

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-009062**Date Inspected:** 31-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:	N/A	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.

Bay 11

This QA Inspector proceeded to the Bay 11 in response to a ZPMC notification of witness inspection #4118 for MT inspection of the following:

This QA Inspector performed random VT and 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 ESTL3-4B/K. The weld designation reviewed was 84A.

Trail Assembly Area

This QA Inspector attended a meeting with QA Inspector Mark Miller, ZPMC QA Wang Lu, and ABF Representative Kelvin Cheung (ABF) in segment 3BE. Items discussed were all related to the longitudinal diaphragm and floor beam cope hole size, shape, and degree of smoothness including the transition from weld metal to base metal in segments 3AE/3BE. All present agreed that the cope wholes needed work to be acceptable, especially for smoothness.

At approximately 0200 hours, this QA Inspector, George Goulet, proceeded to the trail assembly area in response to a call from ABF. This QA Inspector observed the smoothness and transition from weld metal to base metal in all 37 cope holes was not acceptable except in the one cope hole that had been used as a model in the earlier

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discussion with Mark Miller present. It appeared to this QA inspector that no work had been performed on the cope holes since before the earlier discussion when all parties involved in the conversation agreed that the current state of smoothness and transition of weld metal to base meatl was unacceptable.

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

Summary of Conversations:

No relevant conversations except as noted above.

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
