

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-009067**Date Inspected:** 07-Sep-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:	Xu Le Feng, Wan Wen Zhong	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 randomly observed the following work in progress in Bay 10:

SMAW welding of weld joints SSD1-FDSA4-1B/C-57, 58 located on south tower, lift 4, skin D, stiffener connection plate. Welder was identified as 040268. ZPMC QC was identified as CWI Xu Le Feng (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Sun Tian Liang, who was not a CWI. The welding variables recorded by QC1 and QC1's assistant appeared to comply with WPS-345+485-SMAW-2G(2F)-repair. Also at this location and appearing to be monitoring the welding and recording data was ABF Representative Li Nan.

SMAW welding of weld joint SSD1-FDSA4-1B/C-35 located on south tower, lift 4, skin D, stiffener connection plate. Welder was identified as 040491. 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 Sun Tian Liang, who was not a CWI. The welding variables recorded by QC1 and QC1's assistant appeared to comply with WPS-345+485-SMAW-2G(2F)-repair. Also at this location and appearing to be monitoring the welding and recording data was ABF Representative Li Nan.

SMAW tack welding of weld joint SSSL4-1B/L-3 located on south tower, lift 4, skins A/E. Welders were

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identified as 052892, 057186. ZPMC QC was identified as CWI Wan Wen Zhong (QC2). Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Jiang Xiao Bo, who was not a CWI. The welding variables recorded by QC2 and QC2's assistant appeared to comply with WPS-B-P-2212-C-U2.

SMAW welding of weld joint SSD1-FDSA4-1B/C-17 located on south tower, lift 4, skin D, stiffener connection plate. Welder was identified as 040491. 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 Yuan Hui Gang, who was not a CWI. The welding variables recorded by QC1 and QC1's assistant appeared to comply with WPS-345+485-SMAW-2G(2F)-repair.

FCAW welding of weld joints SSSL3-1B/K-79, 80 located inside south tower shaft, lift 3, skins B/C between diaphragms 105M and 109M. Welder was identified as 050041. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2332-Tc-P4-F-2 for weld joint 79 and WPS-B-T-2331-Tc-P4-F-2 for weld joint 80.

FCAW welding of weld joints SSSL3-1B/K-79, 80 located inside south tower shaft, lift 3, skins B/C between diaphragms 102M and 105M. Welder was identified as 057180. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2332-Tc-P4-F-2 for weld joint 79 and WPS-B-T-2331-Tc-P4-F-2 for weld joint 80.

FCAW welding of weld joints SSSL3-1B/K-79, 80 located inside south tower shaft, lift 3, skins B/C between diaphragms 99M and 102M. Welder was identified as 203977. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2332-Tc-P4-F-2 for weld joint 79 and WPS-B-T-2331-Tc-P4-F-2 for weld joint 80.

FCAW welding of weld joints SSSL3-1B/K-77, 78 located inside south tower shaft, lift 3, skins C/D between diaphragms 102M and 105M. Welder was identified as 052075. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2332-Tc-P4-F-2 for weld joint 78 and WPS-B-T-2331-Tc-P4-F-2 for weld joint 77.

FCAW welding of weld joints SSSL3-1B/K-77, 78 located inside south tower shaft, lift 3, skins C/D between diaphragms 99M and 102M. Welder was identified as 040338. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2332-Tc-P4-F-2 for weld joint 78 and WPS-B-T-2331-Tc-P4-F-2 for weld joint 77.

FCAW welding of weld joints SSSL3-1B/K-79, 80 located inside south tower shaft, lift 3, skins B/C between diaphragms 89M and 92.5M. Welder was identified as 040343. 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 Li Peng Fei, who was not a CWI. The welding variables recorded by QC2 and QC2's assistant appeared to comply with WPS-B-T-2332-Tc-P4-F-2 for weld joint 79 and WPS-B-T-2331-Tc-P4-F-2 for weld joint 80.

FCAW welding of weld joints SSSL3-1B/K-79, 80 located inside south tower shaft, lift 3, skins B/C below diaphragm 85M. Welder was identified as 053869. ZPMC QC was identified as QC2. Assisting QC2 at this

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location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Li Peng Fei, who was not a CWI. The welding variables recorded by QC2 and QC2's assistant appeared to comply with WPS-B-T-2332-Tc-P4-F-2 for weld joint 79 and WPS-B-T-2331-Tc-P4-F-2 for weld joint 80.

FCAW welding of weld joints SSTL3-1B/K-77, 78 located inside south tower shaft, lift 3, skins C/D below diaphragm 85M. Welder was identified as 040533. 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 Li Peng Fei, who was not a CWI. The welding variables recorded by QC2 and QC2's assistant appeared to comply with WPS-B-T-2332-Tc-P4-F-2 for weld joint 78 and WPS-B-T-2331-Tc-P4-F-2 for weld joint 77.

FCAW welding of weld joints SSTL3-1B/K-77, 78 located inside south tower shaft, lift 3, skins C/D below diaphragm 85M. Welder was identified as 057244. 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 Li Peng Fei, who was not a CWI. The welding variables recorded by QC2 and QC2's assistant appeared to comply with WPS-B-T-2332-Tc-P4-F-2 for weld joint 78 and WPS-B-T-2331-Tc-P4-F-2 for weld joint 77.

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

Summary of Conversations:

No relevant conversations on this date.

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
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Reviewed By:	Carreon,Albert	QA Reviewer
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