

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-005775**Date Inspected:** 01-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:****Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:****Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Tu Jun, Lei Shi, Guo Yan 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 and OBG 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 10

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

SAW welding of weld joint SSD1-FCSA3-1B/C-9B located on PCMK south tower, lift 3, skin C. Welder is identified as 207745. ZPMC QC was identified as Tu Jun (QC1). The welding variables recorded by QC1 appeared to comply with WPS-B-T-2221-B-U3c-S-2. Also present at this location and appearing to be monitoring the welding was ABF Representative Liu Cheng.

FCAW welding of weld joints NSD1-SA223-166E/E-10 and 9 located on PCMK north tower, lift 2, skin D.

Welders were identified respectively as 068864 and 068501. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2332-Tc-P5-F. Also present at this location and appearing to be monitoring the welding was ABF Lu Yun.

Bay 13

This QA Inspector randomly observed the following work in progress in Bay 13:

SAW welding of weld joint DP574-001 to DP559-001. Welder was identified as 062406. ZPMC QC was identified as Lei Shi (QC2). The welding variables recorded by QC2 appeared to comply with WPS-B-T-2221-B-L2c-S-2. Also present at this location and appearing to be monitoring the welding was ABF representative Zheng Chang Song.

WELDING INSPECTION REPORT

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Bay 14

This QA Inspector randomly observed the following work in progress in Bay 14:

FCAW welding of weld joint 078 located on PCMK DP555-001. Welder was identified as 200149. ZPMC QC was identified as Guo Yan Fei (QC3). The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U4-P-F-1.

Bay 10

This QA inspector proceeded to Bay 10 in response to a ZPMC NDT Inspection Notification to perform MT inspection as follows:

This QA Inspector performed MT of approximately 15% 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 SSD1-FBSA3-1A/C. The weld designations reviewed are as follows: 13A,17A. QA Inspector also notated QA MT review on the member.

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

Summary of Conversations:

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 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 appropriate temperature sticks to monitor 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 Eric Tsang, 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
