

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-007188**Date Inspected:** 25-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:** Wan Wen Zhong, Li Ming**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.

Trial Assembly Area

This QA Inspector, George Goulet, randomly observed the following in CB3 at the center connection to 4BE: Numerous arc strikes near the lap plates which had been tacked into place for match drilling. This QA Inspector, George Goulet, marked the arc strikes with soap stone.

Bay 10

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

FCAW welding of weld joint NSD1-FCSA3-1B/C-60A located on PCMK north tower, lift 3, skin C. Welder was identified as 408378. ZPMC QC was identified as CWI Wan Wen Zhong (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Wang Hao, who was not a CWI. The welding variables recorded by QC1 and his assistant appeared to comply with WPS-B-T-2232-Tc-U5-F. Also at this location and appearing to be monitoring the welding was ABF Representative Yang Ye Heng.

FCAW welding of weld joint NSD1-FCSA3-1B/C-54B located on PCMK north tower, lift 3, skin C. Welder was identified as 048784. ZPMC QC was identified as CWI Wan Wen Zhong (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Wang Hao, who was not

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a CWI. The welding variables recorded by QC1 and his assistant appeared to comply with WPS-B-T-2232-Tc-U5-F. Also at this location and appearing to be monitoring the welding was ABF Representative Yang Ye Heng.

FCAW welding of weld joints NSD1-FCSA3-1B/C-51, 52 located on PCMK north tower, lift 3, skin C. Welders were identified respectively as 201825, 203997. ZPMC QC was identified as CWI Wan Wen Zhong (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Wang Hao, who was not a CWI. The welding variables recorded by QC1 and his assistant appeared to comply with WPS-B-T-2232-Tc-U5-F. Also at this location and appearing to be monitoring the welding was ABF Representative Yang Ye Heng.

SAW welding of weld joints SSD1-FCSA4-1A/C-52B(2), 71, 49B located on PCMK south tower, lift 4, skin C. 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 Yu Zhi Lai. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2221-B-U3c-S-2 for the CJP welds and WPS-B-T-2321-B-P3-S-2 for the PJP weld.

SAW welding of weld joint SSD1-FCSA4-1A/C-46 located on PCMK south tower, lift 4, skin C. Welder was identified as 207746. 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 Yu Zhi Lai. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2321-B-P3-S-2.

SAW welding of weld joints SSD1-FCSA4-1A/C-56B(1), 77, 59B located on PCMK south tower, lift 4, skin C. Welder was identified as 050295. 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 Yu Zhi Lai. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2221-B-U3c-S-2 for the CJP welds and WPS-B-T-2321-B-P3-S-2 for the PJP weld.

SAW welding of weld joints SSD1-FCSA4-1A/C-81, 63B, 85, 68B located on PCMK south tower, lift 4, skin C. Welder was identified as 051413. 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 Yu Zhi Lai. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2221-B-U3c-S-2 for the CJP welds and WPS-B-T-2321-B-P3-S-2 for the PJP weld.

FCAW welding of weld joint NSD1-TL8B/L-5B located on PCMK north tower shaft interior, lift 2, skins D to E, between diaphragms 59M and 62M. Welder was identified as 040533. ZPMC QC was identified as CWI Li Ming (QC2). The welding variables recorded by QC1 appeared to comply with WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint NSD1-TL8B/L-4B located on PCMK north tower shaft interior, lift 2, skins C to D, between diaphragms 59M and 62M. Welder was identified as 040338. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint NSD1-TL8B/L-5B located on PCMK north tower shaft interior, lift 2, skins D to E, between diaphragms 62M and 65M. Welder was identified as 054069. ZPMC QC was identified as QC2. The

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welding variables recorded by QC2 appeared to comply with WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint NSD1-TL8B/L-4B located on PCMK north tower shaft interior, lift 2, skins C to D, between diaphragms 71M and 74M. Welder was identified as 040261. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint NSD1-TL8B/L-4B located on PCMK north tower shaft interior, lift 2, skins C to D, between diaphragms 65M and 68M. Welder was identified as 050041. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint NSD1-TL8B/L-4B located on PCMK north tower shaft interior, lift 2, skins C to D, between diaphragms 53M and 56M. Welder was identified as 05207540338. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2232-Tc-U4b-F.

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 Serge Sinevod, 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
