

**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-012624**Date Inspected:** 27-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:

SMAW welding of weld joint SSD1-TL5-1B-F-39B located inside PCMK south tower, lift 5. Welder was identified as 052930. ZPMC QC was identified as Gong Liang Zhu (QC1). The welding variables recorded by QC1 appeared to comply with WPS-B-T-3211-TC-U4b-1. Also present at this location and appearing to be monitoring the welding related operations was ABF Representatives Zhang Qin Jian and Yang Ye Heng.

SMAW repair welding of weld joints NSTL4-3K/L-146, 63, 64 located inside PCMK north tower, lift 4, skin C, bottom of 143M double diaphragm. Welder was identified as 053049. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-345+485-SMAW-2G(2F)-repair-2 and WPS-345+485-SMAW-3G(3F)-repair-2.

**Bay 11**

No welding related work was observed being performed in Bay 11.

**Heavy Dock**

This QA Inspector randomly observed the following work in progress on the heavy dock:

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# WELDING INSPECTION REPORT

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SMAW repair welding of weld joints NSD1-SA11-14 located inside PCMK north tower, lift 1, skin B. Welder was identified as 500363. ZPMC QC was identified as CWI Zhao Chen Sun (QC2). Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Liu Zhi, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-345-SMAW-3G(3F)-repair.

SMAW repair welding of weld joints NSD1-SA17F/G-10 located inside PCMK north tower, lift 1, skin E. Welder was identified as 500373. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Liu Zhi, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-345-SMAW-3G(3F)-repair.

The tower access elevator was not manned after 2100 hours and it appeared that no work was being performed at the lift1/ lift 2 joints of either of the towers.

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.

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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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