

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-010587**Date Inspected:** 09-Nov-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 SSD1-SPSA4-20-3B located on PCMK south tower, lift 4, splice plate. Welder was identified as 053870. ZPMC QC was identified as CWI Li Ming (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC Li Peng Fei, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-T-2231-TC-U5-F.

SMAW welding of weld joint NSD1-SPSA4-26-2A and 2B located on PCMK north tower, lift 4, splice plate. Welders were identified respectively as 040586, 054547. ZPMC QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC Sun Tian Liang, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-T-2212-TC-U5b. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Yang Ye Heng.

SMAW welding of weld joint NSTL4-3B/L-5A located on PCMK north tower, lift 4, skin B to skin C between approximately 136M and 138M elevations. Welder was identified as 040581. ZPMC QC was identified as Wan Wen Zhong (QC2). The welding variables recorded by QC2 appeared to comply with WPS-B-P-2214-C-U2.

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SMAW welding of weld joint NSTL4-3B/L-5A located on PCMK north tower, lift 4, skin B to skin C between approximately 120M and 122M elevations. Welder was identified as 057220. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-P-2214-C-U2.

FCAW welding of weld joint NSTL4-3B/L-3A located on PCMK north tower, lift 4, skin A to skin E between approximately 120M and 122M elevations. Welder was identified as 050041. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2232-C-U2-F.

SMAW weld metal layering at the bottom ends of skin plate and various internal and external stiffeners located on PCMK north tower, lift 1, skin E. Welder was identified as 050038. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC Sun Tian Liang, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-345-SMAW-2G(2F)-repair.

SMAW weld metal layering at the bottom ends of skin plate and various internal and external stiffeners located on PCMK north tower, lift 1, skin C. Welder was identified as 057226. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC Sun Tian Liang, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-345-SMAW-2G(2F)-repair.

Bay 11

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

Installation of struts onto PCMK west tower, lift 1, skin A at various double diaphragm locations using what appeared to be temporary bolt sets.

Summary of Conversations:

No significant 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
