

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-007581**Date Inspected:** 12-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yu Dong Ping**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 three rows of side plate to side plate lap plates between panel points 26~28 on the south side of segment 4BW in response to Bolting Inspection Notification Sheet No. 00021.

ZPMC workers performed final bolt tightening verification at the direction of ZPMC QC Shen Jiang Bo (QC1) using ZPMC calibrated wrench identified by scribing on the handle as XO2-584. Two of the ASTM A325 bolt sets at each connection were torque tested, with a minimum of four bolt sets tested on each lap plate. QC1 provided this QA Inspector, George Goulet, with the following information regarding the bolt sets installed at this location.

This QA Inspector, George Goulet, observed ZPMC's Bolt Test Log for SFOBB (RoCap list), listing the RoCap Set numbers, bolt set size, and the N.M test result for torque tightening purposes. The information presented by QC1 and listed below appeared to this QA Inspector, George Goulet, to match the RoCap list.

RC Set No. DHGM220021 – M22-2.5x65 – RoCap test result 543N.M - Installed at south side plates

The torque of the above noted bolt sets was verified by torque testing with the above noted calibrated wrench with

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the wrench setting displayed as 545N.M.

This QA Inspector, George Goulet, concurred with QC1 for the issuance of green tag numbers.

Bay 19

This QA Inspector, George Goulet, proceeded to the Bay 19 in response to a ZPMC notification of witness inspection #3395 for MT inspection of the following:

This QA Inspector, George Goulet, performed random VT and then MT of approximately 15% 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 BP025-008. The weld designations reviewed are as follows: 001~003.

Bay 11

This QA Inspector, George Goulet, randomly observed the following work in progress in Bay 11: SAW welding of weld joints WSD1-A423-B/H-98B located on PCMK west tower, plates P281 to P280-1. Welder was identified as 042195. ZPMC QC was identified as CWI Yu Dong Ping QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2221-B-U3c-S-2.

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 welding 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 welding QC showed this QA Inspector, George Goulet, that each welding QC was carrying the proper temperature sticks to monitor the minimum and maximum preheat and interpass temperatures and replied that all each welding 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
