

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-010279**Date Inspected:** 26-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:** 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:

Bay 11, North Tower, Lift 3, A/E Corner Seam, 109M(TOP).

During random In process inspection this QA Inspector observed repaired spot. This is the same spot which has been excavated on 24th Oct'09 (Please refer to the incident report on date 10/24/09) at A/E Corner Seam 109M(top) inside North Tower Lift 3. Upon asking to QC about Weld Repair Report (WRR)/ Welding procedure(WPS), ZPMC QC was not aware of that repair & refused to show any related document. As this QA inspector started tacking pictures ZPMC worker tried to erase UT Repair markings by grinding on the skin Plate about that repair. See attached pictures for details.

Bay 11, West Tower, Lift 2.

Installing Interior Splice Plate on skin B.

Bay 11, West Tower, Lift 1, Skin E.

FCAW Repair welding (Build up) of E-4 Stiffener (WWR # T-WR2582); located on Bay 11, West Tower. Welders are identified as 040723; 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-345-FCAW-2G(2F)-Repair.

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Bay10, South Tower, Interior Splice Plate.

FCAW Repair welding of weld joint SSD1-SPSA3-56-4A (WWR # T-WR2528); located on Bay10, South Tower. Welders are identified as 048627; ZPMC Quality Control Inspector (QC) is identified as Liu Zhong An. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-FCAW-2G(2F)-Repair.

This QA Inspector carried out NDE on following

Bay 11, North Tower, Lift 3, Corner BC, CD Stiffener.

This QA inspector performs Random Ultrasonic Testing (UT) of approximately 10% area previously tested and accepted by ZPMC Quality Control personnel, FOR GREEN TAG. This QA Inspector generated an UT report(TL-6027) for this date. The members are identified as

- 1) ED1-STSA3-2-89M-1-1, 2, 4, 6.
- 2) ED1-STSA3-2-89M-2-1, 2, 4, 6.
- 3) ED1-STSA3-2-99M-1-1, 2, 4, 6.
- 4) ED1-STSA3-2-99M-2-1, 2, 4, 6.
- 5) ED1-STSA3-2-109M-1-1, 2, 4, 6.
- 6) ED1-STSA3-2-109M-2-1, 2, 4, 6.

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



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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 your project.

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