

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-008865**Date Inspected:** 23-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:	Xu Yu Min, Chen Ying Xin	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
Bridge No:	34-0006	Delayed / Cancelled:	Yes	No	N/A
		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:

5AW/5BW, between panel points 31 and 32, 2 extreme north and south deck panel U-ribs – match drilling through 5BW deck panel U-ribs into inner doubler plates only.

1AAW, – FCAW welding after UT indication and excavation of weld joint deck plate to eighth I-rib from south end. Welder was identified as 220063. ZPMC QC was identified as CWI Xu Yu Min (QC1). This QA Inspector, George Goulet, observed an arc strike on the flange of the longitudinal beam at approximately 1625mm east of panel point 14 and informed QC1. QC1 made a record of it and ensured this QA Inspector, George Goulet, that he would have the area ground and MT performed. The welding variables recorded by QC1 appeared to comply with WPS-345-SMAW-4G(4F)-repair. Also at this location was ABF Representative Kelvin Cheung (ABF1). ABF1 also made a record of the arc strike and ensured this QA Inspector, George Goulet, that the area would be ground and MT performed. See photo below of arc strike in foreground and top of above noted flange above weld area.

1AW, panel point 8.5, west side, above south side panel – gouging removal of upper floor beam/deck panel diaphragm weld.

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5AE/5BE, panel points 31~32 – match drilling through 5BE decl panel U-ribs into inner splice plates only.

5BW/5CW south longitudinal diaphragm (LD) connection; 5BE/5CE north LD connection – misalignment of LD connections with jacking equipment in place. See photo below of 5BW/5CW south LD connection.

4AW, panel point 24 – sandblasting of deck panel U-rib area.

Bay 10

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

SMAW welding of weld joint NSTL3-3J/K-59 located in PCMK north tower shaft, lift 3, skin D at diaphragm 111.67. Welder was identified as 050038. ZPMC QC was identified as CWI Chen Ying Xin (QC2). The welding variables recorded by QC3 appeared to comply with WPS-345-SMAW-2G(2F)-repair.

FCAW welding of weld joint NSTL3-3B/K-82B located on PCMK north tower shaft, lift 3, skins B to C. Welder was identified as 050041. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2231-Tc-U5b-F.

FCAW welding of weld joint SSD1-FASA3-1C/E-7 located on PCMK south tower, lift 3, skin A. Welder was identified as 059244. ZPMC QC was identified as CWI Li Yang (QC3). Assisting QC3 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Shi Jing Wei, who was not a CWI. The welding variables recorded by QC3 and QC3's assistant appeared to comply with WPS-B-T-2332-Tc-P4-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 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

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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
