web welds WJ's NSD1-A166F/J-103 and 95 on Lift 1 North Skin Plate D per ZPMC NDT Notification Sheet 003578. There appeared to be no indications and the QA Inspector accepted the above listed weld.

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

The QA Inspector performed a 100% VT Inspection a 15% MT Verification of the 33M Double Diaphragm gusset to web welds WJ's NSD1-A166E/J-110 and 99 on Lift 1 North Skin Plate D per ZPMC NDT Notification Sheet 003578. There appeared to be no indications and the QA Inspector accepted the above listed weld.

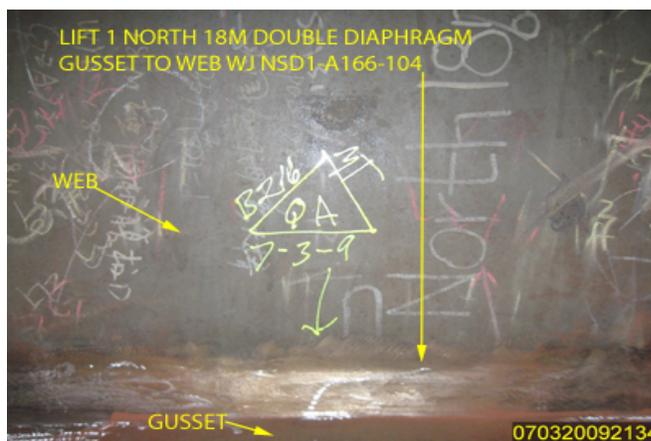
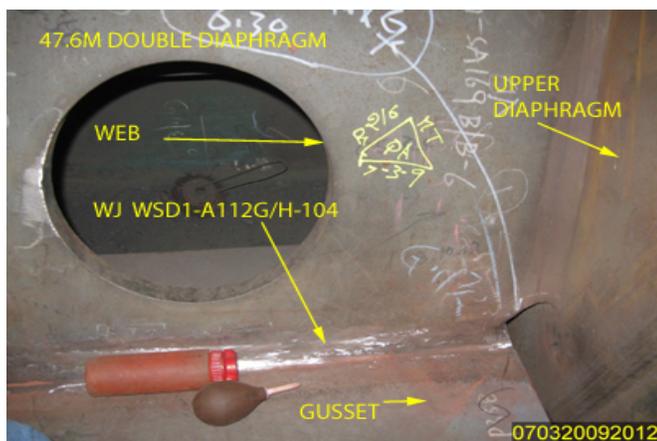
The QA Inspector performed a 100% VT Inspection a 15% MT Verification of the 38M Double Diaphragm gusset to web welds WJ's NSD1-A166D/J-117 and 104 on Lift 1 North Skin Plate D per ZPMC NDT Notification Sheet 003578. There appeared to be no indications and the QA Inspector accepted the above listed weld.

The QA Inspector performed a 100% VT Inspection a 15% MT Verification of the 43M Double Diaphragm gusset to web welds WJ's NSD1-A166C/J-114 and 106 on Lift 1 North Skin Plate D per ZPMC NDT Notification Sheet 003578. There appeared to be no indications and the QA Inspector accepted the above listed weld.

The QA Inspector performed a 100% VT Inspection a 15% MT Verification of the 47.6M Double Diaphragm gusset to web welds WJ's NSD1-A112G/H-120 and 110 on Lift 1 North Skin Plate D per ZPMC NDT Notification Sheet 003578. There appeared to be no indications and the QA Inspector accepted the above listed weld.

The QA Inspector randomly observed ZPMC production personnel utilizing hand held torches to perform heat straightening operations on Lift 4 South Tower Shaft Skin Plate A per ZPMC Heat Straightening Request HSR1(T)-9664 and HSR1(T)-9665.

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.

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

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