

**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-012045**Date Inspected:** 13-Jan-2010**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 #11**

West tower lift#4:- Caltrans QA Inspector observed seven welders performed FCAW process on CJP weld for corner diagonal stiffener that connected skin plate C to D of east tower lift #4. The welding located at elevation 114m to 146.28m. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

West tower lift #4:- Caltrans QA Inspector observed two welders performed FCAW repair process on four spots for inner corner longitudinal seam weld that connected skin plate C and D. All the excavated weld areas have been MT test prior repair welding. The FCAW repair welding was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

West tower lift #4:- Caltrans QA Inspector observed a welder performed FCAW process on exterior corner longitudinal seam weld that connected skin plate B to C. The weld number is WSTLL4-2B/L-58. The welding located at elevation between ASTM 345 material connects to ASTM 485 with 200 mm length. The minimum preheat and maximum interpass temperature requirements for FCAW longitudinal seam weld are 180C 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.

Tower strut connection plate: - Caltrans QA Inspector observed a ZPMC welding operator performed SAW process on CJP weld of tower strut connection plate for tower elevation 123m. . The CJP weld and plate ID are ED1-STSA4-6-123M-1-7B, ED1-STSA4-6-123M-2-7B, ND1-STSA4-6-123M-1-7B, ND1-STSA4-6-127M-1-8B, ND1-STSA4-6-127M-1-8B and ED1-STSA4-6-131M-1-8B. The SAW welding was monitored and recorded by

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ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted. East tower lift #5:- Caltrans QA Inspector observed four welders performed SMAW process on inner corner longitudinal seam welds that connected skin plate C to D and D to E. The seam welds number #ESD1-TL5-2B/F-16A/39A and ESD1-TL5-2B/F-24B/40A. The SMAW welding was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

## CLOSING STATEMENT

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 Skyler Guest 15000422360 , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Pau,Wai	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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