

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-008605**Date Inspected:** 06-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 fifteen ZPMC workers performed drilling process on two tower connection areas of the skin plate B, C, and E 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. Based on Caltrans QA inspector observations, no discrepancies were noted.

Bay #11 East and West Tower Shop

West Tower Lift #1:- Caltrans QA Inspector observed six welders performed FCAW welding process on the corner cover plates that connected skin plate A and E. Total 14 pieces corner cover plates are located at elevation 18m to 47.6m double diaphragm section. The FCAW welding were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

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 B to C 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#3:- Caltrans QA Inspector observed three ZPMC workers and two welders in process of FCAW process on interior diaphragms to skin plate. The interior diaphragms located at the elevation 89m to 105.5m diaphragm sections that connected skin plate D. The FCAW process was monitored and recorded by ZPMC and

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ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

East Tower Lift #3:- 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 85.25m to 111.67m diaphragm sections that connected skin plate B and C 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.

East Tower Lift #3:- Caltrans QA Inspector observed two 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 89m and 109m diaphragm section. The FCAW repair welding was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector 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
Reviewed By:	Clifford,William	QA Reviewer
