

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-007194**Date Inspected:** 31-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:** Xu Le Feng**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.

Trial Assembly Area

This QA Inspector, George Goulet, randomly observed the following in the trial assembly area:

The section 4AE/4BE deck plate U-rib connection bolt sets from lap plate #59 to #78 appeared to have been final tightened with only 4 bolts showing to be less than the minimum 180° nut rotation. The bolt sets were marked by this QA Inspector, George Goulet. No ZPMC workers were performing any other bolting work.

Bay 11

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

FCAW welding of weld joint WSD1-SA295B/E-46 located on PCMK west tower shaft, lift 1, stiffener connection plate. ZPMC QC was identified as Xu Le Feng (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Ma Qian Li, who was not a CWI. The welding variables recorded by QC1 and his assistant appeared to comply with WPS-B-T-2331-Tc-P4-F.

SMAW tack welding of weld joint WSTL3-4F/F114 located on PCMK west tower, lift 3, skin E at diaphragm 95.5M. ZPMC QC was identified as QC1. Welder was identified as 053224. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Ma Qian Li, who was not a

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

CWI. The welding variables recorded by QC1 and his assistant appeared to comply with WPS-B-P-2313-Tc-P5. Also at this location and appearing to be monitoring the welding was ABF representative Wang Jiang Hua.

SAW welding of weld joints WSD1-A115E/J-70A located on PCMK west tower shaft, lift 1, skins A to B. ZPMC QC was identified as QC1. Welder was identified as 041716. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2221-B-L2a-S. Also at this location and appearing to be monitoring the welding was ABF Representative You Yuan Mao.

SAW welding of weld joints WSD1-A423B/H-4B located on PCMK west tower shaft, lift 1, skins A to B. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2221-C-U2b-S-2. Also at this location and appearing to be monitoring the welding was ABF Representative You Yuan Mao.

SAW welding of weld joints WSD1-A423B/H-5B located on PCMK west tower shaft, lift 1, skins B to C. ZPMC QC was identified as QC1. Welder was identified as 047304. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2221-C-U2b-S-2. Also at this location and appearing to be monitoring the welding was ABF Representative You Yuan Mao.

SAW welding of weld joints WSD1-A115C/J-90A located on PCMK west tower shaft, lift 1, skins B to C. ZPMC QC was identified as QC1. Welder was identified as 056975. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2221-C-A3c-S-2. Also at this location and appearing to be monitoring the welding was ABF Representative You Yuan Mao.

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 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. 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 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
