

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-008265**Date Inspected:** 31-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:** Guo Peng**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 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 11

This QA Inspector, George Goulet, proceeded to the Bay 11 in response to a ZPMC notification of witness inspection #3829 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 WSD1-TL6. The weld designations reviewed are as follows: J/L-32, 33, 57, 58; C/L-59, 60, 166, 167; D/L-39, 40, 96, 97; E/L-34, 35, 64, 65; F/L-50, 51, 130, 131; G/L-32, 33, 90, 91; H/L-56, 57, 148, 149; K/L-55, 58.

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

SAW welding of weld joint ESTL3-4B/K-81B located on PCMK east tower shaft, lift 3, skins A to E. Welders were identified from bottom to top as 047304, 052642, 040699, 041716. ZPMC QC was identified as CWI Guo Peng (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 operation was ABF Representative You Yuan Mao.

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

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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
