

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-014928**Date Inspected:** 25-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 observations relative to the work being performed.

Bay 11

This QA Inspector randomly observed no apparent welding related work being performed in Bay 11. ZPMC workers performing match drilling with magnetically mounted drills through previously scored holes into PCMK east tower, lift 3, skin A, 99M and 109M diaphragm doubler plates from the outside in. No template was being used.

Bay 10

This QA Inspector randomly observed no apparent welding related work being performed in Bay 10. ZPMC workers performing match drilling with magnetically mounted drills through previously scored holes into PCMK east tower, lift 3 at the lift 3/lift 4 joint, skin B, from the outside in. No template was being used.

Heavy Dock

ABF Representative Zhao Ying Sheng informed this QA Inspector that no welding related work was being performed on the heavy dock.

OBG Trial Assembly Area

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

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

SMAW welding of weld joint OBE8B-005 located outside PCMK OBG 8AE/8BE, side plate to side plate transverse joint. Welder was identified as 067610. ZPMC QC was identified as ZPMC CWI Liu Hua Jie (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Wang Zhu, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

SMAW welding of weld joint OBE8B-004 located outside PCMK OBG 8AE/8BE, side plate to side plate transverse joint. Welder was identified as 068764. ZPMC QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Wang Zhu, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

ZPMC workers performing match drilling with magnetically mounted drills through previously drilled holes in outer splice plates into U-ribs from the outside in at the 7AEE/8AE joint. No template was being used and the inner splice plate was not being drilled.

SMAW welding of temporary alignment plates located outside PCMK OBG 8BE/8CE joint transverse joint, edge plate to edge plate, north (crossbeam path) side. Welder was identified as 054467. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-P-2112-FCM-1.

SMAW welding of temporary alignment plates located outside PCMK OBG 8BE/8CE joint transverse joint, edge plate to edge plate, south (bike path) side. Welder was identified as 048659. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-P-2112-FCM-1.

SMAW welding of temporary alignment plates located outside PCMK OBG 8BE/8CE joint transverse joint, bottom plate to bottom plate. Welder was identified as 062092. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-P-2114-FCM-1.

FCAW welding of temporary alignment plates located outside PCMK OBG 8BE/8CE joint transverse joint, deck plate to deck plate. Welder was identified as 049771. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2132.

SMAW welding of temporary alignment plates located outside PCMK OBG 8BE/8CE joint transverse joint, side plate to side plate, north (crossbeam) side. Welder was identified as 054467. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-P-2114-FCM-1.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

your project.

Inspected By: Goulet, George

Quality Assurance Inspector

Reviewed By: Dawson, Paul

QA Reviewer