

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-012029**Date Inspected:** 20-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:

SMAW repair welding of weld joint SSSL4-1B/L-3B located inside PCMK south tower, lift 4, skins A/E corner at various locations from 143M to 139M. Welder was identified as 050038. ZPMC QC was identified as CWI Gong Liang Zhu (QC1). The welding variables recorded by QC1 appeared to comply with WPS-345-SMAW-2G(2F)-repair. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Li Nan.

Bay 11

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

ZPMC technicians performing magnetic particle testing (MT) in PCMK east tower, lift 4, skin A at 139M and 143M double diaphragms to fit lugs and fit lugs to stiffeners.

No welding work was observed being performed in Bay 11.

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Heavy Dock

No welding work was observed being performed on the Heavy Dock.

Yard, North of OBG Bay 14

ZPMC issued Inspection Notification Sheet number 01202010-1 informing this QA Inspector that ZPMC had completed visual inspections (VT) and magnetic particle inspections (MT) of OBG segment 5W bottom plate to side plate welds SEG023A-005 and SEG025A-008. This QA Inspector performed random VT and MT of the above noted welds from Y=1200 to Y=3200. No apparent indications were observed. The welds listed above appear to comply with AWS D1.5 MT requirements.

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

Summary of Conversations:

No significant 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
