

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-013658**Date Inspected:** 07-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:** 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.

Caltrans QA inspector observed twenty ZPMC workers in process of assembling the struts connected to east, south, west and north tower #1 with high strength bolts. The struts located at elevation 47.6m and 18m of tower lift #1. During observation, Caltrans QA inspector have discovered few bolting installation issues for the struts need to be correct before install the east tower lift #2. Caltrans QA informed to ABF QC on site and QC also ABF QC informed to ABF office.

The following is the bolts issues:

1. ZPMC installed only 50% bolts instead of 100% bolts on each strut which connected at elevation 47.6m and 18m.
2. A lot of short bolts have been installed into struts; some of bolt appeared not long enough drove all the way into the nut end.
3. Some of bolt appeared one rotates thread is over the nut end after drove through the nut.
4. Some of bolt has over size length.
5. Some of bolts installed without washer.
6. A lot of strut secured by various type bolts on one area, the ID such as SFC88, NL109, and S601 etc.
7. Some of high strength bolts is used bolts.
8. Some of high strength bolt visually can't be identifying.

CLOSING STATEMENT

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

WELDING INSPECTION REPORT

(Continued Page 2 of 3)



The bolts over length



One connecting area has various type bolts



The bolts over size length



short bolts installed to strut



install 50bolts in stead of 100



short bolts

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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