

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-009182**Date Inspected:** 18-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:	Li Hong Fei, Ma Yun, Liu 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 Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 11

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

Heat straightening of SP3-19, SPSA3-53, SP3-25 at weld designations 1A, 1B, 2A, 2B. ZPMC QC was identified as CWI Li Hong Fei (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Fu Wei Min, who was not a CWI. The heat straightening work appeared to comply with HSR1(T)-10216.

Bay 10

This QA inspector randomly observed the following work in progress in Bay 10:

SMAW welding of weld joints ED1-A6001-1-8A, 12A located on a tower strut. Welder was identified as 050289. ZPMC QC was identified as CWI Ma Yun (QC2). Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Liu Shi You, who was not a CWI. The welding variables recorded by QC2 and QC2's assistant appeared to comply with WPS-B-T-3212-TC-U5b-1.

SMAW welding of weld joints ED1-A6001-1-10B, 12A located on a tower strut. Welder was identified as 057258. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding

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and recording data was ZPMC QC Inspector Liu Shi You, who was not a CWI. The welding variables recorded by QC2 and QC2's assistant appeared to comply with WPS-B-T-3212-TC-U5b-1.

SMAW tack welding of weld joint SSSL4-1B/L-5A located on south tower, lift 4, skins B to C at midpoint on the lift. Welders were identified as 040256, 040453. ZPMC QC was identified as CWI Liu Zhong An (QC2). Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Wang Hao, who was not a CWI. The welding variables recorded by QC2 and QC2's assistant appeared to comply with WPS-B-P-2214-C-U2.

SMAW repair welding of weld joint SSSL4-1B/L-2A located inside south tower shaft, lift 4, skin D. Welders were identified as 056364, 040581, 053829. ZPMC QC was identified as CWI Li Ming (QC3). The welding variables recorded by QC2 appeared to comply with WPS-345-SMAW-2G(2F)-repair.

FCAW repair welding of weld joint NSTL3-3B/K-83B located on north tower shaft, lift 3, skins A/B. Welders were identified as 040343, 040533. ZPMC QC was identified as QC3. Assisting QC3 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Shi Jing Wei, who was not a CWI. The welding variables recorded by QC3 and QC3's assistant appeared to comply with WPS-345-FCAW-2G(2F)-repair.

SMAW welding of various surface repairs located inside north tower shaft, lift 3, skin B, between diaphragms 99M and 102.5M. Welders were identified as 057266, 056364. ZPMC QC was identified as QC3. The welding variables recorded by QC2 appeared to comply with WPS-345-SMAW-2G(2F)-repair. Also at this location and appearing to be monitoring the welding and recording data was ABF Representative Zhang Qin Jian.

Summary of Conversations:

No relevant conversations 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.

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