

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-008270**Date Inspected:** 05-Aug-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:	An Qing Xiang, Guo Peng, Li Lin			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 the corner assemblies of segments 2AW/2BW in response to Bolting Inspection Notification Sheet No. 00081:

Sections lift 1 and 2 east, angles inside lower chevron:

At 1920 hours, ZPMC QA Lei Tao informed this QA Inspector, George Goulet, that the inspection was postponed until the next day because of lack of lighting at the above noted location.

Bay 11

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

SAW welding of weld joint WD1-A504A/C-300B located on west tower. Welder was identified as 040772. ZPMC QC was identified as CWI An Qing Xiang (QC1). The welding variables recorded by QC1 appeared to comply with WPS-B-T-2221-B-L2c-S-2. Also at this location and appearing to be monitoring the welding and recording data was ABF Representative Xie Yan.

SAW welding of weld joints SD1-A5002-29-1A, 30-1A, 31-1A, 32-1A located on south tower. Welder was

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identified as 042195. ZPMC QC was identified as CWI Guo Peng (QC2). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Chen Hong Yun, who was not a CWI. The welding variables recorded by QC1 and QC1's assistant appeared to comply with WPS-B-T-3221-Tc-U5-S-1.

SAW welding of weld joint WSTL3-4B/K-84B located on west tower shaft, lift 3, skins B to C. Welders were identified respectively from top to bottom as 047304, 044558, 040699, 052642, 202756. ZPMC QC was identified as CWI Li Lin (QC3). The welding variables recorded by QC1 appeared to comply with WPS-B-T-2221-C-U2b-S-2.

FCAW welding of weld joint WSD1-AH5H/J-196 located on west tower. Welder was identified as 070046. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Lu Wei Min, who was not a CWI. The welding variables recorded by QC2 and QC2's assistant appeared to comply with WPS-B-T-4333-Tc-P4-F.

FCAW welding of weld joint WSD1-A115G/H-164 located on west tower. Welder was identified as 067184. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Lu Wei Min, who was not a CWI. The welding variables recorded by QC2 and QC2's assistant appeared to comply with WPS-B-T-4332-Tc-P4-F.

FCAW welding of weld joint WSD1-A115E/J-178 located on west tower. Welder was identified as 068865. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Lu Wei Min, who was not a CWI. The welding variables recorded by QC2 and QC2's assistant appeared to comply with WPS-B-T-4332-Tc-P4-F.

FCAW welding of weld joint WSD1-A115F/J-51 located on west tower. Welder was identified as 068858. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Lu Wei Min, who was not a CWI. The welding variables recorded by QC2 and QC2's assistant appeared to comply with WPS-B-T-4332-Tc-P4-F.

Bay 10

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

FCAW welding of weld joints SSSL3-1B/K-82B, 83B located on south tower. Welders were identified respectively as 053116, 052075. ZPMC QC was identified as CWI Du Zhi Qun (QC4). Assisting QC4 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Deng Zhi Bin, who was not a CWI. The welding variables recorded by QC4 and QC4's assistant appeared to comply with WPS-B-T-2231-C-U2-F.

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 monitoring the welding if all the welding variables observed by QC appeared to comply with the appropriate WPS, including the preheat requirements

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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 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
