

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-012532**Date Inspected:** 16-Feb-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, China**CWI Name:** Mr. You Qi Guo**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, Nagalingam Pandaram Pillai was present during the times noted above for observations relative to the work being performed.

IN PROCESS INSPECTION:-

TOWER TRAIL ASSEMBLY AREA:-

EAST SHAFT LIFT 1:-

This QA inspector observed the following work in progress:

FCAW welding of weld joint no: ESD1-SA233-5 located on Skin B Interior Bearing Plate. Welder is identified as 066674. ZPMC CWI is identified as Mr. You Qi Guo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

This QA inspector observed the following work in progress:

FCAW welding of weld joint no: ESD1-SA294F/G-15 located on Skin C Interior Bearing Plate. Welder is identified as 040736. ZPMC CWI is identified as Mr. You Qi Guo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F. Please see the attached picture below.

NORTH SHAFT LIFT 1:-

This QA inspector observed the following work in progress:

WELDING INSPECTION REPORT

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ZPMC performed Weld metal repair of Interior Bearing Plate located on Skin E (NSD1-SA76F/H-12, 14, 16). The weld metal repair areas were approximately 2mm depth and 50mm length at 2 random locations. The material is A709M Grade 345 Non-SPCM. Welder is identified as 040270.ZPMC CWI is identified as Mr. You Qi Guo. SMAW welding was been performed. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F)-Repair. Please see the attached picture below.

EAST SHAFT LIFTS 1&2:-

This QA inspector carried out the dimension measurements of Gap and misalignment of Interior splice plates between East tower Lift 1 and Lift 2 from inside. The same was measured from Top and bottom side of interior splice plates over the Longitudinal stiffeners of Skin A, B, C, D and E. The maximum Gap between stiffener to Interior splice plate on both top and bottom found to be 9.8mm and the minimum found to be 0mm. The maximum misalignment between stiffener to Interior splice plate on both top and bottom found to be 7 mm and the minimum found to be 0.5 mm. The readings are recorded on the data sheet and submitted to the Lead Inspector.

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



Summary of Conversations:

No Relevant Conversation.

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:	Pillai,Pandaram	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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