

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-007196**Date Inspected:** 03-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 445**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Yu Dong Ping
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: 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 segments 4AE/4BE:

ZPMC workers performed final bolt tightening of ASTM A325 bolt sets on the inner connections of the lower north chevron, at panel points 26, 27, 28 using a hydraulic bolt tightening wrench as follows: Hydra Electric Pump, Model MP582-11 and Hydra HY.Wrench. The workers appeared to be tightening the nuts to the turn-of-nut specification of 180° to 210°.

ZPMC workers performed final bolt tightening of ASTM A325 bolt sets on the outer connections of the lower north chevron, at panel point 28 using a hydraulic bolt tightening wrench as follows: Hydra Electric Pump, Model MP582-11 and Hydra HY.Wrench. The workers appeared to be tightening the nuts to the turn-of-nut specification of 180° to 210°.

None of the above work was finished at the end of the work shift.

Bay 11

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

WELDING INSPECTION REPORT

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SAW welding of weld joints WSD1-A423B/H-63A located on PCMK west tower, SA7-1/P281. Welder was identified as 042195. ZPMC QC was identified as CWI Yu Dong Ping (QC1). The welding variables recorded by QC1 appeared to comply with WPS-B-T-2221-B-U3c-S-2. Also at this location and appearing to be monitoring the welding was ABF Representative Xie Yan (ABF).

SAW welding of weld joints WSD1-A423B/H-78A located on PCMK west tower, P281/P288. Welder was identified as 041716. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2221-B-U3c-S-2. Also at this location and appearing to be monitoring the welding was ABF.

SAW welding of weld joints WSD1-A423B/H-97A located on PCMK west tower, SA7-1/P288. Welder was identified as 040625. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2221-B-U3c-S-2. Also at this location and appearing to be monitoring the welding was ABF.

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.

Inspected By:	Goulet,George	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
