

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-005562**Date Inspected:** 06-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**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 joint WSD1-SA296F/G-3 located on PCMK west tower, lift 2, skin E. Welder was identified as 066825. 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 Chen Wen Liang.

FCAW welding of weld joint WSD1-SA39A/K-8 located on PCMK west tower, lift 1, skin E. Welder was identified as 067036. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with the WPS: B-T-4332-Tc-P4-F. Also present at this location and appearing to observe the welding operation was ABF Representative Chen Wen Liang.

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

Summary of Conversations:

As noted above, and this QA inspector asked QC noted above if all the welding variables observed by him appeared to comply with the appropriate WPS, including preheat and interpass temperature requirements according to thickness of the thickest member being welded. QC showed this QA Inspector that he was carrying

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

the appropriate 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
