

**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-008670**Date Inspected:** 19-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, proceeded to the OBG trial assembly area in response to a ZPMC notification of witness inspection #3998 for MT inspection of the following:

This QA Inspector, George Goulet, performed random VT and 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 segment 3BW, SEG015B. The weld designations reviewed were 045, 046.

This QA Inspector, George Goulet, attempted to perform random VT and MT of the member is identified as segment 3BW, SEG015B. The weld designations were 003, 004, 005, 006. However, the weld areas displayed no ZPMC acceptance of the designated welds and the welds were wet with standing water present.

This QA Inspector, George Goulet, attempted to perform random VT and MT of the member is identified as segment 3BW, SEG013B. The weld designations were 046, 047, 044, 045, 065. However, the weld areas displayed no ZPMC acceptance of the designated welds and the welds were wet with standing water present.

This QA Inspector, George Goulet, attempted to perform random VT and MT of the member is identified as

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segment 3BW, LD012-001. The weld designation was 003. However, the weld area displayed no ZPMC acceptance of the designated weld and the weld was wet with standing water present.

Bay 11

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

SMAW welding of weld joint WSD1-FESA4-4C/F-12 located on west tower, lift 4, skin E. Welder was identified as 053224. 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 Cao Cheng, who was not a CWI. The welding variables recorded by QC1 and QC1's assistant appeared to comply with WPS-B-T-4112-Tc-P4. Also at this location and appearing to be monitoring the welding and recording data was ABF Representative You Yuan Mao.

SMAW welding of weld joint WSD1-FESA4-4D/F-5 located on west tower, lift 4, skin E. Welder was identified as 053310. 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 Cao Cheng, who was not a CWI. The welding variables recorded by QC1 and QC1's assistant appeared to comply with WPS-B-T-4112-Tc-P4. Also at this location and appearing to be monitoring the welding and recording data was ABF Representative You Yuan Mao.

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 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.

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

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