

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-012046**Date Inspected:** 14-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**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

South tower lift 2: - Caltrans QA Inspector performed QA final VT and dry MT testing on the fillet welds of tower pad eyes. The ZPMC inspection request number is 005054. The pad eyes fillet welds ID for skin A is SSD1-SA164A/F-20~33. Skin B is SSD1-SA163A/D-30~39 and SSD1-SA163B/D-1~4. All the fillet welds have been accepted by ZPMC and ABF prior Caltrans QA inspection. Base on Caltrans VT and MT testing, the fillet welds appeared to be in compliance with requirements of AWS D1.5 2002 and Caltrans contract documents. A green tag # 11591 has been signed on this pad eyes by ABF after Caltrans completed the testing.

North tower lift 2: - Caltrans QA Inspector performed QA final VT and dry MT testing on the buttering welds of interior splice plate for skin plate B, D and E which connected to north tower lift #2 and #3. The ZPMC inspection request number is 005057. The buttering welds ID for skin B is nsd1-spsa3-62, skin d is nsd1-spsa3-70 and skin E is nsd1-sapsa3-4. The length of three buttering areas is 13mm for each. All the buttering areas have been accepted by ZPMC and ABF prior Caltrans QA inspection. Base on Caltrans VT and MT testing, the buttering areas appeared to be in compliance with requirements of AWS D1.5 2002 and Caltrans contract documents. A green tag # 16654-R1, 11689-R1 and 11682 R1 have been signed on these buttering areas by ABF after Caltrans completed the testing.

Tower strut plate: - Caltrans QA inspector performed final QA VT, dry MT, UT test and dimension check on CJP and fillet welds of strut plate. The ZPMC inspection request number is 005058. The strut plates welds and ID are wd1-stsa3-2-99m-1-61/64/24/10/11/1~4/6/8~61/64. The CJP and fillet welds for dry MT testing have been accepted by ZPMC prior Caltrans QA inspection. Base on Caltrans MT inspection, the welds appeared to be in

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compliance with requirements of AWS D1.5 2002 and Caltrans contract documents. A green tag # 11706 has been signed on these buttering areas by ABF after Caltrans completed the testing.

Bay #11

East tower lift 4: - Caltrans QA Inspector performed QA final VT and dry MT testing on the PJP welds of diagonal stiffeners of skin plate C and D for east tower lift #4. The ZPMC inspection request number is 005055. The PJP welds located at 123m, 131m and 143m diaphragm sections. The PJP welds ID is Est14-2k/1-71/72/1/2, Est14-2f/1-71/72/1/2, Est14-2h/1-70/72/1/2 and Est14-2b/1-7/3. All the PJP welds have been accepted by ZPMC and ABF prior Caltrans QA inspection. Base on Caltrans VT and MT testing, the PJP welds appeared to be in compliance with requirements of AWS D1.5 2002 and Caltrans contract documents.

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.

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