

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-009814**Date Inspected:** 13-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:

SMAW welding of weld joint WD1-A6001-6-88 located on PCMK west tower strut. Welder was identified as 202100. ZPMC QC was identified as CWI Xu Le Feng (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC CAWI Liu Duo Feng. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-T-4113.

FCAW tack welding of weld joints ED1-A149A/C-4, 5, 6, 8 located on PCMK east tower skirt plate. Joint fit-up observed appeared to be within tolerance. Welder was identified as 059525. 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 Xu Jin Long. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2132.

Bay 10

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

SMAW repair welding of weld joints NSTL3-3B/K-79 located inside PCMK north tower, lift 3, skin B to skin C

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

corner. Welder was identified as 052930. ZPMC QC was identified as CWI Liu Zhang An (QC3). The welding variables recorded by QC3 appeared to comply with WPS-345-SMAW-2G(2F)-repair.

FCAW welding of weld joints SSSL4-1H/L-134, 80 located inside PCMK south tower, lift 4, skin D to fit lugs at top of 131M double diaphragm and weld joints SSSL4-1H/L-132, 13 at bottom of 131M double diaphragm. Welder was identified as 053870. ZPMC QC was identified as CWI Wang Chuang Qing (QC4). The welding variables recorded by QC4 appeared to comply with WPS-B-T-4332-TC-P5-F.

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

Summary of Conversations:

No relevant conversations.

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 |
|---------------------|-------------|-------------|