

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-012070**Date Inspected:** 27-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.

Strut connection flat plate: - Caltrans QA Inspector observed two ZPMC welding operators performed SAW process on CJP weld of tower strut connection flat plate. The material used tower strut connection flat plate was reported by ZPMC QC as ASTM 345 with 28mm wall thickness and ASTM 485 with 60mm wall thickness. The CJP weld and plate ID are ED1-STSA4-10-119M-2-6B; ED1-STSA4-10-119M-1-6B, ED1-STSA4-6-127M-2-2B, ND1-STSA4-6-127M-2-2B, ED1-STSA4-6-131M-1-2B, ED1-STSA4-6-127M-2-4A, ND1-STSA4-6-127M-2-4A, ND1-STSA4-6-127M-1-4A, ED1-STSA4-6-131M-1-4A, ED1-STSA4-6-131M-2-4A. The SAW welding was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

Strut connection U shape plate: - Caltrans QA Inspector observed a ZPMC welding operator performed SAW process on CJP weld of strut connection U shape plates. The material of strut connection U shape plate is ASTM 485 with 40mm wall thickness. The CJP weld and plate ID is ED1-SA4-68-127M-87-1B, ED1-SA4-68-127M-71-1B and ED1-SA4-68-127M-61-1B. The SMAW process 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 three welders performed SMAW repair process on the interior corner longitudinal seam welds that connected skin plate C to D. The repair weld area has been pre heat prior welding. The repair welding located at elevation 127m and 131m. The SMAW repair processes were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

East tower lift #4:- Caltrans QA Inspector observed four welders performed SMAW repair process on the interior

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corner longitudinal seam welds that connected skin plate A to B. The repair weld area has been pre heat prior welding. The repair welding located at elevation 123m, 127m and 131m. The SMAW repair processes were 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
