

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-011076**Date Inspected:** 03-Jan-2010**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:

Drilling through previously pilot-scored holes into PCMK west tower, lift 2, skin plate A at 53M, 65M, and 77M double diaphragm doubler plates, from the outside in. No template was being used. ZPMC workers were also removing temporary alignment plates from the doubler plate at 65M double diaphragm on skin A.

Bay 10

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

SMAW welding of temporary alignment plates at top end of PCMK south tower, lift 2, skin D at the C/D corner. Welder was identified as 052889. ZPMC QC was identified as CWI Du Zhi Qun (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 welding variables recorded by QC1's assistant appeared to comply with WPS-B-T-2314-TC-P5. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Yang Ye Heng.

SMAW tack welding of weld joint SSSL4-1B/L-49 located inside PCMK south tower, lift 5, top of diagonal

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

corner plate at the skin B/C corner at 140M elevation. Welder was identified as 050038. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-345-SMAW-1G(1F)-repair. The root opening appeared to be 1mm or less at all observed locations.

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
Reviewed By:	Dawson, Paul	QA Reviewer
