

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-012028**Date Inspected:** 19-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 joint NSTL4-3B/L-2A located inside PCMK north tower, lift 4, skins D/E corner, at 130M to 132M. Welder was identified as 056200. 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 QC Lu Wei Chao, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-345-SMAW-2G(2F)-repair. QC1 informed this QA Inspector that these repairs were in response to ultrasonic testing (UT) indications observed during UT performed by ZPMC technicians.

SMAW repair welding of weld joint SSSL4-1L/L-5B located inside PCMK south tower, lift 4, skins B/C corner, various small repair areas from 144M to 146M elevations. Welder was identified as 053829. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-485-SMAW-2G(2F)-repair-1. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Li Nan.

SMAW repair welding of weld joint SSSL4-1B/L-3B located inside PCMK south tower, lift 4, at 142M elevation. Welder was identified as 052493. ZPMC QC was identified as QC1. The welding variables recorded by QC1

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appeared to comply with WPS-345-SMAW-2G(2F)-repair-1. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Li Nan.

ABF technicians performing magnetic particle testing of weld joints SSSL4-1B/L-49,53 inside PCMK south tower, lift 4, skins B/C corner angle plate between 119M and 123M elevations.

Bay 11

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

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
