

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-005529**Date Inspected:** 03-Feb-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:	Li Hong Fei, Wan Wen Zhong	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:

FCAW welding of weld joints WSD1-SA298F/G-2, 3, 7, and 8 located on PCMK west tower, lift 2, skin E.

Welders were identified respectively as 066420, 070254, 058493, and 067104. ZPMC QC was identified as Li Hong Fei (QC1). The welding variables recorded by QC1 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 Shen Wen Liang.

SAW fill pass welding of weld joint WSD1-SA209A/D-2A located on PCMK west tower, lift 2, skin D. Welder was identified as 041716. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with the WPS's: B-T-2221-B-U3c-S-2. Also present at this location and appearing to observe the welding operation was ABF Representative Luo Lai Quan. At 0205 hours, the SAW welding operation was suspended because QC1 noted that the interpass temperature had exceeded the 230°C maximum temperature allowed by the above noted WPS and the welder preferred not to wait for the temperature to decrease to within the allowable limit.

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

Bay 10

WELDING INSPECTION REPORT

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

FCAW fill pass welding of weld joint NSD1-SA97-4A located on PCMK north tower, lift 1, skin A splice. The skin splice assembly was mounted on an A frame with the weld joint in the flat position. Welder was identified as 067275. ZPMC QC was identified as Wan Wen Zhong (QC2). The welding variables recorded by QC2 appeared to comply with the WPS: B-T-2231-Tc-U5-F.

This QA inspector observed no ZPMC workers performing any welding on either of the tower shaft assemblies in the back of Bay 10.

Summary of Conversations:

As noted above, and this QA inspector asked both 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:	Clifford, William	QA Reviewer
