

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-015108**Date Inspected:** 01-Jun-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 10

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

SMAW welding of temporary alignment plates located at the top of north tower, lift 3, skins C/D corner. Welder was identified as 040581. QC was identified as ZPMC CWI An Qing Xiang (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Yuan Hui Gang, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-T-2314-TC-P5. Also present at this location and appearing to be monitoring the welding operations were ABF Representatives Li Nan and Zhao Ying Sheng.

SMAW welding of weld joints ND1-STSA4-10-119M-1-26, 31 located on PCMK north tower, strut assembly. Welders were identified respectively as 041271, 040614. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Mao Bin Bin, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-T-2113. Also present at this location and appearing to be monitoring the welding operations was ABF Representative Li Nan.

Bay 11

This QA Inspector randomly observed no welding related work in progress in Bay 11.

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OBG Trial Assembly Area

SMAW welding of weld joint SEG039D-067, 119, 137, 164, 173 located inside PCMK OBG 7DE, north (crossbeam) side. Welder was identified as 216086. QC was identified as ZPMC CWI Wu Zhi Cheng (QC2). Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Shen Jian Bo, who was not a CWI. Welding variables recorded by QC2's assistant appeared to comply with WPS-345-SMAW-3G(3F)-repair as listed on ZPMC Weld Repair Report number B-WR13251~6 as presented to this QA Inspector. Also present at this location and appearing to be monitoring the welding operations was ABF Representative Wang Zhong Yuan.

SMAW welding of weld joint CA 049-006 located inside PCMK OBG 8BW, deck plate to edge plate, south (crossbeam) side. Welder was identified as 200569. QC was identified as ZPMC CWI Liu Hua Jie (QC3). Assisting QC3 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Sha Zhi, who was not a CWI. Welding variables recorded by QC3's assistant appeared to comply with WPS-345-SMAW-2G(2F)-FCM-repair-1.

Heavy Dock

This QA Inspector randomly observed the following on the heavy Dock:

South tower, lift 3 and East tower, lift 3 were laying horizontally at the foot of the Heavy Dock. No floating crane was moored in the immediate area.

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
