

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-006733**Date Inspected:** 04-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Tu Jun, Liu Zhong An**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 and OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 5

This QA Inspector, George Goulet, proceeded to Bay 5 in response to a ZPMC notification of witness inspection #2927 for MT inspection as follows:

This QA Inspector, George Goulet, performed VT of 100% of the area previously tested and accepted by ZPMC Quality Control personnel. The four members were identified as CTS7-A, B, C, D.

This QA Inspector, George Goulet, performed VT of 100% of the area previously tested and accepted by ZPMC Quality Control personnel. The four members were identified as CTS8-A-A, B and CTS8-B-A, B.

Bay 10

This QA Inspector, George Goulet, randomly observed the following work in progress in Bay 10:

SAW welding of weld joint ESD1-A167B/H-3B located on PCMK east tower, SA7-P280/P281. Welder was identified as 050295. ZPMC QC was identified as Tu Jun (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Yuan Hai Gong, who was not a CWI. The welding variables recorded by QC1 and his assistant appeared to comply with WPS-B-T-2221-B-U3c-S-2.

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FCAW welding of weld joints SSD1-TL5J/L-57, 58 located on PCMK south tower, lift 2, skins C/D, between diaphragms 62M and 65M. Welder was identified as 057180. ZPMC QC was identified as Liu Zhong An (QC2). The welding variables recorded by QC2 appeared to comply with WPS-B-T-2331-Tc-P4-F. Also at this location and appearing to be monitoring the welding and recording data was ABF Representative Yang Yi Heng (ABF1).

FCAW welding of weld joints SSD1-TL5J/L-55, 56 located on PCMK south tower, lift 2, skins B/C, between diaphragms 59M and 62M. Welder was identified as 201825. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2331-Tc-P4-F. Also at this location and appearing to be monitoring the welding and recording data was ABF1.

FCAW welding of weld joints SSD1-TL5J/L-55, 56 located on PCMK south tower, lift 2, skins B/C, between diaphragms 53M and 56M. Welder was identified as 053869. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2331-Tc-P4-F. Also at this location and appearing to be monitoring the welding and recording data was ABF1.

Bay 11

This QA Inspector, George Goulet, randomly observed the following work in progress in Bay 11:

FCAW welding of weld joints WSD1-FASA3-2E/E-29A, 25A, 4A located on PCMK west tower, lift 3, skin A. The section was mounted on an A-frame with the welds in the flat position. Welders were identified respectively as 053316, 040775, 040723. ZPMC QC was identified as You Qi Guo (QC3). The welding variables recorded by QC3 appeared to comply with WPS-B-T-2232-Tc-U5-F. Also at this location and appearing to be monitoring the welding and recording data was ABF Representative Jiang Zi Wen.

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

Summary of Conversations:

As noted above, and this QA Inspector, George Goulet, asked each QC if all the welding variables observed by him appeared to comply with the appropriate WPS, including the preheat requirements according to thickness of the thickest member being welded. Each QC showed this QA Inspector, George Goulet, that he was carrying the proper temperature sticks to monitor the minimum and maximum preheat and interpass temperatures and replied that all he observed did appear to comply.

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 Eric Tsang, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
