

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-009815**Date Inspected:** 17-Oct-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:** See below**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 Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 11

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

FCAW welding of various pieces of 29 of strut plates with no specific weld numbers or PCMK. The quantities of specific plate numbers listed on ZPMC T-WR2467 were as follows: 20 – P1144, 5 – P1232, 2 – P170, P175. A layering technique was being used to add 10mm to 17mm to the ends of the plates per T-WR2467. Welders were identified as 046706, 049220. ZPMC QC was identified as CWI Li Lin (QC1). The welding variables recorded by QC1 appeared to comply with WPS-345-FCAW-2G(2F)-repair, also listed on T-WR2467.

FCAW welding of weld joint ED1-A435B/C-3-23 located on PCMK east tower, beam to plate. Welder was identified as 042218. 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 Xu Jin Long, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-T-2132.

FCAW welding of weld joint ED1-A435B/C-3-24 located on PCMK east tower, beam to plate. Welder was identified as 062126. 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 Xu Jin Long, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-T-2132.

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This QA Inspector observed 3 ABF representatives inside West tower, lift 2 performing magnetic particle testing of diaphragm to skin welds, diaphragm to fit lug welds, and fitlug to skin stiffener welds at diaphragms 53M, 56M, and 59M.

This QA Inspector observed ZPMC personnel performing match drilling of 30mm holes into skin plates C and D through doubler plates on both sides of the lift 1/lift2 joint on west tower. It appeared that the holes were being drilled only partially into the the skin plates.

Bay 10

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

FCAW repair welding of 600mm of weld joint NSTL3-3B/K-83A located on PCMK north tower, lift 3, at the 102M elevation. Welder was identified as 053870. ZPMC QC was identified as CWI Wang Chuan Qing (QC2). The welding variables recorded by QC2 appeared to comply with WPS-345-FCAW-1G(1F)-repair.

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 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:	Dawson,Paul	QA Reviewer
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