

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-010921**Date Inspected:** 28-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**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 Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

Heavy Dock

This QA Inspector randomly observed the following work in progress on the Heavy Dock:

QA Inspector Amit Juvekar informed this QA Inspector of crack-like linear indications at temporary attachment areas inside east tower shaft, lift 1 and provided this QA Inspector with photos by way of email. This QA Inspector was instructed to observe these indications and monitor any work being performed by ZPMC personnel in this area. This QA Inspector proceeded to the area and visually observed and verified the indications near weld joints ESD1-297B/E-6, 10, 12 located inside the shaft at the bottom of PCMK east tower, lift 1, at skin E. This QA Inspector observed what appeared to be the same indications and same conditions as seen in the photos noted above. See photos taken by this QA Inspector below. No work was observed being performed at either of these locations.

Bay 11

This QA Inspector randomly observed the following work in progress in Bay 11:

SAW welding of weld joint WSTL4-2L/L-4A located outside PCMK west tower, lift 4, skin A to skin B, between approximately 144M and 146M elevations. Welder was identified as 040772. ZPMC QC was identified as CWI Liu Xiao Zhong (QC1). The welding variables recorded by QC1 appeared to comply with

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WPS-B-T-3221-C-U2b-S. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Wang Jiang Hua.

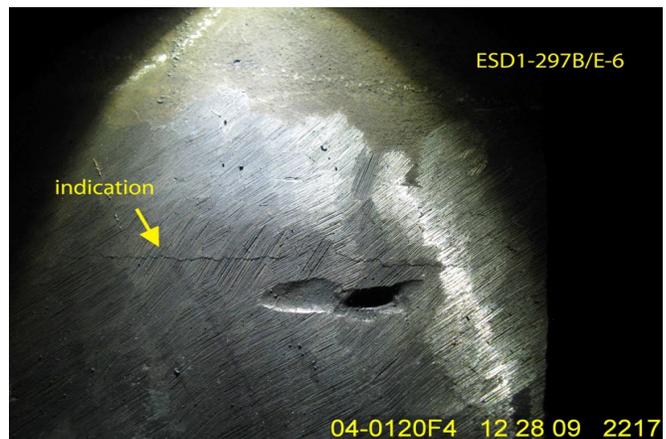
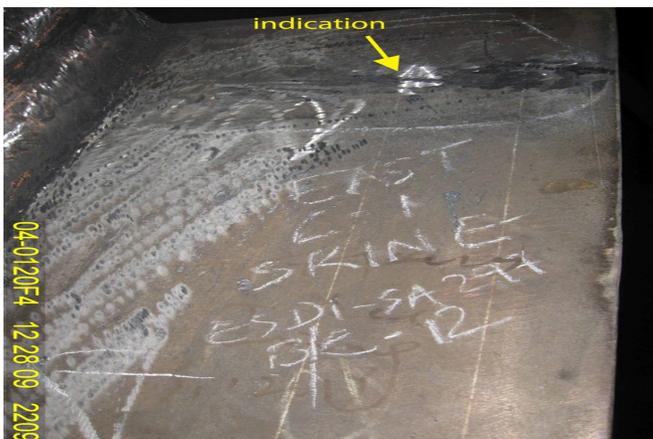
SAW welding of weld joint WSTL4-2B/L-59A located outside PCMK west tower, lift 4, skin A to skin B, between approximately 138M and 144M elevations. Welder was identified as 202756. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2221-C-U2b-S. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Wang Jiang Hua.

SAW welding of weld joint WSTL4-2B/L-59A located outside PCMK west tower, lift 4, skin A to skin B, between approximately 131M and 135M elevations. Welder was identified as 042195. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2221-C-U2b-S. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Wang Jiang Hua.

SAW welding of weld joint WSTL4-2B/L-59A located outside PCMK west tower, lift 4, skin A to skin B, between approximately 127M and 131M elevations. Welder was identified as 047304. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2221-C-U2b-S. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Wang Jiang hua.

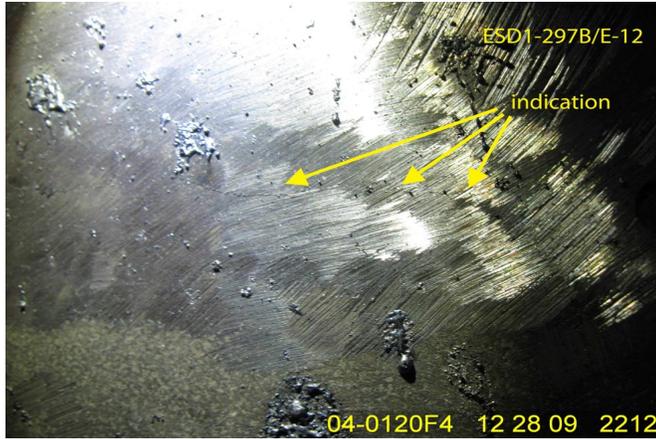
SAW welding of weld joint WSTL4-2B/L-59A located outside PCMK west tower, lift 4, skin A to skin B, between approximately 122M and 127M elevations. Welder was identified as 041716. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2221-C-U2b-S. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Wang Jiang hua.

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



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Summary of Conversations:

As noted 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 Sinevod, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By: Goulet, George

Quality Assurance Inspector

Reviewed By: Dawson, Paul

QA Reviewer