

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-008273**Date Inspected:** 09-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 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.

OBG Trial Assembly Area

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

3AE, panel points 20 to 22, north side – ZPMC QC workers installing 24x2.5x70 ASTM A325M bolt sets with the washer against the bolt head inserted from bottom at the bottom plate/FL3 joint. The bolt set number appeared to be DHGM240003.

1AAE/1AE joint – ZPMC workers, including welders exiting the area of the joint. Fresh welds were obvious and the steel base metal still hot.

Bay 11

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

SAW welding of weld joint WSTL3-4B/K-81B located on PCMK west tower shaft, skins E to A. Welders were identified as 044558, 044560, 044550, 056975, 202756. ZPMC QC was identified as CWI Li Lin (QC1). The welding variables recorded by QC1 appeared to comply with WPS-B-T-2211-C-U2b-S-2.

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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 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. 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
