

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-011795**Date Inspected:** 08-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 and OBG 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:

Repair gouging of weld joint NSTL4-3B/L-3B located inside PCMK north tower, lift 4, between approximately 135M and 139M elevations. 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 Gao Zhi Chun, who was not a CWI. The gouging operation appeared to comply with the unnumbered ZPMC repair report.

ZPMC personnel drilling through previously drilled holes in PCMK north tower, lift 2, 65M double diaphragm doubler plate into skin A. No template was being used.

No other welding related work was being performed in Bay 10.

Bay 11

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

ZPMC personnel drilling through previously drilled holes in PCMK west tower, lift 2, 65M double diaphragm doubler plate into skin E. No template was being used. ABF Representative Luo Lai Quan was present and

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appeared to be monitoring the drilling operation.

No welding was being performed in Bay 11.

Blast Shop #1

This QA Inspector and Caltrans QA Inspectors Paul Dawson and Mike Hasler performed random visual inspections of the upper interior areas of OBG Segment 7CW from the segment seam at 7BW to panel point 53 as per ZPMC request number 2472. ZPMC had recently completed grit blasting of these areas and the steel surfaces were mostly free of rust oxide and other contaminants that had previously obscured portions of the plate and weld surfaces. This QA Inspector visually observed approximately 30 locations that required grinding to resolve visual weld spatter, arc strikes, shallow nicks, scrapes, and other minor surface rejections. The areas were marked with colored chalk and ZPMC had several workers using grinders to remove the visually unacceptable areas and ZPMC had assigned a magnetic particle test (MT) inspector to perform MT of the arc strike removal areas upon completion of grinding the area marked. The obvious arc strikes were marked for grinding and MT.

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 Skyler Guest, 150-0042-2360, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet,George	Quality Assurance Inspector
Reviewed By:	Dawson,Paul	QA Reviewer
