DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-011145
Date Inspected: 25-Dec-2009

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 1700
OSM Departure Time: 1900
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 #11

East tower lift#4:- Caltrans QA Inspector observed six welders performed FCAW process on CJP weld for corner diagonal stiffener that connected skin plate C to D. The welding located at elevation114m to 146.28m. The minimum preheat and maximum interpass temperature requirements for FCAW CJP weld are 110C degree and 230 C degree. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

West Tower Lift#3:- Caltrans QA Inspector observed four ZPMC grinders performed grinding process on fit lugs and rat holes of diaphragm that connected skin plate C, D and E. The fit lugs and rat holes are located at elevation between 89m to 109m diaphragm section. The grinding and FCAW welding process are removing and repair the fillet welds that have been rejected by ZPMC VT inspection. Base on Caltrans observation, no discrepancies were noted.

West tower Lift #3:- Caltrans QA Inspector observed nine ZPMC workers performed drilling process on exterior square plate attached to skin E for west tower lift #3. The holes template has been installed and secured by hold devices, the alignment of holes template has accepted by ZPMC and ABF prior drilling hole. Based on Caltrans QA inspector observations, no discrepancies were noted.

WELDING INSPECTION REPORT

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West Tower Lift #4:- Caltrans QA inspector observed four ZPMC welding operators performed semi-automatic SAW on outer corner longitudinal seam weld # WSTL4-2B/L-5A that connected skin plate C and skin plate D of west tower lift #4. The weld designed is a double -V-groove with welding conducted in the in flat position (1G). The minimum preheat and maximum interpass temperature requirements for SAW longitudinal seam weld are 110C degree and 230 C degree. The semi-automatic SAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

Bay #10

North tower lift#2:- Caltrans QA Inspector observed a welder performed FCAW process on fillet weld for two exterior square plates that connected skin plate D. The minimum preheat and maximum interpass temperature requirements for FCAW fillet weld are 110C degree and 230 C degree. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

North Tower Lift #4:- Caltrans QA inspector observed four ZPMC welding operators performed semi-automatic SAW on outer corner longitudinal seam weld # NSTL4-3B/L-5A that connected skin plate A and skin plate B of north tower lift #4. The weld designed is a double -V-groove with welding conducted in the in flat position (1G). The minimum preheat and maximum interpass temperature requirements for SAW longitudinal seam weld are 110C degree and 230 C degree. The semi-automatic SAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI 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