

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-010299**Date Inspected:** 31-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:** Yu Dong Ping.**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:

Bay10, South Tower, Lift 4, Skin C, Near 143M, Temporary Attachment Area.

During random visual inspection at South Shaft, Lift 4, Skin C (Temporary Attachment Area near Corner Seam C/D) this Caltrans Quality Assurance (QA) Inspector observed "Crack Like" indications at the removed Temporary attachment Weld area. The indications were shown to ZPMC and ABF QC Inspectors. No Incident Report has been written on this issue. The attached photographs provide additional detail.

Bay11, East Tower, Corner Angle Plate, Repair Gouge out.

During random visual inspection at East Shaft, This QA Inspector observed Repair Gouge out. Weld identified as ED1-A5001-1-1B. The attached photographs provide additional detail.

Bay11, South Tower, Strut, Base metal Damaged.

During random visual inspection at South Tower, This QA Inspector observed Base metal Damaged on the edge of Strut identified as SD1-A6002-7-1A/B. The attached photographs provide additional detail.

Bay11, West Tower, Lift 1.

1) Installation of Interior Splice Plate on Skin E.

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Bay 11, West tower, Corner Angle Splice.

SMAW Repair welding of weld joint WD1-SA3-18-99M-5-1A(WRR # T-WR2598); located on Bay 11, West tower. Welders are identified as 040614; ZPMC Quality Control Inspector (QC) is identified as Yu Dong Ping. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-485-SMAW-1G(1F)-FCM-REPAIR-1.

Bay 11, West tower, Corner Angle Splice.

SMAW Repair welding of weld joint WD1-SA3-18-99M-8-1A(WRR # T-WR2599); located on Bay 11, West tower. Welders are identified as 041271; ZPMC Quality Control Inspector (QC) is identified as Yu Dong Ping. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-485-SMAW-1G(1F)-FCM-REPAIR-1.

Bay 11, East tower, Lift 4, 119M, Stiffener to Diaphragm.

FCAW welding of weld joint ESTL4-2C/L-42, 39; located on Bay 11, East tower, Lift 4. Welders are identified as 053316; ZPMC Quality Control Inspector (QC) is identified as Li Lin. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-4333-TC-P4-F.

Bay10, North Tower, Lift 1 & 2.

Ready for Assembly.

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.

Inspected By: Juvekar,Amit

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer