

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-008668**Date Inspected:** 17-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:** Li Lin, Wang Chuan Qing**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, randomly observed the following work in progress in Bay 11:

FCAW buttering welding of the bottom end of west tower, lift 1, skin A, shown on drawing # WSD1-A423B/H. The four welders were identified as 068923, 068858, 067184, 066471. ZPMC QC was identified as CWI Li Lin (QC1). The welding variables recorded by QC1 appeared to comply with WPS-345-FCAW-2G(2F)-repair which was listed as one of the WPS's on ZPMC repair order T-WR1961. Also at this location and appearing to be monitoring the welding and recording data was ABF Representative Luo Lai Quan.

Bay 10

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

FCAW buttering welding of the bottom end of north tower, lift 1, skin B, shown on drawing # NSD1-SA11A/F. The two welders were identified as 050041, 057246. ZPMC QC was identified as CWI Wang Chuan Qing (QC2). The welding variables recorded by QC2 appeared to comply with WPS-345-FCAW-3G(3F)-repair which was listed as one of the WPS's on ZPMC repair order T-CWR55.

FCAW buttering welding of the bottom end of north tower, lift 1, skin E, shown on drawing # NSD1-SA10A/K.

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The welder was identified as 052075. 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 Li Peng Fei, who was not a CWI. The welding variables recorded by QC2 and QC2's assistant appeared to comply with WPS-345-FCAW-2G(2F)-repair which was listed as one of the WPS's on ZPMC repair order T-CWR33.

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 according to thickness of the thickest member being welded. Each QC 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
