

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-006732**Date Inspected:** 03-May-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:** Tu Jun, Liu Yang**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 10

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

FCAW welding of weld joint NSD1-A112F/H-68, 69 located on PCMK north tower, lift 1, skin D. Welder was identified as 053116. ZPMC QC was identified as Tu Jun (QC1). The welding variables recorded by QC1 appeared to comply with WPS-B-T-2133. Also at this location and appearing to be monitoring the welding and recording data was ABF Representative Zhang Qin Jian (ABF).

FCAW welding of weld joint NSD1-A166C/J-262, 119 located on PCMK north tower, lift 1, skin D. Welders were identified respectively as 040553, 053869. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2133. Also at this location and appearing to be monitoring the welding and recording data was ABF.

FCAW welding of weld joint NSD1-A116A/J-107, 108 located on PCMK north tower, lift 1, skin D. Welders were identified respectively as 201825, 203977. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2133. Also at this location and appearing to be monitoring the welding and recording data was ABF.

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FCAW welding of weld joint NSD1-A166G/J-100 located on PCMK north tower, lift 1, skin D. Welder was identified as 057224. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2133. Also at this location and appearing to be monitoring the welding and recording data was ABF.

FCAW welding of weld joint NSD1-A166G/J-220 located on PCMK north tower, lift 1, skin D. Welder was identified as 050041. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2133. Also at this location and appearing to be monitoring the welding and recording data was ABF.

FCAW welding of weld joint SSD1-FDSA3-1B/C-41A located on PCMK north tower, lift 3, skin D. ZPMC QC was identified as Liu Yang (QC2). QC2 presented this QA Inspector, George Goulet, with a weld repair procedure with no identifying number. QC2 informed this QA Inspector, George Goulet, that an identifying number would be assigned during the following day shift. The welding variables recorded by QC2 appeared to comply with WPS-345-FCAW2G(2F)-repair, listed on the repair procedure presented to this QA Inspector, George Goulet.

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

Summary of Conversations:

As noted above, and QA inspector asked each QC if all the welding variables observed by him appeared to comply with the appropriate WPS, including the preheat 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:	Carreon,Albert	QA Reviewer
