

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-009063**Date Inspected:** 01-Sep-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 Jia, Zhan Bo**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.

OBG Trial Assembly Area

This QA Inspector randomly observed the following work in progress in the trial assembly area:

1AW, east of panel point 9, bottom plate – ZPMC performing SMAW plug welds on misplaced drilled holes. Welder was identified as 220063. ZPMC QC was identified as CWI Li Jia (QC1) by ZPMC QC Inspector Feng Ya Jun. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Feng Ya Jun, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-345-FCAW-1G-repair-misplaced hole listed on ZPMC Repair Order B-WR7178 presented to this QA Inspector, George Goulet, by ZPMC QC Inspector Feng Ya Jun.

1AW, panel point 11.5 - ABF performing MT at the upper floor beam web to upper flange welds.

1AE, panel points 9, 10 - ABF performing MT at the upper floor beam web to upper flange welds.

5AW, panel point 29, ABF performing MT at the upper floor beam web to upper flange welds.

4BW, east of panel point 28 – ZPMC performing SMAW welding to holdback welds SP012-001-042, T-rib stiffener to side plate joint on segment 4BW. This QA Inspector, George Goulet, also observed ZPMC personnel

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performing SMAW welding under the same or similar conditions on the following hold back welds in the same area: SP020-001-025, SP020-001-027, SP028-001-027, SP028-001-033, BP019-001-025, BP019-001-029.

This QA Inspector observed that no ZPMC CWI or other QC inspector was present during the welding operations at OBG segment 4BW during the time that this QA Inspector, George Goulet, was present from 2145 to 2225, during which time the welding occurred.

This QA Inspector observed a 140 degree Celsius Tempstick mark placed within approximately 50mm from the point of welding did not melt when applied to the adjacent base material.

This QA Inspector generated an incident report concerning the above noted issues.

Bay 11

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

SMAW welding of weld joint WSTL3-4B/K-83B located on west tower, lift 3. Welder was identified as 047470. ZPMC QC was identified as CWI Zhan Bo (QC2). The welding variables recorded by QC2 appeared to comply with WPS-345-SMAW-2G(2F)-repair listed on ZPMC Repair Order T-WR 2047.

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

Summary of Conversations:

No relevant conversations.

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
