

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-008269**Date Inspected:** 04-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**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 10

This QA Inspector, George Goulet, proceeded to the Bay 11 in response to a ZPMC notification of witness inspection #3861 for MT inspection of the following:

This QA Inspector, George Goulet, performed random VT and then MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector, George Goulet, generated an MT report for this date. The member is identified as NSD1-TL8. The weld designations reviewed are as follows: J/L-30, 31; J/L 57, 58 from the top of diaphragm 65M to top of lift 2; F/L-54, 171, 172; G/L-32, 33, 87, 88; H/L-55, 56, 146, 147.

This QA Inspector, George Goulet, performed random VT only on the following weld designations K/L-46~58. The MT inspection on these welds was cancelled by ZPMC CWI Wang Chuan Qing.

Bay 11

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

SMAW tack welding of weld joint SD1-A5002-37-1A, 38-1A located on south tower. Welder was identified as 040669. ZPMC QC was identified as CWI Li Lin (QC1). Assisting QC1 at this location and appearing to be

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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-3211-Tc-U5b-1.

SMAW tack welding of weld joint SD1-A5002-39-1A, 40-1A located on south tower. Welder was identified as 047470. 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 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-3211-Tc-U5b-1.

FCAW welding, using the northwest gantry, of weld joint WSD1-FDSA4-4D/D-16, 17, 33, 34 located on west tower, lift 4, skin D. Welders were identified respectively as 066882, 067184, 066883, 068864. 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 Chen Hong Yun, who was not a CWI. The welding variables recorded by QC1 and QC1's assistant appeared to comply with WPS-B-T-2332-Tc-P5-F.

FCAW welding, using the northeast gantry, of weld joint WSD1-FDSA4-4D/D-38, 39 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.

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 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
