

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-013759**Date Inspected:** 01-Mar-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.

Tower assembly dock

Caltrans QA inspector observed twenty ZPMC workers in process of temporary bolting and holes drilling 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 23m thru 43m 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. The elevation 23m thru 43m have not been completed 25% temporary bolting. It'll be schedule continue tomorrow.

West tower lift #1 bearing stiffeners: - Caltrans QA Inspector observed four ZPMC welders in process FCAW process on exterior bearing stiffeners for skin B and C of south tower lift #1. The weld is designed PJP weld use ZPMC joint detail WT10 with welded in 3G position. The bearing stiffeners weld joint has been pre heat prior welding. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

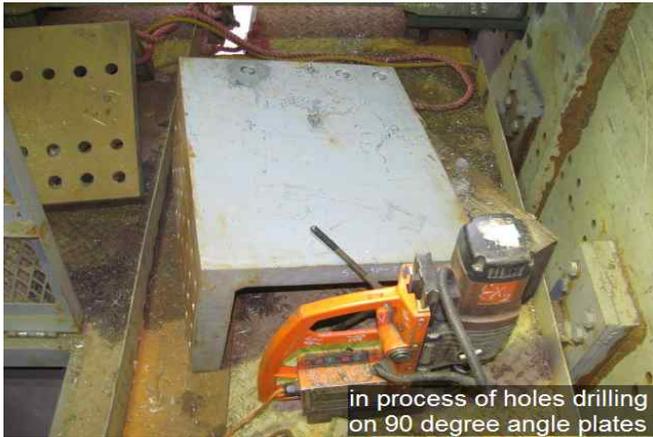
South tower lift #1 bearing stiffeners: - Caltrans QA Inspector observed three ZPMC welders in process FCAW process on exterior bearing stiffeners for skin A, B and C of south tower lift #1. The weld is designed PJP weld use ZPMC joint detail WT10 with welded in 3G position. The bearing stiffeners weld joint has been pre heat prior welding. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

CLOSING STATEMENT

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

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
