

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-013681**Date Inspected:** 16-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1800**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.

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-SA4-68-135M-6-1B, ED1-SA4-68-135M-5-1B and ED1-SA4-68-135M-4-1B. The SAW process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

Caltrans QA inspector observed six ZPMC workers in process of temporary bolting to the struts and 90 degree angle plates which connected to tower skin plate A, B, C, D and E. The struts located at elevation 18m of north, south, east and west tower lift #1. The ZPMC will install only 25% bolts on each strut. During observation, some of temporary bolts do not have properly length after installed into the struts and 90 degree angle plates. This issue has been discovered by Caltrans QA inspector on Feb-7-10. Also, Caltrans found some of strut installed on 18m that has rust on the surface require to re-sand blast and re- print. The struts for elevation 18m have been completed installing and 25% temporary bolting.

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.

WELDING INSPECTION REPORT

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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
