

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-012027**Date Inspected:** 15-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 and OBG 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:

SMAW repair welding of weld joint SSSL4-1B/L-2A located outside PCMK south tower, lift 4, skins D/E corner at 136M elevation being prepared by electrically preheating the area to 200°C. Welder who was present and appeared to have all necessary equipment as well as a heated filler metal container was identified as 050289. ZPMC QC was identified as CWI Du Zhi Qun (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC Jiang La Mei, who was not a CWI. Also present at this location and appearing to be prepared to monitor the welding operation was ABF Representative Yang Ye Heng (ABF). ABF informed this QA Inspector that this repair welding would be performed soon during this night shift. However, this QA Inspector observed all ZPMC personnel and all inspectors had left Bay 10 and appeared to be gone for the remainder of the night shift without any welding being performed at this location.

FCAW repair welding of weld joint NSTL4-3B/L-4A located outside PCMK south tower, lift 4, skins A/B corner from 119.5 to 120.5M elevations. Welder was identified as 040434. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-345-FCAW-1G(1F)-repair. Also present at

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this location and appearing to be monitoring the welding operation was ABF Representative Zhang Qin Jian.

Bay 11

This QA Inspector randomly observed no welding work being performed in Bay 11.

Blast Shop #1

This QA Inspector and Caltrans QA Inspectors Paul Dawson and Mike Hasler responded to responded to ZPMC Notice of Inspection, Request Number 2516 at 0030 hours on 1/16/2010 to perform random visual inspections in Blast Shop 1 of the internal floor of OBG Segment 8BE from panel point 67 to panel point 68. Upon arrival, ZPMC QC informed QA Inspector Paul Dawson that the time listed on the notice of inspection was incorrect and the above noted segment would not be ready for inspection until 0630 hours. This QA Inspector did not perform the above noted inspection on this work shift.

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

Summary of Conversations:

As notes 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 Skyler Guest, 150-0042-2360, who represents the Office of Structural Materials for your project.

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