

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-015130**Date Inspected:** 09-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 no welding related work being performed in Bay 10.

Bay 11

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

No welding related work being performed in Bay 11. ZPMC personnel were observed loading parts appearing to be lap plates into shipping containers.

Heavy Dock

This QA Inspector observed no welding related work was being performed on the heavy dock. North and west towers, lifts 1 were laying horizontally at the foot of the dock and ZPMC workers were continuing to load lap plates inside west tower, lift 1.

OBG Trial Assembly Area

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

SMAW repair welding of weld joint OBW8B-003 located inside PCMK OBG 8AW/8BW, bottom plate to bottom plate transverse joint. Welder was identified as 045133. QC was identified as ZPMC CWI Wu Zhi Cheng (QC1).

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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. Welding variables recorded by QC1's assistant appeared to comply with WPS-345-SMAW-1G(1F)-FCM-repair as listed on a document presented to this QA Inspector by ZPMC QC Wang Zhu, ZPMC Weld Repair Report B-WR1597. Also present at this location and appearing to be monitoring the welding operations was ABF Representative Zhang Xiao Bin.

SMAW repair welding of weld joint OBW8C-003 located inside PCMK OBG 8BW/8CW, bottom plate to bottom plate transverse joint. Welder was not identified. QC was identified as ZPMC CWI Wu Zhi Cheng (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. Welding variables recorded by QC1's assistant appeared to comply with WPS-345-SMAW-1G(1F)-FCM-repair as listed on a document presented to this QA Inspector by ZPMC QC Wang Zhu, ZPMC Weld Repair Report B-WR1612. Also present at this location and appearing to be monitoring the welding operations was ABF Representative Zhang Xiao Bin.

ZPMC welding personnel performed weld repairs without an approved Certified Welding Inspector (CWI) present for a period exceeding 30 minutes. This QA was present in the area from 2120 hrs to 2115 hours, during which time CWR repair welding was being performed. This QA notified ZPMC CWI identified as Mr. Wu Zhi Cheng by telephone and QC inspector identified as Mr. Wang Zhu of this issue. Mr. Wang Zhu was present after 2145 hours. Mr. Wu Zhi Cheng informed this QA that no CWI's were assigned to the night shift for the OBG Trial Assembly area. The Y locations as recorded on the material are 6600mm at OBW8B-003 per ZPMC Repair Order B-CWR1597 (8AW to 8BW) and approximately 3000 at OBW8C-003 ZPMC Repair Order B-CWR1612 (8BW to 8CW). The weld joints are Complete Joint Penetration (CJP) Bottom Plate to Bottom Plate transverse splice joints.

This QA Inspector informed CWI Wu Zhi Cheng and ABF Representative Zhang Xiao Bin that a Caltrans Incident Report would be generated for the above noted issue.

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
