

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-009560**Date Inspected:** 07-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 10

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

FCAW welding of weld joint NSD1-SPSA3-56-2A located on PCMK north tower, lift 3, splice plate. Welder was identified as 040533. ZPMC QC was identified as CWI Wang Chuan Qing (QC1). The welding variables recorded by QC1 appeared to comply with WPS-B-T-2231-TC-U5-F.

FCAW welding of weld joint ESD1-SPSA3-4-2A located on PCMK east tower, lift 3, splice plate. Welder was identified as 053870. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2231-TC-U5-F.

SMAW welding of weld joint ED1-A5007-31-1B located on PCMK east tower, strut. Welder was identified as 057258. ZPMC QC was identified as CWI Xu Le Feng (QC2). Assisting QC2 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 QC2's assistant appeared to comply with WPS-345-SMAW-4G(4F)-repair.

FCAW welding of weld joint NSTL3-3L/K-96 located inside PCMK north tower, lift 3, skin C to skin D corner, angle stiffener to the top of 109M diaphragm. ZPMC QC was identified as Tu Jun (QC3). The welding variables

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recorded by QC3 appeared to comply with WPS-B-T-4333-TC-P5-F.

FCAW welding of weld joint NSTL3-3G/K-4 located inside PCMK north tower, lift 3, skin C to skin D corner, angle stiffener to bottom of 99M diaphragm. Welder was identified as 052075. ZPMC QC was identified as QC3. The welding variables recorded by QC3 appeared to comply with WPS-B-T-4333-TC-P5-F.

FCAW welding of weld joint NSTL3-3F/K-81 located inside PCMK north tower, lift 3, skin C to skin D corner, angle stiffener to bottom of 95.5M 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-2333-TC-P5-F.

FCAW welding of weld joint NSTL3-3C/K-4 located inside PCMK north tower, lift 3, skin C to skin D corner, angle stiffener to bottom of 89M diaphragm. Welder was identified as 057266. ZPMC QC was identified as QC3. The welding variables recorded by QC3 appeared to comply with WPS-B-T-4333-TC-P5-F.

FCAW welding of weld joint NSTL3-3C/K-5 located inside PCMK north tower, lift 3, skin C to skin D corner, angle stiffener to bottom of 89M diaphragm. Welder was identified as 057244. ZPMC QC was identified as QC3. The welding variables recorded by QC3 appeared to comply with WPS-B-T-4333-TC-P5-F.

SMAW welding of various weld joints attaching lower shaft rotator fenders on PCMK south tower, lift 4, skin D. Welder was identified as 057220. ZPMC QC was identified as QC3. Assisting QC2 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 QC2's assistant appeared to comply with WPS-B-T-2133.

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
