

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-008867**Date Inspected:** 25-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**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:** 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:

1AE/1AAE – FCAW welding after UT indication and excavation per ZPMC repair order B-WR7128 and drawing OBE1-004. Welder was identified as 045240. ZPMC QC was identified as CWI Xu Yu Min (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Pan Wen Long, who was not a CWI. The welding variables recorded by QC1 and QC1's assistant appeared to comply with WPS-345-FCAW-3G(3F)-repair.

3AW/FL3 , panel points 20~22 – sandblasting in the FL3 area.

5BE/5CE joint – FCAW fill pass welding of the bottom plate joint. Welders were identified as 053609 on the north side and 053742 on the south side. ZPMC QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Pan Wen Long, who was not a CWI. The welding variables recorded by QC1 and QC1's assistant appeared to comply with WPS-B-T-2231-T.

5BW/5CW joint – FCAW welding of the weld joint BP-138-001-020 at the bottom plate T-rib web. Welder was

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identified as 220067. ZPMC QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Pan Wen Long, who was not a CWI. The welding variables recorded by QC1 and QC1's assistant appeared to comply with WPS-B-T-2233-B-U2-F.

4AW/4BW – spray painting inside the segments.

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 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
