

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-010596**Date Inspected:** 25-Oct-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**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:** OBG**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#5

Traveler rails: - Caltrans QA inspector observed four ZPMC welders performed FCAW process on the flange to web plate of traveler rail #10TK3-015, 10TR3-013, 10TR3-029, 10TR3-030, TR103-007 and 10TK3-020. This type component designed has CJP and PJP weld along on one side of full weld length and other side has CJP only. All the welding areas have been pre heating prior FCAW welding. The FCAW process were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA Inspector observations, no discrepancies were noted.

Traveler rails: - Caltrans QA inspector observed two ZPMC workers and one tack weld welder performed fit up and SMAW tack weld process on the flange to web plate of eight traveler rails 10TR3 type. A numerous temporary tack welds have been welded attach to the web after adjusted and secured by template. The fit up and SMAW tack welding process were monitored and recorded by ZPMC and ABF QC inspector. Base on Caltrans QAI observation, no discrepancies were noted.

Bay#6

Tower strut: - Caltrans QA Inspector observed two welders performed SMAW critical and noncritical weld repair process on tower strut and 90 degree angle plate. The tower strut and angle plate weld ID are WD1-A305-65M-1-12A/B and ND1-SA658-53M-15-1A/B. The SMAW critical repair weld located at web to

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flange and noncritical weld repair located at plate to plate which has been rejected by ZPMC UT testing. The weld repair report number for critical is T-CWR-335 and noncritical is TWR-2468. The SMAW critical and noncritical weld repair is monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

Bike path: - Caltrans QA Inspector observed three welders performed FCAW process on six lift lugs of bike path. The bike path ID is BK-001-043, BK-001-044 and BK-001-047. The FCAW welding process were monitored and recorded by ZPMC and ABF QC inspector. Base on Caltrans QAI observation, 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 Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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Inspected By:	Pau, Wai	Quality Assurance Inspector
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Reviewed By:	Clifford, William	QA Reviewer
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