

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-010910**Date Inspected:** 13-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:

FCAW welding of weld joint NSTL4-3C/L-36 located inside PCMK north tower, lift 4, skin E to 119M double diaphragm web. Welder was identified as 052075. ZPMC QC was identified as CWI Wang Chuan Qing (QC1). The welding variables recorded by QC1 appeared to comply with WPS-B-T-4132.

FCAW welding of weld joint NSTL4-3F/L-27 located inside PCMK north tower, lift 4, skin E to 123M double diaphragm web. Welder was identified as 053116. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-4132.

FCAW welding of weld joint NSTL4-3K/L-27 located inside PCMK north tower, lift 4, skin E to 143M double diaphragm web. Welder was identified as 054069. ZPMC QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC Wang Hao, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-T-4132.

FCAW welding of weld joint NSTL4-3J/L-26 located inside PCMK north tower, lift 4, skin E to 139M double diaphragm web. Welder was identified as 201825. ZPMC QC was identified as QC1. Assisting QC1 at this

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

location and appearing to be monitoring the welding and recording data was ZPMC Wang Hao, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-T-4132.

FCAW welding of weld joints NSTL4-3I/L-26, NSTL-4-3H/L-26 located inside PCMK north tower, lift 4, skin E to 131M double diaphragm web. Welder was identified as 053869. ZPMC QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC Wang Hao, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-T-4132.

SAW welding of weld joint NSTL4-3B/L-4A located outside PCMK north tower, lift 4, skin A to skin B, between approximately 114.5M and 120M elevation. Welder was identified as 051413. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2221-C-U2b-S-2. Also at this location and appearing to be monitoring the welding operation were ABF Representatives Li Nan and Liu Cheng.

SAW welding of weld joint NSTL4-3B/L-4A located outside PCMK north tower, lift 4, skin A to skin B, between approximately 129M and 136M elevation. Welder was identified as 207745. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2221-C-U2b-S-2. Also at this location and appearing to be monitoring the welding operation were ABF Representatives Li Nan and Liu Cheng.

SAW welding of weld joint NSTL4-3B/L-5A located outside PCMK north tower, lift 4, skin B to skin C, between approximately 122.5M and 129M elevation. Welder was identified as 0503060. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2221-C-U2b-S-2. Also at this location and appearing to be monitoring the welding operation were ABF Representatives Li Nan and Liu Cheng.

SAW welding of weld joint NSTL4-3B/L-5A located outside PCMK north tower, lift 4, skin B to skin C, between approximately 138M and 144M elevation. Welder was identified as 050295. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2221-C-U2b-S-2. Also at this location and appearing to be monitoring the welding operation were ABF Representatives Li Nan and Liu Cheng.

SAW welding of weld joint NSTL4-3B/L-3A located outside PCMK north tower, lift 4, skin B to skin C, between approximately 144M and 146M elevation. Welder was identified as 201750. ZPMC QC was identified as CWI Tu Jun (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-3221-C-U2b-S-2. Also at this location and appearing to be monitoring the welding operation was ABF Representative Li Nan.

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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Goulet,George	Quality Assurance Inspector
----------------------	---------------	-----------------------------

Reviewed By:	Dawson,Paul	QA Reviewer
---------------------	-------------	-------------