

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-015113**Date Inspected:** 05-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 11

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

SMAW welding of weld joints ND1-STSA4-10-119M-2-11, 12, 59, 60 located on PCMK north tower, strut assembly. Welder was identified as 046769. QC was identified as ZPMC CWI Xu Le Feng (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data were ZPMC QC's Mao Bin Bin, who was not a CWI and Liu Dao Feng, who was a CAWI. The welding variables recorded by QC1's assistants appeared to comply with WPS-2112. Also present at this location and appearing to be monitoring the welding operations was ABF Representative Li Shi You.

SMAW welding of weld joints ND1-STSA4-10-119M-1-11, 12 located on PCMK north tower, strut assembly. Welder was identified as 251194. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data were ZPMC QC's Mao Bin Bin, who was not a CWI and Liu Dao Feng, who was a CAWI. The welding variables recorded by QC1's assistants appeared to comply with WPS-2112. Also present at this location and appearing to be monitoring the welding operations was ABF Representative Li Shi You.

Bay 10

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA Inspector randomly observed no welding related work in progress in Bay 10.

Heavy Dock

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

South tower, lift 3 and east tower, lift 3 appeared to be atop their respective tower, lift's 2 and the floating crane moored to the foot of the Heavy Dock appeared to still be connected to east tower, lift 3. North tower, lift 1 was laying horizontally at the foot of the Heavy Dock. The elevator was dark and appeared to not be operating. It appeared to this QA Inspector that no work was being performed on the Heavy Dock.

OBG Trial Assembly Area

SMAW repair welding of weld joint SEG014D-036 located inside PCMK OBG 8AE, north (crossbeam) side, transverse DP stiffener to side plate. Welder was identified as 216086. QC was identified as ZPMC CWI Wu Zhi Cheng (QC2). Welding variables recorded by QC2 appeared to comply with WPS-345-SMAW-3G(3F)-repair as listed on ZPMC Weld Repair Report number B-WR13262 as presented to this QA Inspector.

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

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 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
