

**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-008260**Date Inspected:** 18-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Guo Yan Fei, Cui Jun Jie, Xu Xia			<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 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 9**

This QA Inspector, George Goulet, randomly observed the following work in progress in Bay 9:

FCAW welding of weld joint DP3006-001-022. Welder was identified as 201250. ZPMC QC was identified as CWI Guo Yan Fei (QC1). The welding variables recorded by QC1 appeared to comply with WPS-B-T-2232-B-U2-F.

**Bay 7**

This QA Inspector, George Goulet, randomly observed the following work in progress in Bay 7:

FCAW welding of weld joint SP3016-001-016. Welder was identified as 048625. ZPMC QC was identified as CWI Cui Jun Jie (QC2). The welding variables recorded by QC2 appeared to comply with WPS-B-T-2231-B-U2-F.

FCAW welding of weld joint SP3016-001-067. Welder was identified as 053609. ZPMC QC was identified as CWI Xu Jian Ping (QC3). The welding variables recorded by QC3 appeared to comply with WPS-B-T-2233-B-U2-F.

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# WELDING INSPECTION REPORT

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## Bay 6

This QA Inspector, George Goulet, randomly observed the following work in progress in Bay 6:

SMAW welding of weld joints WD1-A305-65M-3-27, 23, 26, 22 located on PCMK west tower. Welders were identified respectively as 037932, 037780, 068091, 066456. ZPMC QC was identified as CWI Zou Liu Hai (QC4).

The welding variables recorded by QC4 appeared to comply with WPS-B-T-3212-Tc-U5b-1.

## OBG Trial Assembly Area

This QA Inspector, George Goulet, randomly observed the following work in progress in the trial assembly area:

3AE, panel point 20 – sandblasting at upper floor beam area.

4AE, Panel point 24~25 – tightening with torque wrench the temporary bracing.

3AW, panel point 19 – ZPMC workers installing floor beam to bottom plate bolt sets.

3AW~3BW joint - ZPMC workers tightening with torque wrench U-rib bolt sets.

1AAW/1AW joint – fitting up the mating surfaces using hydraulic jacks and turnbuckles.

4BW/FL3, panel point 28 – plug welding of extreme outer bolt hole in the top four transverse ribs.

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

### Summary of Conversations:

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

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