

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-011796**Date Inspected:** 10-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:

SMAW repair welding of weld joint WSTL4-2B/L-57A located outside PCMK west tower, lift 4, skins C/D corner, approximately 200mm long at 138M elevation. Welder was identified as 058026. ZPMC QC was identified as CWI Li Lin (QC1). The welding variables recorded by QC1 appeared to comply with WPS-345-SMAW-2G(2F)-repair listed on the unnumbered ZPMC repair order. The location being repaired, per QC1, was listed as Y=23870 on ZPMC repair report T-WR2977. Also present at this location and appearing to be monitoring the welding related operations was ABF Representative Luo Lai Quan.

ZPMC personnel installing temporary staging located outside PCMK west tower, lift 2, skin A, at 53M and 77M double diaphragm areas. It appeared the staging was being attached to the diaphragm struts using temporary bolt sets.

Bay 10

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

SMAW repair welding of weld joint NSTL4-3B/L-3B located inside PCMK north tower, lift 4, skins A/E corner,

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approximately 325mm long at 135M elevation. Welder was identified as 050289. ZPMC QC was identified as CWI Wang Chuan Qing (QC2). The welding variables recorded by QC2 appeared to comply with WPS-345-SMAW-2G(2F)-repair listed on the unnumbered ZPMC repair order. Also present at this location and appearing to be monitoring the welding related operations were ABF Representatives Zhang Qin Jian and Yang Ye Heng.

SMAW repair welding of weld joint NSTL4-3B/L-5B located inside PCMK north tower, lift 4,skins B/C corner, approximately 600mm long at 131.5M elevation. Welder was identified as 052930. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-345-SMAW-2G(2F)-repair listed on the unnumbered ZPMC repair order. Also present at this location and appearing to be monitoring the welding related operations were ABF Representatives Zhang Qin Jian and Yang Ye Heng.

SMAW repair welding of weld joint SSTL4-1B/L-24 located inside PCMK south tower, lift 4,skins C/D corner, at approximately 142.5M elevation. Welder was identified as 050038. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-345-SMAW-2G(2F)-repair listed on the unnumbered ZPMC repair order. Also present at this location and appearing to be monitoring the welding related operations were ABF Representatives Zhang Qin Jian and Yang Ye Heng.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted above.

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
