

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-014659**Date Inspected:** 16-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 and OBG 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 relative to the work being performed.

Bay 10

This QA Inspector randomly observed no apparent welding related work being performed in Bay 10.

Bay 11

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

SMAW welding of weld joint ND1-STSA4-6-127M-2-no weld number located on PCMK north tower strut, temporary outer stiffener. Welder was identified as 216950. QC was identified as ZPMC CWI Du Zhi Qun (QC1).

Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Liu Dao Feng, who was a CAWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-T-4113.

SMAW tack welding of weld joint ND1-STSA4-6-131M-1-47 located on PCMK north tower strut. Welder was identified as 054217. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Liu Dao Feng, who was a CAWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-T-2114.

Trial Assembly Area

WELDING INSPECTION REPORT

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This QA Inspector randomly observed the following work in progress in the Trial Assembly Area:

SMAW welding of weld joint OBE7C-008 located outside PCMK OBG 7E, bottom plate to bottom plate, at the 7DE/7EE joint. Welders were identified as 059841, 068917, 037932. ZPMC QC was identified as Wu Zhi Cheng (QC2). Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Wang Li Yang, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

FCAW welding of weld joint SEG040A-028 located inside PCMK OBG 7E, side plate to edge plate, at the 7DE/7EE joint. Welder was identified as 048659. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2232-TC-U4b-F.

ZPMC welding personnel performing weld repairs inside PCMK 7DE to 7EE bottom panel and side panel transverse segment splice welds near PP058 without a CWI present for a period exceeding 30 minutes. This QA was present in the area from 2050 hours to 2200 hours and again from 2230 hours to 2330 hours. The weld joints were identified as OBE7C-007, 008 and 010 and SEG040A-028 all of which are joining Seismic Performance Critical Material (SPCM). Also present at this location was ABF Representative Zou Hu (ABF1). This QA notified ABF1 and ZPMC QC inspector Mr. Zhong Yong Gang, who was in the area and not a CWI, of this issue and informed him that this QA Inspector would generate an incident report concerning this issue. See the Caltrans Incident Report (TL-15) for this date for more information.

Heavy Dock

This QA Inspector randomly observed the following work in progress on the Heavy Dock:

ABF Representative Zhao Ying Sheng informed this QA Inspector that no welding related work was being performed on the tower trial assembly and all ZPMC work crews would be finished for the night at approximately 2200 hours.

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

Summary of Conversations:

As noted 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 Eric Tsang, 150-0042-2372, who represents the Office of Structural Materials for your project.

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