

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-010794**Date Inspected:** 05-Dec-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 10

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

SMAW welding of weld joints ND1-6002-18-37, 38 located on PCMK north tower, strut. Welder was identified as 040268. ZPMC QC was identified as CWI Gong Liang Zhu (QC1). The welding variables recorded by QC1 appeared to comply with WPS-B-T-2113 for weld 37 and WPS-B-T-4113-1 for weld 38.

SMAW welding of weld joints ND1-6002-18-39, 40 located on PCMK north tower, strut. Welder was identified as 040267. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2113 for weld 39 and WPS-B-T-4113-1 for weld 40.

SMAW repair welding of weld joint NSD1-TL5-3C-F-9A located on PCMK north tower, lift 5. Welder was identified as 056200. ZPMC QC was identified as QC1. The welding variables recorded by QC appeared to comply with WPS-485-SMAW-1G(1F)-repair per the ZPMC repair order presented to this inspector by QC1. The repair order had no repair order number.

SMAW welding of weld joint NSTL4-3L/L-3B located inside PCMK north tower, lift 4, skin B to skin C between 143M double diaphragm and the top end of lift 4. Welder was identified as 050289. ZPMC QC was identified as

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CWI Tu Jun (QC2). The welding variables recorded by QC2 appeared to comply with WPS-B-T-3212-TC-U4b-1.

FCAW welding of weld joint NSTL4-3K/L-111 located inside PCMK north tower, lift 4, skin A, stiffener to top of 143M double diaphragm. Welder was identified as 052075. ZPMC QC was identified as QC2. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Wang Hao, who was not a CWI. The welding variables recorded by QC2 's assistant appeared to comply with WPS-B-T-4333-P4-F.

FCAW welding of weld joints NSTL4-3H/L-48, 38 located inside PCMK north tower, lift 4, skin A, stiffener to bottom of 143M double diaphragm. Welder was identified as 050041. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Wang Hao, who was not a CWI. The welding variables recorded by QC2 's assistant appeared to comply with WPS-B-T-4333-P4-F.

FCAW welding of weld joint NSTL4-3F/L-41 located inside PCMK north tower, lift 4, skin A, stiffener to 123M double diaphragm. Welder was identified as 054069. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Wang Hao, who was not a CWI. The welding variables recorded by QC2 's assistant appeared to comply with WPS-B-T-4333-P4-F.

FCAW welding of weld joint NSTL4-3F/L-51 located inside PCMK north tower, lift 4, skin A, stiffener to 123M double diaphragm. Welder was identified as 053116. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Wang Hao, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-4333-P4-F.

SMAW welding of temporary connection plates to skin E at the bottom of PCMK north tower, lift 1. Welder was identified as 040581. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC Gao Zhi Chun, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2114.

SMAW welding of temporary connection plates to skin A at the bottom of PCMK north tower, lift 1. Welder was identified as 040280. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC Gao Zhi Chun, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2114.

FCAW welding of temporary connection plates to skin D at the bottom of PCMK north tower, lift 1. Welder was identified as 201825. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC Gao Zhi Chun, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2132 and WPS-B-T-2133. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Xiao Jun Peng.

Bay 11

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

SMAW tack welding of backing plates to one end of PCMK west tower, lift 2/3 splice plate, skin B. Welder was identified as 053310. ZPMC QC was identified as CWI You Qi Guo (QC3). Assisting QC3 at this location and

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appearing to be monitoring the welding and recording data was ZPMC Shao Hai Long, who was not a CWI. The welding variables recorded by QC3's assistant appeared to comply with WPS-B-T-2112. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Luo Lai Quan.

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

Summary of Conversations:

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:	Dawson,Paul	QA Reviewer
