

**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-011854**Date Inspected:** 17-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 (QA 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 weld joints NSTL4-3C/L-106, 113 located inside PCMK north tower, lift 4, skin A at 119M double diaphragm to skin stiffener. Welder was identified as 040581. ZPMC QC was identified as CWI Du Zhi Qun (QC1). The welding variables recorded by QC1 appeared to comply with WPS-345+485-SMAW-4G(4F)-repair. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Li Nan.

SMAW repair welding of weld joint NSTL4-3C/L-109 located inside PCMK north tower, lift 4, skin A at 119M double diaphragm to fit lug. Welder was identified as 040581. ZPMC QC was identified as CWI Du Zhi Qun (QC1). The welding variables recorded by QC1 appeared to comply with WPS-345+485-SMAW-4G(4F)-repair. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Li Nan.

SMAW repair welding of weld joints NSTL4-3C/L-123 located inside PCMK north tower, lift 4, skin B at 119M double diaphragm, fit lug to skin stiffener. Welder was identified as 050038. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-345-SMAW-4G(4F)-repair. Also present

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

SMAW repair welding of weld joints NSTL4-3C/L-128 located inside PCMK north tower, lift 4, skin C at 119M double diaphragm to skin stiffener. Welder was identified as 050038. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-345+485-SMAW-4G(4F)-repair. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Li Nan.

SMAW repair welding of weld joint NSTL4-3B/L-1B located inside PCMK north tower, lift 4, skins C/D corner at 123M elevation. Welder was identified as 057220. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-345-SMAW-2G(2F)-repair as listed on ZPMC welding repair report T-CWR533.

FCAW repair welding of weld joint NSTL4-3B/L-1B located inside PCMK north tower, lift 4, skins C/D corner at 127M elevation. Welder was identified as 040261. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-345-FCAW-2G(2F)-repair as listed on ZPMC welding repair report T-CWR533.

## Bay 11

This QA Inspector randomly observed no welding work being performed in Bay 11.

## Heavy Dock

This QA Inspector randomly observed the following work in progress on the Heavy Dock:

FCAW welding of weld joint WSD1-SA279-27 located outside PCMK west tower, lift 1, skin B, external base stiffener. Welder was identified as 040759. ZPMC QC was identified as CWI Gong Liang Zhu (QC2). The welding variables recorded by QC2 appeared to comply with WPS-B-T-2333-TC-P4-F.

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.

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

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