

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-009907**Date Inspected:** 09-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhan Bo, An Qin Xiang.**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:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay11, East Tower, Lift 4, Skin D Corner Seam(Inside).

During random visual inspection at East Shaft, Lift 4; this Caltrans Quality Assurance (QA) Inspector observed Transverse and Longitudinal Linear Indications in the root-pass of the 143M double diaphragm Top & Bottom to the skin 'D' weld ESTL4-2K/L-66, 62(Observed by Amit Juvekar.) & ESTL4-2K/L-125(Observed by Shrikant Utekar.). The linear indications were shown to ZPMC and ABF QC Inspectors. This Caltrans Quality Assurance (QA) Inspector also confirmed these Indications by Magnetic Particle Testing. This QA Inspector Have Submitted Incident Report on this Issue on same date.

Bay11, West Tower, Lift 3, A/E Corner Backfill Plate Weld(Inside).

SMAW welding of weld joint WSTL3-4I/K-35; located on Bay11, West Tower, Lift 3. Welders are identified as 046704; ZPMC Quality Control Inspector (QC) is identified as An Qin Xiang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-3212-B-U2A-2.

Bay11, West Tower, Skirt Beam.

FCAW welding of weld joint WSD1-A801B/D-11; located on Bay11, West Tower. Welder is identified as 049220; ZPMC Quality Control Inspector (QC) is identified as Zhan Bo. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2332-TC-P4-F.

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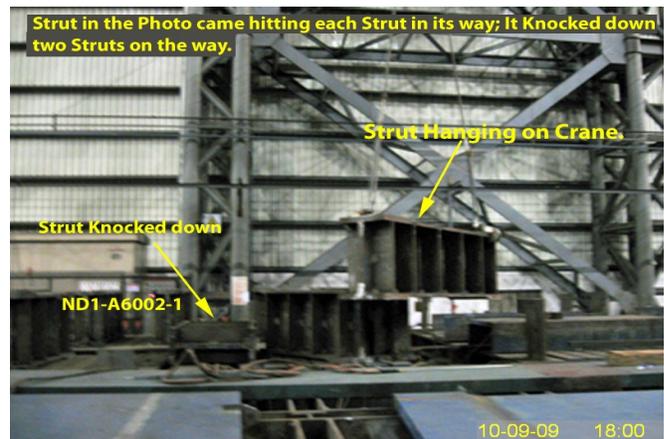
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Bay11, East Tower, Lift 4, A/E Corner Seam Weld(Ring Area).

FCAW Repair welding of weld joint ESTL4-2B/L-60A; located on Bay11, East Tower. Welders are identified as 053316, 040775; ZPMC Quality Control Inspector (QC) is identified as Peng Guo. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2232-C-U2-F.

This Caltrans Quality Assurance (QA) Inspector observed ZPMC Crane operator lost control over crane while moving Srtut. Strut hanging hit several Struts in the way & Knocked down two(2) Struts Identified as ND1-A6002-3 & ND1-6002-1. No damages found on the other struts except few scratches. The strut which are knocked down to be checked for damages after ZPMC lift it up again. No incident report submitted on this issue. The attached photographs provide additional detail

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

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 Sinevod, 13482570045, who represents the Office of Structural Materials for

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your project.

Inspected By:	Juvekar,Amit	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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