

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-008267**Date Inspected:** 02-Aug-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

CWI Name:	Li Lin, Yu Dong Ping, Guo Peng			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 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 11

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

SAW welding of weld joints WD1-A504A/C-185A located on PCMK west tower. Welder was identified as 040699. ZPMC QC was identified as CWI Li Lin (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Mao Bin Bin, who was not a CWI. The welding variables recorded by QC1 and QC1's assistant appeared to comply with WPS-B-T-2221-B-L2c-S-2.

SMAW welding of weld joint WSD1-FCSA4-2C/C-28A, 14B located on west tower, lift 4, skin C. Welders were identified as 050611, 053916. 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 Fu Wei Min, who was not a CWI. The welding variables recorded by QC1 and QC1's assistant appeared to comply with WPS-B-P-3212-Tc-U5b-2.

SAW welding of weld joints SD1-A5002-13-1A, 14-1A, 15-1A, 16-1A located on PCMK south tower. Welder was identified as 041716. ZPMC QC was identified as CWI Yu Dong Ping (QC2). Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Chen Hong Yun, who was not a CWI. The welding variables recorded by QC2 and QC2's assistant appeared to comply with WPS-B-T-3221-Tc-U5-S-1.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

FCAW welding, using northeast gantry, of weld joint WSD1-FDSA4-2D/D-5, 6 located on west tower, lift 4, skin D. Welders were identified respectively as 070212, 070140. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2332-Tc-P5-F.

FCAW welding, using northwest gantry, of weld joint WSD1-FDSA4-4D/D-16, 17 located on west tower, lift 4, skin D. Welders were identified respectively as 067184, 068206. ZPMC QC was identified as CWI Guo Peng (QC3). The welding variables recorded by QC3 appeared to comply with WPS-B-T-2332-Tc-P5-F.

SAW welding of weld joints WD1-A5007-13-1A, 14-1A, 15-1A, 16-1A located on PCMK west tower. Welder was identified as 047304. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Chen Hong Yun, who was not a CWI. The welding variables recorded by QC2 and QC2's assistant appeared to comply with WPS-B-T-3221-Tc-U5-S-1.

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 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
