

**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-010922**Date Inspected:** 29-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 tack welding of temporary end plates the lower end of SSD1-TL5 located on PCMK south tower, lift 5, skin A. Welders were identified as 061938, 040324. ZPMC QC was identified as CWI Wang Chuan Qing (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC Jiang Xiao Bo, who was not a CWI. The root opening appeared to be 0 to 1mm at all locations observed. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-T-4112.

SMAW tack welding of temporary rotating fenders at the lower end, approximately 120M to 122M elevations of PCMK south tower, lift 5, at the skin B/C corner. Welder was identified as 053469. ZPMC QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC Yuan Hui Gang, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-P-2113, WPS-B-P-2114.

SAW welding of weld joint NSTL4-3B/L-3A located outside PCMK north tower, lift 4, skin A to skin E, between approximately 115M and 120M elevations. Welder was identified as 040489. 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 present at this

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location and appearing to be monitoring the welding operation was ABF Representative Li Nan.

SAW welding of weld joint NSTL4-3B/L-3A located outside PCMK north tower, lift 4, skin A to skin E, between approximately 122M and 129M elevations. 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 present at this location and appearing to be monitoring the welding operation was ABF Representative Li Nan.

SAW welding of weld joint NSTL4-3B/L-3A located outside PCMK north tower, lift 4, skin A to skin E, between approximately 129M and 136M elevations. 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 present at this location and appearing to be monitoring the welding operation was ABF Representative Li Nan.

SAW welding of weld joint NSTL4-3B/L-3A located outside PCMK north tower, lift 4, skin A to skin E, between approximately 138M and 144M elevations. Welder was identified as 209051. 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 present 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.

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<b>Inspected By:</b>	Goulet,George	Quality Assurance Inspector
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<b>Reviewed By:</b>	Dawson,Paul	QA Reviewer
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