

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-013425**Date Inspected:** 24-Apr-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 (QA 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:

Match drilling with magnetically mounted drills through previously scored holes into PCMK east tower, lift 3 and lift 4 at the lift3/lift 4 joint, skin A, from the outside in. No template was being used.

Heavy Dock

This QA Inspector randomly observed the following work in progress on the heavy dock.

FCAW welding of weld joint NSD1-SA17-78 located outside PCMK north tower, lift 1 base, skin C, shear plate stiffener to connection plate. Welder was identified as 068765. QC was identified as ZPMC CWI Gong Liang Zhu (QC2). The welding variables recorded by QC2 appeared to comply with WPS-B-T-2333-TC-P4-F.

FCAW welding of weld joint NSD1-SA17-48 located outside PCMK north tower, lift 1 base, skin C, shear plate stiffener to connection plate. Welder was identified as 040349. QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2333-TC-P4-F.

FCAW welding of weld joint NSD1-SA17-38 located outside PCMK north tower, lift 1 base, skin C, shear plate

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stiffener to connection plate. Welder was identified as 067993. QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2333-TC-P4-F.

FCAW welding of weld joint NSD1-A112A/H-1 located outside PCMK west tower, lift 1 base, skins B/C corner, shear plate stiffener to connection plate. Welder was identified as 068916. QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2333-TC-P4-F.

FCAW welding of weld joint SSD1-SA16F/G-52 located outside PCMK south tower, lift 1 base, skin E, shear plate stiffener to connection plate. Welder was identified as 066398. QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2333-TC-P4-F.

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

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