

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-008602**Date Inspected:** 05-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.

Tower Assemble Yard

East Tower Lift #1 & #2:- Caltrans QA Inspector observed six ZPMC workers performed drilling process on two tower connection areas of the skin plate A for east tower lift #1 & #2. The holes template has been installed and secured by hold devices, the alignment of holes template has accepted by ZPMC and ABF prior drilling hole. The drilling process has cancelled approximately 1030 due to the heat from the sun affect the alignment of skin plates. Based on Caltrans QA inspector observations, no discrepancies were noted.

East Tower Lift #1:- Caltrans QA Inspector observed ZPMC three welders performed FCAW build up weld metal welding for weld joint bevel on stiffeners which located at exterior bottom tower of skin plate C and D. The metal buildup on skin plate C is 1mm to 10mm thick and skin plate D is 1mm to 12mm thick. The FCAW welding was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

South Tower Lift #1 & #2:- Caltrans QA Inspector observed seven ZPMC workers adjusted the alignments for the skin plate A, B, C, D and E between the connection of south tower lift #1 and #2. The alignments have 7mm off set on skin plate C and D after three hours adjustment operation. The operation has been cancelled at 1030 due to heat of sun affect the skin plates. Based on Caltrans QAI observations, no discrepancies were noted.

South Tower Lift #1:- Caltrans QA Inspector observed ZPMC two welders performed FCAW build up weld metal welding for weld joint bevel on the skin plate A and E of south tower lift #1. The metal buildup on skin plate is from 1mm to 12mm thick. The FCAW welding was monitored and recorded by ZPMC and ABF QC inspector.

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Based on Caltrans QAI observations, no discrepancies were noted.

Bay #11 South and North Tower Shop

West 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 to D of west tower lift #3. The semi-automatic SAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

West Tower Lift#2:- Caltrans QA Inspector observed six ZPMC grinders in process of grinding on fit lugs and rat holes of interior diaphragms. The fit lugs and rat holes located at the elevation 53m to 80.75m diaphragm sections that connected skin plate A and E of west tower lift #2. 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#3:- Caltrans QA Inspector observed two welders performed FCAW process on outer corner longitudinal seam weld that connected skin plate C to D. The FCAW welding is one meter length areas are located two roller installing surface. The FCAW 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.



East tower lift #1 & #2 skin plate A drilling holes with holes template

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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