

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-008579**Date Inspected:** 17-Jul-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:** 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 Mr. Wai Pau, was present during the times noted above for observations relative to the work being performed.

Bay #10 South and North Tower Shop

North Tower Lift #1: - Caltrans QA inspector performed final VT and dry MT inspection on welds of brace plates for North tower lift #1. The brace plates between stiffener and skin B & C and the weld number is NSD1-SA11E/F-22, 23, 24, 25, NSD1-SA178C/D-19, 20, 21, 22 and NSD1-SA17F/G-142, 143, 144 and 145. The welds for VT and 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.

North Tower Lift#3:- Caltrans QA Inspector observed three ZPMC welders performed FCAW process on interior diaphragms. The interior diaphragms located at diaphragm elevation from 85.25m to 99m of skin plate E. The FCAW process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

North Tower Lift#2:- Caltrans QA Inspector observed six welders performed FCAW process on CJP weld for corner diagonal stiffener that connected skin plate C to D and B to C. The welding located at elevation 53m to 80.75m diaphragm sections. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

South Tower Lift #3:- Caltrans QA inspector observed four ZPMC welding operators performed semi-automatic SAW on outer corner longitudinal seam weld that connected skin plate C and D of south tower lift #3. The semi-automatic SAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI

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observations, no discrepancies were noted.

Bay #11 South and North Tower Shop

East Tower lift#1:- Caltrans QA Inspector observed five ZPMC grinders in process of grinding process on interior diaphragms. The interior diaphragms located at the elevation 85.25m to 116.25m diaphragm sections that connected skin plate A and B of east tower lift #3. The grinding process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

West Tower Lift#1:- Caltrans QA Inspector observed eight welders performed FCAW process on CJP weld for corner diagonal stiffener that connected skin plate C to D and B to C. The welding located at elevation 9m to 47.6m diaphragm sections. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

West Tower lift#1:- Caltrans QA Inspector observed five ZPMC grinders in process of grinding process on fit lugs. The fit lug located at the elevation 18m, 23m, 33m and 45m diaphragm sections that connected skin plate B, C and D of west tower lift #1. The grinding process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

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.

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