

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-005650**Date Inspected:** 13-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 6

This QA inspector proceeded to Bay 6 in response to a ZPMC notification of witness inspection to perform MT inspection as follows:

This QA Inspector performed MT of approximately 15% the total linear distance of the 100% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The member is identified as west tower 53M diaphragm assembly. The weld designations reviewed as marked on the part are as follows: WSD1-SA404-4; WSD1-SA381A/B-4; and WSD1-SA381B/B-3, 4, 5, 6, 9, 10, 13, 14. QA Inspector also notated MT review on the member.

Bay 11

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

SAW welding of weld joint ESD1-A165E/J-268B located on PCMK east tower, lift 1, skin A to skin B. Welder was identified as 040634. ZPMC QC was identified as Li Hong Fei (QC). The welding variables recorded by QC appeared to comply with WPS: B-T-2221-C-U2b-S-2.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

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Summary of Conversations:

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 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:	Carreon,Albert	QA Reviewer
