

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-009183**Date Inspected:** 20-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:	Ma Yun, Liu Zhong An, Guo Yan			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 randomly observed the following work in progress in the trial assembly area:

5AE, panel point 29, south lower chevron – ZPMC workers removing bolt sets from the connection between the lower chevron and plate. These bolts appeared to be without turn-of-nut markings.

4BW, panel points 27~28 spray painting deck panel area (inside the segment)

4BW, panel points 25~28, floor beams - sanding and brush painting

5CE, panel point 36, north and south longitudinal diaphragms and floor beams – grinding cope holes

3AW, panel points 20~21, north corner assembly - spray painting deck panel area

1E – ZPMC workers appeared to be rigging 5 Goldhofer lift vehicles under the segment.

1AAW/1AW, top of deck joint – 24 excavations between 100mm and 200mm long and up to 20mm deep. No work currently being performed in this area.

WELDING INSPECTION REPORT

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Bay 10

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

FCAW welding of weld joint NSTL3-3B/K-82A located inside north tower shaft, lift 3, skins B/C. Welder was identified as 040343. ZPMC QC was identified as CWI Ma Yun (QC1). The welding variables recorded by QC1 appeared to comply with WPS-345-FCAW-2G(2F)-repair.

FCAW welding of weld joint NSD1-SPSA3-56-3A located on north tower, lift 3 splice plate. Welder was identified as 040533. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2231-TC-U5-F.

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
Reviewed By:	Carreon,Albert	QA Reviewer
