

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-011142**Date Inspected:** 17-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.

Bay #10

Tower strut: - Caltrans QA Inspector observed three welders performed SMAW process on the CJP and fillet welds of tower strut. The tower strut ID is SD1-STSA3-1-109M-1, SD1-STSA3-1-89M-1, WD1-STSA3-2-99M-2, WD1-STSA3-2-99M-1, WD1-STSA3-2-109M-2 and SD1-STSA3-1-99M-1. The CJP welds located at flange to web and the fillet located at web to stiffeners. All the welding areas have 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 welders performed SMAW noncritical repair weld process on CJP welds which connected to flange to web. The tower struts ID are SD1-A6002-3 and SD1-A6002-6. The SMAW noncritical repair is rejected by ZPMC VT inspection. 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.

Interior connection plate: - Caltrans QA Inspector observed a welder performed SMAW process on CJP welds which connected to stiffener to base plate of skin C for west tower between lift #3 and lift #4. The interior connection plate welds ID is WSD1-SPSA-4-2-2A/B. The welding areas have been pre heat prior welding. The SMAW process is monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

observations, no discrepancies were noted.

Bay #11

Transverse diaphragm: - Caltrans QA Inspector observed three welder performed SMAW process on CJP welds of north tower lift#4. The transverse diaphragm ID is ND1-BPSA-5-3-2A/B and ND1-BPSA-5-1-1A/B. The welding areas have 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.

Interior connection plate: - Caltrans QA Inspector observed a welder performed SMAW process on CJP welds which connected to stiffener to base plate of skin C for north tower between lift #3 and lift#4. The interior connection plate welds ID is NSD1-SPSA4-18-2A/B. The welding areas have 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 three welders performed SMAW noncritical repair weld process on fillet welds which connected to flange to web. The tower struts ID are ND1-STSA3-1-89M-1 and NDI-A6002-12-10A The SMAW noncritical repair is rejected by ZPMC VT inspection. 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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Pau, Wai	Quality Assurance Inspector
----------------------	----------	-----------------------------

Reviewed By:	Clifford, William	QA Reviewer
---------------------	-------------------	-------------