

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-008582**Date Inspected:** 01-Aug-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#2:- Caltrans QA Inspector observed seven 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 three welders performed FCAW repair process on inner corner longitudinal seam weld that connected skin plate B to C. The FCAW repair welding located at elevation 92.5m to 109m diaphragm section. The FCAW welding was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

North Tower lift#1:- Caltrans QA Inspector observed five ZPMC grinders and two welders in process of grinding and FCAW repair welding on corner diagonal stiffeners. The diagonal stiffeners located at the elevation 9m to 47.6m diaphragm sections that connected skin plate B, C and D of north tower lift #1. The grinding and FCAW repair welding process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

Bay #12

Tower façade part: - Caltrans QA inspector performed final VT and dry MT inspection on welds for seal plates of tower façade part. Tower façade parts ID number are ED1-A131-1-1~32, ED1-A131-2-1~32, ED1-A131-3-1~32,

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ED1-A131-4-1~32, ED1-A131-5-1~32, ED1-A131-6-1~32, ED1-A130-1-1~32, ED1-A130-2-1~32, ED1-A130-3-1~32, ED1-A130-4-1~32, ED1-A130-5-1~32, ED1-A130-6-1~32, ND1-A400-1-1~4, ND1-A401-2-1~4, ND1-A401-1-1~4, ND1-A400-2-1~4, ND1-A405-1-1~4, ND1-A405-2-1~4, ND1-A406-1-1~4, ND1-A406-2-1~4, ND1-A412-1-1~4, ND1-A412-2-1~4, ND1-A432-1-1~4, ND1-A432-2-1~4, ND1-A366-1-1~4, ND1-A366-2-1~4, ND1-370-1-1~4, ND1-A370-2-1~4, ND1-A385-1-1~4, ND1-A385-2-1~4, ND1-A384-1-1~4, ND1-A384-2-1~4, ND1-A340-1-1~8, ND1-A340-2-1~8, ND1-A345-1-1~8, ND1-A345-2-1~8, ND1-A129-1-1~8, ND1-A129-2-1~8, ND1-A128-1-1~8, ND1-A128-2-1~8, ND1-A197-1-1~8, ND1-A197-2-1~8, ND1-A199-1-1~8, ND1-A199-2-1~8, ND1-A360-1-1~12, ND1-A360-2-1~12, ND1-A361-1-1~12 and ND1-A361-2-1~12. The welds for VT and MT inspection have been accepted by ZPMC prior Caltrans QA inspection Base on Caltrans inspection, the welds appeared to be in compliance with requirements of AWS D1.5 2002 and Caltrans contract documents.

OBG U- plates: - Caltrans QA inspector performed final UT inspection on welds for OBG U- plates. The welds number are usp11-178-001, 002, usp11-179-001, 002, usp11-181-001, 002, usp11-182-001, 002, usp11-183-001, 002, usp11-184-001, 002, usp11-186-001, 002, usp11-187-001, 002, usp11-188-001, 002, usp11-189-001, 002 and usp11-190-001, 002. The welds for UT inspection have been accepted by ZPMC prior Caltrans QA inspection Base on Caltrans inspection, the 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.

Inspected By: Pau,Wai

Quality Assurance Inspector

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Reviewed By: Clifford, William

QA Reviewer