

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-008262**Date Inspected:** 20-Jul-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
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.

Bay 10

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

SAW welding of weld joints ND1-A6002-12-6B, 11-6B, 10-6B, 12-5B, 11-5B, 10-5B located on north tower.

Welder was identified as 201750. ZPMC QC was identified as CWI Yu Dong Ping (QC1). The welding variables recorded by QC1 appeared to comply with WPS-B-T-4221-B-U3c-S-1.

SAW welding of weld joints ND1-A6003-7-6A, 8-6A located on north tower. Welder was identified as 040460.

ZPMC QC was identified as CWI Yu Dong Ping (QC1). The welding variables recorded by QC1 appeared to comply with WPS-B-T-4221-B-U3c-S-1.

OBG Trial Assembly Area

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

2AE/2BE, north longitudinal – SMAW of outboard weld to bottom plate, both east and west if the connection.

CB1/2AE and 2AW – installation by drilling and bolting of four bent plate hold downs, one at each end of the CB1/2AE and CB1/2AW deck splice connections.

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3AE/FL3 and the west side of the south end of the panel point 19 floor beam area - sandblasting.

1AAW/1AW joint – broken fit-up dog that appeared to be broken at the welds.

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 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. 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
