

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-012295**Date Inspected:** 03-Feb-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 (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:

FCAW welding of weld joint SSSL4-1G/L-99 located inside PCMK south tower, lift 4, skin E to corner closure plate at top of 127M double diaphragm. Welder was identified as 040302. ZPMC QC was identified as CWI Liu Zhong An (QC1). The welding variables recorded by QC1 appeared to comply with WPS-B-T-4333-TC-P4-F. Also present at this location and appearing to be monitoring the welding related operations was ABF Representative Li Nan.

SMAW welding of weld joint SSSL4-1H/L-131 located inside PCMK south tower, lift 4, skin E to corner closure plate at top of 131M double diaphragm. Welder was identified as 057220. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-3213-B-U2a. Also present at this location and appearing to be monitoring the welding related operations was ABF Representative Li Nan.

SMAW repair welding of weld joint SSSL4-1K/L-8 located inside PCMK south tower, lift 4, skin D to 143M double diaphragm. Welder was identified as 040581. ZPMC QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC Deng Zhi Bin, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

WPS-345+485-SMAW-4G(4F)-repair-2. Also present at this location and appearing to be monitoring the welding related operations was ABF Representative Li Nan.

SMAW repair welding of weld joints SSTL4-1J/L-77, 79 located inside PCMK south tower, lift 4, skin D to 139M double diaphragm and fit lug to 139M double diaphragm, respectively. Welder was identified as 040581. ZPMC QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC Deng Zhi Bin, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-345+485-SMAW-4G(4F)-repair-2. Also present at this location and appearing to be monitoring the welding related operations was ABF Representative Li Nan.

Bay 11

No welding was observed being performed in Bay 11.

Blast Shop #1

This QA Inspector and Caltrans QA Inspector Shrikant Utekar proceeded to Blast Shop 1 to perform random visual inspections of the entire floor areas of OBG Segment 7EW in response to receiving ZPMC request number 2610. ZPMC QC Guo Wan Li (QC) and ABF Representatives Shi Zhao Yuan, Jiang Huan, Liu Song, and Sheng Qing Quan (ABF) were present and informed this QA Inspector that they had rejected the initial grit blasting of these areas and the steel surfaces because they were not free of rust oxide and other contaminants that was obscuring portions of the plate and weld surfaces. This QA Inspector and Caltrans QA Inspector Shrikant Utekar observed condition of steel surfaces over large portions of floor areas as noted above and concurred with QC and ABF to reject the original blast inspection.

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
