

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-015257**Date Inspected:** 26-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:

ZPMC worker backgouging weld joint SSD1-SPSA5-13-3A located on PCMK south tower, lift 5, internal splice plate assembly, which was mounted on an A-frame support with the weld joint in the flat position.

Bay 11

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

SMAW layered repair welding on the plate edge of PCMK LD5-4, thickness = 70mm. ZPMC CWI Gao Zhi Chun (QC1) presented this QA Inspector with ZPMC Critical Weld Repair Report CWR649 displaying the item name as East west tower 5 lifting transverse diaphragm and the drawing number as LD5-4. Welders were identified as follows: 044551, 251194 on the west diaphragm and 041271, 040667 on the east diaphragm. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Ma Qian Li, who was not a CWI. Welding variables recorded by QC1's assistant appeared to comply with WPS-485-SMAW-2G-(2F)-repair as listed on ZPMC Critical Weld Repair Report CWR649.

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 2)

SMAW welding of weld joints retro-G-01-008-49, 50 located inside the OBG at PCMK 9BE, T-shaped assemblies to side plate between longitudinal stiffeners, north (crossbeam) side. Welder was identified as 048800. 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 Shi Lei, who was not a CWI. Welding variables recorded by QC2's assistant appeared to comply with WPS-B-P-2113-FCM-1. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Zhang Xiao Ming.

SMAW welding of temporary alignment plate located outside the OBG at PCMK 9CW, to bottom plate, outside and below FL3 at panel point 68, south (crossbeam) side. Welder was identified as 068097. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was Shi Lei, who was not a CWI. Welding variables recorded by QC2's assistant appeared to comply with WPS-B-P-2112-FCM-1.

FCAW welding of weld joints SEG052A-21, SEG054A-13 located inside the OBG at PCMK 9BE/9CE, bottom plate to side plate, north (crossbeam) side. Welder was identified as 220063. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was Shi Lei, who was not a CWI. Welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2231T-1.

Heavy Dock

This QA Inspector observed no welding related work was being performed on the heavy dock. All 4 tower lifts 2 were erect with all 4 tower lifts 3 attached above, respectively. No ZPMC floating crane was in the immediate area. The worker access tower elevator was dark. ABF Representative Kang Yi acknowledged that no work was being performed on the Heavy Dock.

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
