

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-012474**Date Inspected:** 22-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	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 and OBG Components	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Bays 10 and 11

No welding related work was observed being performed in either Bay 10 or Bay 11.

Heavy Dock

This QA Inspector randomly observed the following work in progress on the Heavy Dock:

The elevator was not manned and it appeared that no work was being performed at the lift 1/ lift 2 joints of the east and south towers. West tower, lift 2 was in a horizontal position on the deck near the foot of the heavy dock. The ZPMC 1600 ton floating crane was rigged with belly straps draped loosely under west tower, lift 2.

OBG Trial Assembly Area

This QA Inspector randomly observed the following work in progress in the OBG Trial Assembly Area:

No welding related work was observed being performed in the OBG Trial Assembly Area. However, the following was observed:

Four ABF technicians were performing magnetic particle testing (MT) and grinding outside OBG section

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6BE/6CE, at the areas of temporary alignment plate removal only at tranverse seams across the entire deck and both edge plates. Several areas were marked by ABF technicians as displaying indications.

ZPMC workers were spraying zinc-based coating inside OBG section 5CW in the bottom plate area between panel points 34 and 35.

Bay 10 - MT

This QA Inspector performed random visual testing (VT) and then MT of approximately 15% of the tack welds of the welds noted below. This inspection was performed on an informational basis and no TL-6028 report was generated for this date. The member is identified as inside north tower, lift 4, skins C and D at 119M double diaphragm. The weld designations reviewed were NSTL4-3C/L-1, 16, 23, 24, 25, 26, 27, 30, 66, 67, 68, 69, 70. No apparent indications were observed.

This QA Inspector performed random VT and then MT of approximately 15% of the tack welds of the welds noted below. This inspection was performed on an informational basis and no TL-6028 report was generated for this date. The member is identified as inside north tower, lift 4, skins C and D at 116M single diaphragm. The weld designations reviewed were NSTL4-3C/L-8, 9, 18, 19, 24, 25, 26, 27, 28, 29, 30, 55, 56, 57, 59. No apparent indications were observed.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No significant conversations.

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, 150-0042-2360, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet,George	Quality Assurance Inspector
Reviewed By:	Dawson,Paul	QA Reviewer
