

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-006574**Date Inspected:** 20-Apr-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:** Sun Bo**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 11

This QA Inspector, George Goulet, proceeded to Bay 11 in response to a ZPMC notification of witness inspection #2726 to perform MT inspection as follows:

This QA Inspector, George Goulet, performed VT of 100% of the area and MT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector, George Goulet, generated an MT report for this date. The member is identified as WSD1-FBSA3-2A/C. The weld designations reviewed are as follows: 11, 15, 20, 24, 16B-1, 16B-2. This QA Inspector, George Goulet, also notated MT review on the member.

This QA Inspector, George Goulet, performed VT of 100% of the area and MT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector, George Goulet, generated an MT report for this date. The member is identified as WSD1-FDSA3-2B/C. The weld designations reviewed are as follows: 3A-2, 9A, 13A-1, 13A-2, 18A, 6, 10, 15, 19. This QA Inspector, George Goulet, also notated MT review on the member.

Bay 9 - PMT

This QA Inspector, George Goulet, monitored OBG Production Monitoring Test (PMT) #1 for deck panels

WELDING INSPECTION REPORT

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DP509-001 and DP350-002 at Gantry #2. Prior to PMT #1, the magnetic particle test (MT) of the tack welds was noted on the test panel as having been performed by ZPMC MT Inspector Sun Gong Chang. The visual inspection of tack welds and root gap was performed by ABF Representative Lv Yun (ABF), ZPMC CWI Sun Bo (QC), and this QA Inspector, George Goulet. The start time for welding of PMT #1 was approximately 0014 hours on Tuesday, 4/21/09 and the finish time was approximately 0047 hours. This QA Inspector, George Goulet, randomly verified and documented the welding amperage, voltage and travel speed during the gas metal arc welding (GMAW) and submerged arc welding (SAW) processes, welds 1 thru 6 at the completion of both the GMAW root pass and SAW cover pass. The welds were visually inspected by ABF, QC and this QA inspector, George Goulet. QC and ABF informed this QA Inspector, George Goulet, that all six welds were acceptable and this QA Inspector, George Goulet, concurred. This QA Inspector, George Goulet, randomly witnessed ZPMC ultrasonic testing (UT) inspector, identified as Xue Hai Rong, perform UT on each of the 500 mm test welds for depth of penetration and conformance. This QA Inspector, George Goulet, selected fifteen designated locations for macroetch sampling per contract requirements. Each macroetch location was stamped by ZPMC personnel with the number 509, the letter D, and an individual macroetch identifying number for each macroetch sample. At approximately 0330 hours, ZPMC QA Inspector Zhang Jiadi informed this QA Inspector, George Goulet, that QC had rejected one of the fifteen macroetch samples during the visual inspection and ZPMC chose not perform another PMT during this work shift.

See Caltrans U-ribs PMT Inspection Sheet, ZPMC Production Monitoring Test Plate Inspection Report, and Caltrans Macro Etch Log - all dated 4/21/2008 for additional information.

Summary of Conversations:

As noted above.

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
