

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-005170**Date Inspected:** 15-Jan-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** You Qi Guo, Tu Jun**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 Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, George Goulet, was present during the times noted above for observations relative to the work being performed.

Bay 11

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

SAW fill and cover pass welding of weld joints WSD1-SA388C/D-47, 32A, 43, 30A, 8, 28A, 39, 26A, 5, and 50A located on PCMK west tower, lift 2, skin C. Welder was identified as 042195. ZPMC QC was identified as CWI You Qi Guo (QC1). The welding variables recorded by QC1 appeared to comply with the WPS's:

B-T-2221-B-U3c-S-2 for the CJP welds, designated by the letter A, and WPS: B-T-2321-B-P3-S-2 for the other welds which were PJP welds. Also present at this location and appearing to observe the welding operation was ABF Representative Wang Cheng Jun (ABF1).

SAW fill and cover pass welding of weld joints WSD1-SA388C/D-34B, 36, 22B, and 2 located on PCMK west tower, lift 2, skin C. Welder was identified as 041716. ZPMC QC was identified as Yang Ming Ming (QC2) assisting QC1. The welding variables recorded by QC2 appeared to comply with the WPS's:

B-T-2221-B-U3c-S-2 for the CJP welds, designated by the letter B, and WPS: B-T-2321-B-P3-S-2 for the other welds which were PJP welds. Also present at this location and appearing to observe the welding operation was ABF1.

SAW fill and cover pass welding of weld joints WSD1-SA388C/D-4, 21B, 34, and 23B located on PCMK west

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tower, lift 2, skin C. Welder was identified as 056975. ZPMC QC was identified as QC2 assisting QC1. The welding variables recorded by QC1 appeared to comply with the WPS's: B-T-2221-B-U3c-S-2 for the CJP welds, designated by the letter B, and WPS: B-T-2321-B-P3-S-2 for the other welds which were PJP welds. Also present at this location and appearing to observe the welding operation was ABF1.

Bay 10

FCAW fill pass welding using the southeast gantry in this bay of weld joints NSD1-SA166D/F-10 and 11, and NSD1-SA340E/F-9 and 10 located on PCMK west tower, lift 2, skin A. Welders were identified respectively as 037907, 067500, 068923, and 068087. ZPMC QC's were identified as Tu Jun (QC3) and QC3's assistant, Den Bing Zhi (QC4). The welding variables recorded by QC3 appeared to comply with the WPS: B-T-2332-TC-P5-F. Also present at this location and appearing to observe the welding operation was ABF Representative Li Nan (ABF2).

FCAW fill welding using the southwest gantry in this bay of weld joints NSD1-SA166D/F-14 and 15, and NSD1-SA340E/F-13 and 14 located on PCMK west tower, lift 2, skin A. Welders were identified respectively as 066687, 060683, 068493, and 068494. ZPMC QC's were identified as QC3 and QC4. The welding variables recorded by QC3 appeared to comply with the WPS: B-T-2332-TC-P5-F. Also present at this location and appearing to observe the welding operation was ABF Representative ABF2.

This QA inspector observed no ZPMC workers performing any welding on the tower shaft assemblies in the back of Bay 11.

Summary of Conversations:

As noted above, and this QA inspector asked all three QC's noted above if all the welding variables observed by them appeared to comply with the appropriate WPS, including the preheat and interpass temperature requirements according to thickness of the thickest member being welded. Each QC showed this QA Inspector that he was carrying the proper temperature sticks to monitor the minimum and maximum preheat and interpass temperatures and replied that all he observed did appear to comply.

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 Serge Sinevod, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Lindenmuth, Mahlon	QA Reviewer
