

**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-007189**Date Inspected:** 02-Jun-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

<b>CWI Name:</b>	Jin Dong Liang, Yu Dong Ping	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes	No N/A
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes	No N/A
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes	No N/A
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes	No N/A
		<b>Delayed / Cancelled:</b>	Yes	No N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	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.

## Trial Assembly Area

This QA Inspector, George Goulet, randomly observed the following in segments 4AE/4BE, 4AW/4BW:

ZPMC workers removed 154 – ASTM A325 bolt sets from the bottom plate/lap plate connections.

## Bay 10

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

FCAW welding of weld joint SSD1-FASA4-1E/E-54B located on PCMK south tower, lift 4, skin A. Welder was identified as 048378. ZPMC QC was identified as CWI Jin Dong Liang (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Wang Hao, who was not a CWI. The welding variables recorded by QC1 and his assistant appeared to comply with WPS-B-T-2231-B-U3-F.

FCAW welding of weld joint NSD1-FASA3-1A/E-5 located on PCMK north tower, lift 3, skin A. Welders were identified as 052075, 201825. ZPMC QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Sun Tian Liang, who was not a CWI. The welding variables recorded by QC1 and his assistant appeared to comply with WPS-B-T-2132. Also at this

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location and appearing to be monitoring the welding was ABF Representative Zhang Qin Jian.

Bay 11

This QA Inspector, George Goulet, randomly observed the following work in progress in Bay 11:

SAW welding of weld joint WSD1-A423B/H-78B located on PCMK west tower, P280-1/P281. ZPMC QC was identified as Yu Dong Ping (QC2). Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Cao Chen. The welding variables recorded by QC2 and QC2's assistant appeared to comply with WPS-B-T-2221-B-U3c-S-2.

SMAW tack welding of weld joint SSD1-A111B/H-2A located on PCMK south tower, P81/P387. Welder was identified as 206195. ZPMC QC was identified as QC2. The welding variables recorded by QC2 and QC2's assistant appeared to comply with WPS-B-T-2211-B-U3b. Also at this location and appearing to be monitoring the welding was ABF Representative Xie Yan.

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

**Summary of Conversations:**

As noted above, and this QA Inspector, George Goulet, asked each QC if all the welding variables observed by QC 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, George Goulet, that QC was carrying the proper temperature sticks to monitor the minimum and maximum preheat and interpass temperatures and replied that all QC 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.

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<b>Inspected By:</b>	Goulet,George	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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