

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-006741**Date Inspected:** 13-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			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 #3070 for MT inspection as follows:

This QA Inspector, George Goulet, performed random VT of the area previously tested and accepted by ZPMC Quality Control personnel. The twelve members were identified as CTS1E1-A3, A4, B3, B4, E3, E4, F3, F4, G3, G4, H3, H4.

This QA Inspector, George Goulet, observed and marked numerous areas of weld overlap and incomplete fusion on each of the above noted parts. This QA Inspector, George Goulet, informed the ZPMC shop foreman, ZPMC CWI Li Yang, and ZPMC QA Wang Lu that this QA Inspector, George Goulet, was rejecting the acceptability of the welding work for the above noted reasons.

Bay 10

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

SMAW welding of the runoff plates on weld joint SSD1-FCSA4-1A/C-61A located on PCMK south tower, lift 4, skin C. Welder was identified as 040475. 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 Lu Wei Chao, who was not a CWI. The welding variables recorded by QC1 and his assistant appeared to comply with

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WPS-B-P-2211-B-U3b.

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
