

**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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019702**Date Inspected:** 06-Jan-2011**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

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	TOWER & OBG Components	

**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

**BAY#10**

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 08064

**Visual Inspection Testing (VT)**

This QA inspector performed VT of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as OBG Component. The identified component designations reviewed are as follows:

**OBG BIKE PATH**

BK004A3 – 033 – 065, 067~071, 100~105

BK004A4 – 033 – 080, 082, 083, 085~087, 100~105

**BAY#11**

This QA Inspector observed the following work not in compliance:

**Description of Incident:**

During the Caltrans Quality Assurance (QA) in-process observation on lift-5 grillage of West, South, East and North shafts, this QA Inspector discovered the following issue:

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- ZPMC applied final coat Interfine 979 on faying surface of the following locations, which is non-compliant as per the approved contract documents.

1. West tower, skin 'C' – approximately 1258 mm painted from B/C corner.
  2. South tower, skin 'D' – approximately 1075 mm painted from C/D corner.
  3. East tower, skin 'D' – approximately 1075 mm painted from C/D corner.
  4. North tower, skin 'C' – approximately 1210 mm painted from C/D corner.
- These members are Non-Seismic Performance Critical Member's (SPCM).
  - These components are located at fabrication Bay#11.

Applicable reference:

Special Provisions, Section 10-1.71 - Painting: "Unless otherwise specified, all coatings used on faying surfaces shall meet the slip coefficient requirements for a Class B coating on blast-cleaned steel, as specified in the RCSC Specification."

Approved shop drawings: ESD1-FCSA5-2; ESD1-FDSA5-2

For further information, please see the attached pictures below.

This QA Inspector observed the following work not in compliance:

Description of Incident:

During the Caltrans Quality Assurance (QA) in-process observation on lift-5 grillage diaphragms (I-beams), this QA Inspector discovered the following issue:

- Bent plate on Grillage diaphragm has been bent, deviation measured approximately 35 mm over 40 mm length.
- Grillage diaphragm (I-beam) identified as WD1-BPSA5-7-N4.
- Bent plate identified as N4-2.
- This component located at fabrication Bay#11.

Applicable reference:

Caltrans Standard Specifications: Section 55-1.04; "In handling and shipping of the steel work, every care shall be taken to avoid bending, scraping or overstressing the pieces. All pieces bent or otherwise injured will be rejected".

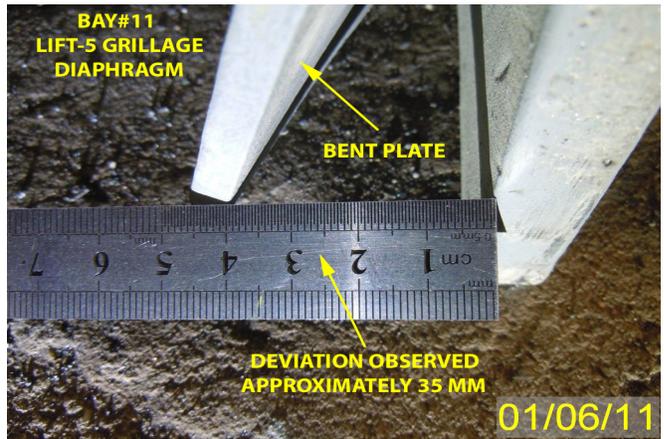
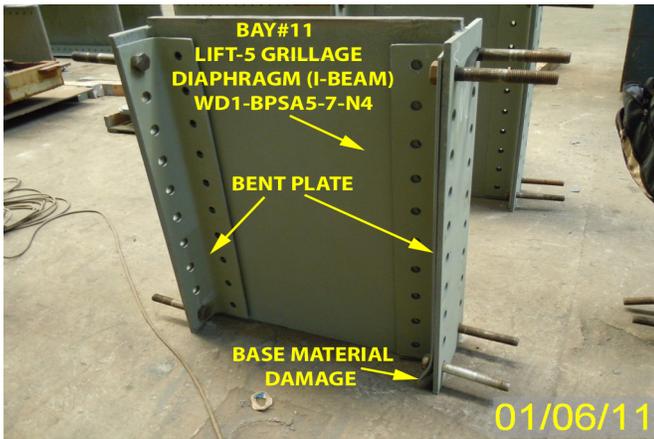
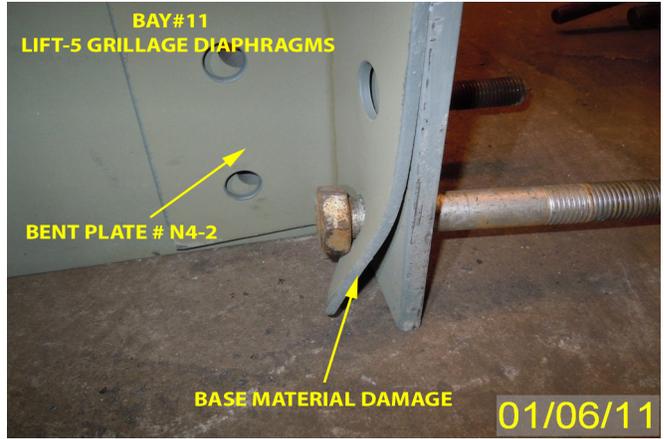
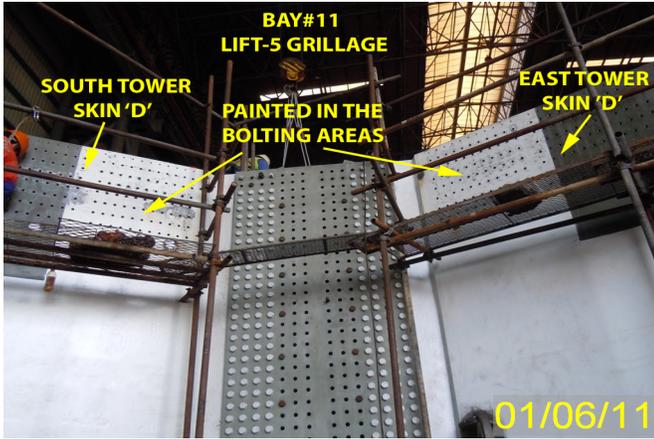
Caltrans Standard Specifications: Section 55-3.09; "Finished members shall be true to line and free from twists, bends and open joints".

For further information, please see the attached pictures below.

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

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## Summary of Conversations:

No Relevant Conversations.

## 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 Thomas Ho- 15002048250, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Sandeep	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer