

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-011141**Date Inspected:** 10-Dec-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:** Tower**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.

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North tower lift #4 plate: - Caltrans QA inspector performed final dry MT inspection on CJP welds of steel plate for north tower lift #4. The steel plate welds ID are NSD1-TL5-3CF-9B, NSD1-TL5-3CF-8B and NSD1-TL5-3EF-4A. The welds for dry MT inspection have been accepted by ZPMC and ABF prior Caltrans QA inspection. Base on Caltrans MT inspection, the welds appeared to be in compliance with requirements of AWS D1.5 2002 and Caltrans contract documents.

South tower lift #5 plates: - Caltrans QA inspector performed final dry MT inspection on CJP welds of steel plate for south tower lift #5. The steel plate welds ID are SSD1-TL5-1E-F-14A, SSD1-TL5-1E-F-9A, SSD1-TL5-3C-F-7B and SSD1-TL5-1C-F-8A. The welds for dry MT inspection have been accepted by ZPMC and ABF prior Caltrans QA inspection. Base on Caltrans MT inspection, the welds appeared to be in compliance with requirements of AWS D1.5 2002 and Caltrans contract documents.

South tower lift #4 plates: - Caltrans QA inspector performed final dry MT inspection on CJP welds of steel plate for south tower lift #4. The steel plate welds ID are SSD1-TL5-1C-F-7B, and SSD1-TL5-1E-F-13B. The welds for dry MT inspection have been accepted by ZPMC and ABF prior Caltrans QA inspection. Base on Caltrans MT inspection, the welds appeared to be in compliance with requirements of AWS D1.5 2002 and Caltrans contract documents.

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South Tower Lift #4: - Caltrans QA inspector performed final VT and dry MT inspection on welds of diagonal square plates for south tower lift #4. The diagonal square plates and welds ID are SST14-1B/1-50/20, SST14-1E/1-64/125/21/77, SST14-1F/1-63/125/4/74, SST14-1G/1-58/122/2/73, SST14-1H/1-58/119/2/73, SST14-1i/1-59/122/4/73, sst14-1J/1-58/120/2/73 and SST14-1K/1-61/120/2/73. The welds for VT and MT inspection have been accepted by ZPMC prior Caltrans QA inspection. Base on Caltrans inspection, the welds appeared to be in compliance with requirements of AWS D1.5 2002 and Caltrans contract documents.

Tower strut: - Caltrans QA Inspector observed three welders performed t SMAW process on the CJP and fillet welds of tower strut. The tower strut weld ID is ED1-STSA3-1-89M-1, ED1-STSA3-2-99M-1 and ED1-SAS3-2-89M-1. The CJP welds located at flange to web and the fillet located at web to stiffeners. All the welding area has been pre heat prior welding. The SMAW process is monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

Tower strut: - Caltrans QA Inspector observed two welder performed SMAW noncritical repair weld process on CJP welds which connected to flange to web. The tower strut weld ID is ND1-A6002-9-9A and ND1-A6002-1-7A. The SMAW noncritical repair is rejected by ZPMC UT inspection. The size of repair welds is 25mm depth x100mm length and 30mm depth x 80mm depth. The SMAW noncritical weld repair is monitored and recorded by ZPMC and ABF QC inspector.

Based on Caltrans QA inspector observations, 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 Serge Sinevod 13482570045 , who represents the Office of Structural Materials for your project.

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