

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-009176**Date Inspected:** 09-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:	Liu Zhong An, Li Hong Fei	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 and 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.

Trial Assembly Area

This QA Inspector randomly observed the following in response to ZPMC Bolting Inspection Notification Sheet No. 000147:

Segment 4BW/FL3, panel points 26~28 – 3 floor beam to the south side panel connections, 12 bolts each:

ZPMC workers attempted to perform final bolt tightening verification at the direction of ZPMC QC Inspector Shen Jian Bo (QC1) using ZPMC calibrated wrench #XO-584. However, the wrench would not fit onto 3 of the 12 bolts on each of the 3 connections. This QA Inspector spoke by phone to ZPMC QA Lei Tao who cancelled the inspection.

Bay 10

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

SMAW welding of weld joint NSD1-FASA4-1B/E-5-21 located on north tower, lift 4, skin A. Welder was identified as 060038. ZPMC QC was identified as CWI Liu Zhong An (QC1). The welding variables recorded by QC1 appeared to comply with WPS-B-P-2213.

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SMAW welding of weld joint NSD1-FASA4-1B/E-3-21 located on north tower, lift 4, skin A. Welder was identified as 053829. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-P-2213.

SMAW welding of weld joint NSD1-FASA4-1B/E-1-20 located on north tower, lift 4, skin A. Welder was identified as 040582. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-P-2213.

SMAW welding of weld joint NSD1-FESA4-3C/F-3-21 located on north tower, lift 4, skin E. Welders were identified as 052892, 057186. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-P-4312-TC-P4.

FCAW welding of weld joint NSD1-SPSA3-66-2A located on north tower, lift 3. Welder was identified as 040343. 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 Yuan Hui Gang, who was not a CWI. The welding variables recorded by QC1 and QC1's assistant appeared to comply with WPS-B-T-2231-TC-U5-F.

SMAW welding of weld joints SSD1-FDSA4-1B/C-51, 52 located on south tower, lift 4, skin D. Welder was identified as 053829. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-345+485-SMAW-2G(2F)-repair.

SMAW welding of weld joints SSD1-FDSA4-1B/C-56, 57, 58 located on south tower, lift 4, skin D. Welder was identified as 040582. ZPMC QC's were identified as QC1 and CWI Li Hong Fei (QC2). The welding variables recorded by QC2 appeared to comply with WPS-345+485-SMAW-2G(2F)-repair.

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

Summary of Conversations:

No relevant conversations on this date 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 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
