

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-008575**Date Inspected:** 24-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**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:** ZPMC and ABF**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:** SAS Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Wai Pau, was present during the times noted above for observations relative to the work being performed.

West Tower Lift #2: - Caltrans QA inspector performed final VT and dry MT inspection on fillet welds of diagonal plates for west tower lift #2. The diagonal plates located at skin plate B to C the weld number are WSD1-TL6J/L-20, WSD1-TL6H/L-37, WSD1-TL6G/L-78, WSD1-TL6F/L-33, WSD1-TL6E/L-149, WSD1-TL6E/L-22, WSD1-TL6D/L-82, and WSD1-TL6D/L-22. The diagonal plates located at skin plate C to D the weld number are WSD1-TL6J/L-30, WSD1-TL6H/L-151, WSD1-TL6H/L-54, WSD1-TL6G/L-93, WSD1-TL6F/L-53, WSD1-TL6E/L-37, WSD1-TL6D/L-99 and WSD1-TL6D/L-37. The fillet welds for MT inspection have been accepted by ZPMC prior Caltrans QA inspection. Base on Caltrans inspection, the four CJP stiffener welds appeared to be in compliance with requirements of AWS D1.5 2002 and Caltrans contract documents.

West Tower Lift #1: - Caltrans QA inspector performed final VT and dry MT inspection on fillet welds of diagonal plates for west tower lift #1. The diagonal plates located at skin plate B to C the weld number are WSD1-A115H/J-87, WSD1- A115G/J-81, WSD1- A115F/J-90, WSD1- A115E/J-211, WSD1- A115E/J-92, WSD1- A115D/J-214, WSD1- A115D/J-83, WSD1- A115C/J-203, WSD1- A423G/H-121, WSD1- A423F/H-66, WSD1- A423E/H-210, and WSD1- A423E/H-121. The diagonal plates located at skin plate C to D the weld number are WSD1-A115H/J-117, WSD1- A115G/J-118, WSD1- A115F/J121, WSD1- A115E/J-121, WSD1- A115E/J-124, WSD1- A115D/J-246, WSD1- A115D/J-111, WSD1- A115C/J-240, WSD1- A115C/J-96, WSD1- A423G/H-105, WSD1- A423F/H-61 and WSD1- A423E/H-120. The fillet welds for MT inspection have been

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accepted by ZPMC prior Caltrans QA inspection. Base on Caltrans inspection, the four CJP stiffener welds appeared to be in compliance with requirements of AWS D1.5 2002 and Caltrans contract documents.

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

Summary of Conversations:

As notes within report above.

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 Sinoved 13482570045, who represents the Office of Structural Materials for your project.

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| Inspected By: | Pau,Wai | Quality Assurance Inspector |
| Reviewed By: | Clifford,William | QA Reviewer |
