

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-009669**Date Inspected:** 15-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 four ZPMC grinders and one welder in process of grinding and FCAW repair welding on fit lugs and rat holes of interior diaphragms. The fit lugs and rat holes located at the elevation 53 m, 59m, 71m and 77m diaphragm sections that connected skin plate D of north tower lift #2. The grinding and FCAW repair welding process were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

North Tower Lift #1:- Caltrans QA Inspector observed six ZPMC grinders and two welders in process of grinding and FCAW repair welding on fit lugs and rat holes of interior diaphragms. The fit lugs and rat holes located at the elevation 13 m to 43m diaphragm sections that connected skin plate D of north tower lift #1. The grinding and FCAW repair welding process were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

North Tower Lift #1:- Caltrans QA Inspector observed two welders performed FCAW repair process on inner corner longitudinal seam weld that connected skin plate A to E. The FCAW repair welding located at elevation 23m and 38m 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.

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North Tower Lift #3:- Caltrans QA inspector observed three ZPMC welding operators performed semi-automatic SAW on outer corner longitudinal seam weld that connected skin plate D to E of north 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.

South Tower Lift #3:- Caltrans QA Inspector observed four ZPMC grinders and one welder in process of grinding and FCAW repair welding on fit lugs and rat holes of interior diaphragms. The fit lugs and rat holes located at the elevation 89m, 92.5m, 99m, 102.5m and 109m diaphragm sections that connected skin plate D of south tower lift #3. The grinding and FCAW repair welding process were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

Tower Assemble Yard

South Tower Lift #1 & #2:- Caltrans QA Inspector observed fourteen ZPMC workers performed drilling process on two tower connection areas of the skin plate B and C for south 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.

East Tower Lift #1:- Caltrans QA Inspector observed ZPMC four grinders performed grinding process on buildup weld metal for weld joint bevel. The buildup weld metal is on stiffeners which located at exterior bottom tower of skin plate A, B, C, D and E for east tower lift #1. The grinding was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

East Tower Lift #1 & #2:- Caltrans QA Inspector observed ten ZPMC workers performed drilling process on two tower connection areas of the skin plate C and D 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

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
