

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-014081**Date Inspected:** 08-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.

Caltrans QA inspector observed fifteen 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. The elevation 23m thru 43m have not been completed 25% temporary bolting. It'll be schedule continue tomorrow. Based on Caltrans QAI observations, no discrepancies were noted.

Caltrans QA inspector observed twenty ZPMC workers in process of temporary bolting to the interior skin connection plates which connected to skin plate A, B, C, D and E of north, south, east and west tower lift #1 and lift #2. The ZPMC will install only 50% bolts on each skin connection plate. The temporary bolting of interior skin connection plates have not been completed will be schedule continue tomorrow.

South tower lift #1 bearing stiffeners: - Caltrans QA Inspector observed six ZPMC welders in process FCAW process on 2nd stage exterior bearing stiffeners for skin C of south tower lift #1. The welds ID are SSD1-SA17-F/G-78/68/56/42//38/10. The material used for the 2nd stage exterior bearing stiffeners was reported by ZPMC QC as ASTM a 709M-345 plate with 60mm wall thickness. 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.

East tower lift #1 bearing stiffeners: - Caltrans QA Inspector observed two ZPMC welders in process FCAW process on 2nd stage exterior bearing stiffeners for skin A and D of east tower lift #1. The welds ID are ESD1-SA237 D/F-9/16. The material used for the 2nd stage exterior bearing stiffeners was reported by ZPMC QC

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as ASTM a 709M-345 plate with 60mm wall thickness. 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.

West tower lift #1 bearing stiffeners: - Caltrans QA Inspector observed a ZPMC welder in process FCAW repair process on 1st stage exterior bearing stiffeners for skin C of west tower lift #1. The welds ID are WSD1-5A294 F/G-53-19/40. The material used for the 1st stage exterior bearing stiffeners was reported by ZPMC QC as ASTM a 709M-345 plate with 60mm wall thickness. The bearing stiffeners repair 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

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.



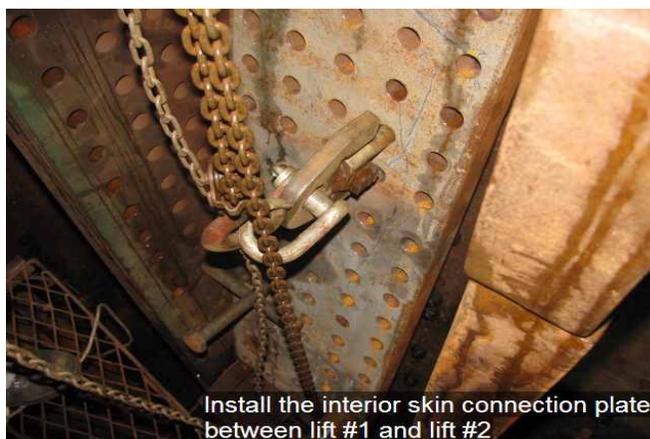
FCAW in process on 2nd stage exterior bearing stiffeners of south tower lift #1



pre heat in process on 2nd stage exterior bearing stiffeners



The interior skin connection plate has been installed and 50 temporary bolting



Install the interior skin connection plate between lift #1 and lift #2

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.

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Inspected By:	Pau, Wai	Quality Assurance Inspector
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Reviewed By:	Clifford, William	QA Reviewer
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