

**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-006735**Date Inspected:** 06-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

<b>CWI Name:</b>	Tu Jun			<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 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 10

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

SAW welding of weld joint NSD1-A112B/H-49A located on PCMK north tower, SA6-P386/P387. Welder was identified as 209051. ZPMC QC was identified as CWI 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.

SAW welding of weld joint NSD1-A112B/H-68A located on PCMK north tower, SA6-P386/P387. Welder was identified as 207745. ZPMC QC was identified as 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.

FCAW welding, using the northwest gantry, of weld joints NSD1-FASA3-1E/E-55, 54 located on PCMK north tower, lift 3, skin A. Welders were identified respectively as 048784, 040345. ZPMC QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Zong Yi, who was not a CWI. The welding variables recorded by QC1 appeared to comply with

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## WELDING INSPECTION REPORT

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WPS-B-T-2332-Tc-P5-F.

Fitting and SMAW tack welding of weld joints NSD1-FESA3-1B/D-4A, 4B located on PCMK north tower, lift 3, skin E. Welders were identified respectively as 250252, 040475. ZPMC QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Lu Wei Chan, who was not a CWI. The welding variables recorded by QC1 appeared to comply with WPS-B-P-2212-Tc-U5b.

FCAW welding, using the northwest gantry, of weld joints NSD1-FASA3-1E/E-26, 27, 58, 59 located on PCMK north tower, lift 3, skin A. Welders were identified respectively as 040330, 053869, 040345, 048784. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2332-Tc-P5-F.

### Summary of Conversations:

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

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<b>Inspected By:</b>	Goulet,George	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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