

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-009179**Date Inspected:** 14-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
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: 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 10

This QA Inspector, George Goulet, proceeded to the OBG trial assembly area in response to the verbal request of Caltrans OSM Quality Assurance day shift personnel for MT inspection of the following:

This QA Inspector, George Goulet, performed VT and MT of approximately 15% of the tack welds 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 NSD1-FASA4-1A/E. The weld designation reviewed was 9.

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

FCAW welding of weld joint NSD1-FASA4-1A/E-8 located on north tower, lift 4, skin A, doubler plate. Welders were identified as 050041, 040338. ZPMC QC was identified as CWI Liu Zhong An (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Jiang Xiao Bo, who was not a CWI. The welding variables recorded by QC1 and QC1's assistant appeared to comply with WPS-B-T-4132. Also at this location and appearing to be monitoring the welding and recording data was ABF Representative Yang Yi Heng.

Bay 9

This QA Inspector, George Goulet, proceeded to Bay 9 in response to the request of day shift Caltrans OSM

WELDING INSPECTION REPORT

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Quality Assurance personnel for MT inspection of the following:

This QA Inspector, George Goulet, performed VT and MT of approximately 15% of the tack welds previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector, George Goulet, generated an MT report for this date. The members are identified as DP3004A-001, DP3045A-001. The weld designations reviewed were 001~010, 001~008 respectively.

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
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Reviewed By:	Carreon,Albert	QA Reviewer
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