

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-007727**Date Inspected:** 28-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:	Li Jia, Chen Ying Xin, Zhen Bo	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.

OBG Trial Assembly Area

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

Section 4BW/5AW, panel points 28~29, north – ZPMC workers fitting up longitudinal diaphragm. ZPMC CWI Li Jia was present and observing the operation.

Bay 10

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

FCAW welding, using the southeast gantry, of weld joints SSD1-FESA4-2F/F-55,56 located on PCMK south tower, lift 4, skin E. Welders were identified respectively as 054069, 057244. ZPMC QC was identified as CWI Chen Ying Xin (QC1). The welding variables recorded by QC2 appeared to comply with WPS-B-T-2332-Tc-P5-F.

FCAW welding, using the southwest gantry, of weld joints SSD1-FESA4-2F/F-44,45 located on PCMK south tower, lift 4, skin E. Welders were identified respectively as 053116, 203977. ZPMC QC was identified as CWI Chen Ying Xin (QC1). The welding variables recorded by QC1 appeared to comply with

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

WPS-B-T-2332-Tc-P5-F.

Bay 11

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

FCAW welding of weld joint ESD1-FASA4-2E/E-37B, mounted on an A-frame located on PCMK east tower, lift 4, skin A. Welder was identified as 040713. ZPMC QC was identified as Zhen Bo (QC2). The welding variables recorded by QC2 appeared to comply with WPS-B-T-2231-Tc-U5-F. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Wang Jiang Hua.

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

Summary of Conversations:

This QA Inspector, George Goulet, asked each QC monitoring the welding 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 monitoring the welding 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
