

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-009177**Date Inspected:** 12-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

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|------------------------------------|---|----|-----|----------------------------------|--------------------------|----|-----|
| CWI Name: | Wan Wen Zhong, Li Hong Fei, Guo Wen Fei | | | 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: | OBG and Tower Components | | |

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance 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 joint ND1-FDSA4-1B/C-5 located on north tower, lift 4, skin D, stiffener connection plate. Welder was identified as 040268. ZPMC QC was identified as CWI Wan Wen Zhong (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(3F)-repair.

SMAW welding of weld joint SSSL3-1B/K-80 located on south tower, lift 3, skins B/C at 85.25M. Welder was identified as 040582. 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 Li Peng Fei, who was not a CWI. The welding variables recorded by QC1 and QC1's assistant appeared to comply with WPS-345-SMAW-2G(3F)-repair-1.

FCAW welding of weld joints SSSL3-1C/K-98, 99 located on south tower, lift 3, skins B/C, inside 89M diaphragm. Welder was identified as 050041. 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 Li Peng Fei, who was not

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a CWI. The welding variables recorded by QC1 and QC1's assistant appeared to comply with WPS-B-T-2231-B-U2a-F-1.

FCAW welding of weld joints NSD1-FESA4-3B/F-7 located on north tower, lift 4, skin E. Welders were identified as 052075, 040338. 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 Jiang Xiao Bo, who was not a CWI. The welding variables recorded by QC1 and QC1's assistant appeared to comply with WPS-B-T-4332-Tc-P5-F-1.

FCAW welding of weld joints NSD1-FESA4-3C/F-3 located on north tower, lift 4, skin E. Welders were identified as 057244, 057180. 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 Jiang Xiao Bo, who was not a CWI. The welding variables recorded by QC1 and QC1's assistant appeared to comply with WPS-B-T-4332-Tc-P5-F-1.

FCAW welding of weld joints NSD1-FESA4-3D/F-3 located on north tower, lift 4, skin E. Welders were identified as 053869, 040533. 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 Jiang Xiao Bo, who was not a CWI. The welding variables recorded by QC1 and QC1's assistant appeared to comply with WPS-B-T-4332-Tc-P5-F-1.

Bay 11

This QA inspector randomly observed the following work in progress in Bay 11:

SMAW welding of weld joint ESTL4-2B/L-59B located on east tower, lift 4, skins A/B. Welders were identified as 202323, 040733. ZPMC QC was identified as CWI Li Hong Fei (QC2). Assisting QC2 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 QC2 and QC2's assistant appeared to comply with WPS-B-P-2214-Tc-P4. Also at this location and appearing to be monitoring the welding and recording data was ABF Representative Samuel Chen.

Bay 9 – PMT

This QA inspector went to Bay 9 to monitor the scheduled OBG Production Monitoring Test (PMT) for deck panels. ZPMC CWI Guo Yan Fei and ABF Representative Huang Wen Guang informed this QA inspector that no PMT would be performed on this date because the test panel had not had the tack welds MT tested and approved by ZPMC.

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 except as noted above.

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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| Inspected By: | Goulet, George | Quality Assurance Inspector |
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| Reviewed By: | Carreon, Albert | QA Reviewer |
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