

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-009559**Date Inspected:** 05-Oct-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:** See below**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:

FCAW welding of lifting eyes to various 60mm A709M-345-T2-Z25 plates, not all with legible numbers. Some numbers observed were P176, P169, P409, P1144, WD1-A597-P1963. Welder was identified as 0406704. ZPMC QC was identified as CWI Yo Qi Guo (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Li Jun, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-P-2112. Also at this location and appearing to be monitoring the welding and recording data was ABF Representative Xie Yan.

FCAW welding of weld joint WD1-A597B/C-5-7, 11, 3 located on PCMK west tower, skirt beam. Welder was identified as 049220. ZPMC QC was identified as CWI Li Lin (QC2). The welding variables recorded by QC2 appeared to comply with WPS-B-T-2332-TC-P4-F.

SMAW welding of weld joint WSTL3-2B/K-81A located outside PCMK west tower, lift 3, skin A to skin E. Welder was identified as 058009. 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 Cao Cheng, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-345-SMAW-2G(2F)-repair.

WELDING INSPECTION REPORT

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Bay 10

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

SMAW welding of weld joint SSTL4-1B/L-5A located outside of PCMK south tower, lift 4, skin B to skin C, at approximately 121M elevation. Welder was identified as 056200. ZPMC QC was identified as CWI Tu Jun (QC3). Assisting QC3 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 QC3 and QC3's assistant appeared to comply with WPS-345-SMAW-4G(4F)-repair.

FCAW welding of weld joints NSTL3-3B/K-80, 79 located inside PCMK north tower, lift 3, skin B to skin C angle stiffener between 102.5M diaphragm and 105.5M diaphragm. Welder was identified as 053116. ZPMC QC was identified as QC3. The welding variables recorded by QC3 appeared to comply with WPS-B-T-2331-TC-P4-F-2 on weld #80 and WPS-B-T-2332-TC-P4-F-2 on weld #79.

FCAW welding of weld joints NSTL3-3B/K-77, 78 located inside PCMK north tower, lift 3, skin C to skin D angle stiffener between 109 M diaphragm and 111.67M diaphragm. Welder was identified as 057180. ZPMC QC was identified as QC3. The welding variables recorded by QC3 appeared to comply with WPS-B-T-2331-TC-P4-F-2 on weld #77 and WPS-B-T-2332-TC-P4-F-2 on weld #78.

FCAW welding of weld joints NSTL3-3B/K-77, 78 located inside PCMK north tower, lift 3, skin C to skin D angle stiffener inside 89.5M diaphragm. Welder was identified as 054069. ZPMC QC was identified as QC3. The welding variables recorded by QC3 appeared to comply with WPS-B-T-2331-TC-P4-F-2 on weld #77 and WPS-B-T-2332-TC-P4-F-2 on weld #78.

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

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:	Dawson,Paul	QA Reviewer
