

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-011345**Date Inspected:** 06-Jan-2010**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 repair welding of weld joint WSTL4-2B/L-61 located inside PCMK west tower, lift 4, skins D/E corner, approximately 1550mm at 122M elevation. Welder was identified as 040713. ZPMC QC was identified as CWI Li Lin (QC1). The welding variables recorded by QC1 appeared to comply with WPS-345-FCAW-2G(2F)-repair listed on the unnumbered ZPMC repair order.

Bay 10

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

SMAW welding of temporary staging attachment outside PCMK south tower, lift 2, skin D, approximately 1600mm from top of lift 2. Welder was identified as 056200. ZPMC QC was identified as CWI Du Zhi Qun (QC2). The welding variables recorded by QC2 appeared to comply with WPS-B-T-2114.

FCAW welding of weld joint SSTL4-1J/L-70 located inside PCMK south tower, lift 4, skins C/D corner, top of 139M double diaphragm to diagonal corner plate. Welder was identified as 066477. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC

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Wang Hao, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-4333-TC-P5-F.

FCAW welding of weld joint SSTL4-1B/L-24 located inside PCMK south tower, lift 4, skins C/D corner, top of diagonal corner plate to skin D at the 140M elevation. Welder was identified as 053116. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC Wang Hao, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2231-TC-P4-F-2.

FCAW welding of weld joints SSTL4-1B/L-24, 20 located inside PCMK south tower, lift 4, skins C/D, top and bottom of diagonal corner plate at the 131M elevation. Welder was identified as 068919. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC Wang Hao, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2331-TC-P4-2 for weld 24 and WPS-B-T-2332-TC-P4-F-2 for weld 20.

FCAW welding of weld joint SSTL4-1B/L-53 located inside PCMK south tower, lift 4, skins B/C, bottom of diagonal corner plate at the 128M elevation. Welder was identified as 057244. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2332-TC-P4-F-2.

FCAW welding of weld joint SSTL4-1B/L-20 located inside PCMK south tower, lift 4, skins C/D, bottom of diagonal corner plate at the 128M elevation. Welder was identified as 068864. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2332-TC-P4-F-2.

FCAW welding of weld joint SSTL4-1B/L-24 located inside PCMK south tower, lift 4, skins C/D, top of diagonal corner plate at the 124M elevation. Welder was identified as 201825. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2331-TC-P4-F-2.

FCAW welding of weld joint SSTL4-1B/L-24 located inside PCMK south tower, lift 4, skins C/D, top of diagonal corner plate at the 120M elevation. Welder was identified as 040343. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2331-TC-P4-F-2.

FCAW welding of weld joint SSTL4-1B/L-49 located inside PCMK south tower, lift 4, skins B/C, top of diagonal corner plate at the 119M elevation. Welder was identified as 054069. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2331-TC-P4-F-2.

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.

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Inspected By:	Goulet,George	Quality Assurance Inspector
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Reviewed By:	Dawson,Paul	QA Reviewer
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