

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-011077**Date Inspected:** 05-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 10

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

SMAW repair welding of of weld joint ED1-STSA3-2-109-2B located on PCMK east tower, lift 3, strut at the 109M elevation. Welder was identified as 057258. ZPMC QC was identified as CWI Li Lin (QC1). The welding variables recorded by QC1 appeared to comply with WPS-485-SMAW-2G(2F)-repair-1 listed on the unnumbered ZPMC repair order.

FCAW layered repair welding on the end of internal plate SPSA3-70 located on lift 3, skin D, internal splice plate. Welders were identified as 054069, 053116. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-345-FCAW-2G(2F)-repair listed on the unnumbered ZPMC repair order.

FCAW welding of weld joints SSSL4-1B/L-24, 20 located inside PCMK south tower, lift 4, skins C/D, top and bottom of diagonal corner plate at the 142M elevation. Welder was identified as 066477. ZPMC QC was identified as CWI Du Zhi Qun QC2. Assisting QC2 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 QC2's assistant appeared to comply with WPS-B-T-2331-TC-P4-2 for weld 24 and WPS-B-T-2332-TC-P4-F-2 for weld 20.

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FCAW welding of weld joints SSSL4-1B/L-49, 53 located inside PCMK south tower, lift 4, skins B/C, top and bottom of diagonal corner plate at the 141M elevation. Welder was identified as 068852. ZPMC QC was identified as QC2. Assisting QC2 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 QC2's assistant appeared to comply with WPS-B-T-2331-TC-P4-F-2 for weld 49 and WPS-B-T-2332-TC-P4-F-2 for weld 53.

FCAW welding of weld joints SSSL4-1B/L-49, 53 located inside PCMK south tower, lift 4, skins B/C, top and bottom of diagonal corner plate at the 137M elevation. Welder was identified as 068206. ZPMC QC was identified as QC2. Assisting QC2 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 QC2's assistant appeared to comply with WPS-B-T-2331-TC-P4-F-2 for weld 49 and WPS-B-T-2332-TC-P4-F-2 for weld 53.

FCAW welding of weld joints SSSL4-1B/L-24, 20 located inside PCMK south tower, lift 4, skins C/D, top and bottom of diagonal corner plate at the 139M elevation. Welder was identified as 067550. ZPMC QC was identified as QC2. Assisting QC2 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 QC2's assistant appeared to comply with WPS-B-T-2331-TC-P4-F-2 for weld 24 and WPS-B-T-2332-TC-P4-F-2 for weld 20.

FCAW welding of weld joints SSSL4-1B/L-49, 53 located inside PCMK south tower, lift 4, skins B/C, top and bottom of diagonal corner plate at the 133M elevation. 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 Wang Hao, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2331-TC-P4-F-2 for weld 49 and WPS-B-T-2332-TC-P4-F-2 for weld 53.

FCAW welding of weld joints SSSL4-1B/L-24, 20 located inside PCMK south tower, lift 4, skins C/D, top and bottom of diagonal corner plate at the 135M elevation. Welder was identified as 037873. ZPMC QC was identified as QC2. Assisting QC2 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 QC2's assistant appeared to comply with WPS-B-T-2331-TC-P4-F-2 for weld 24 and WPS-B-T-2332-TC-P4-F-2 for weld 20.

FCAW welding of weld joints SSSL4-1B/L-24, 20 located inside PCMK south tower, lift 4, skins C/D, top and bottom of diagonal corner plate at the 132M elevation. Welder was identified as 068916. ZPMC QC was identified as QC2. Assisting QC2 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 QC2's assistant appeared to comply with WPS-B-T-2331-TC-P4-F-2 for weld 24 and WPS-B-T-2332-TC-P4-F-2 for weld 20.

FCAW welding of weld joints SSSL4-1B/L-49, 53 located inside PCMK south tower, lift 4, skins B/C, top and bottom of diagonal corner plate at the 125M elevation. Welder was identified as 068864. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2331-TC-P4-F-2 for weld 49 and WPS-B-T-2332-TC-P4-F-2 for weld 53.

FCAW welding of weld joints SSSL4-1B/L-24, 20 located inside PCMK south tower, lift 4, skins C/D, top and bottom of diagonal corner plate at the 126M elevation. Welder was identified as 068919. ZPMC QC was

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Inspected By: Goulet, George

Quality Assurance Inspector

Reviewed By: Dawson, Paul

QA Reviewer