

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-012657**Date Inspected:** 12-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2400**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 repair welding of weld joint NSTL4-3B/L-2A located outside PCMK north tower, lift 4, skins D/E corner.

Welder was identified as 500363. ZPMC QC was identified as Di Zhi Qun (QC1). The welding variables recorded by QC1 appeared to comply with WPS-345-SMAW-2G(2F)-repair listed on ZPMC repair document T-WR3068.

SAW welding of weld joint SSD1-TL5-1B/F-24B located outside PCMK south tower, lift 5. Welder was identified as 201750. ZPMC QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC Yu Zhi Lai, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-T-3221-C-U2b-S. Also present at this location and appearing to be monitoring the welding related operations was ABF Representative Hu Gui Hua.

Bay 11

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

Heavy Dock

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

FCAW welding of weld joint WSD1-SA653D/F-9 located outside PCMK west tower, lift 1 base, skin A, shear plate stiffener to connection plate. Welder was identified as 070022. ZPMC QC was identified as CWI You Qi Guo (QC2). Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC He Gen, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2333-TC-P4-F. Also present at this location and appearing to be monitoring the welding related operations were ABF Representatives Kong Xian Hui and Kang Yi.

FCAW welding of weld joint WSD1-SA279-31 located outside PCMK west tower, lift 1 base, skin B, shear plate stiffener to connection plate. Welder was identified as 068918. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC He Gen, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2333-TC-P4-F. Also present at this location and appearing to be monitoring the welding related operations were ABF Representatives Kong Xian Hui and Kang Yi.

FCAW welding of weld joint WSD1-SA279-19 located outside PCMK west tower, lift 1 base, skin B, shear plate stiffener to connection plate. Welder was identified as 068919. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC He Gen, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2333-TC-P4-F. Also present at this location and appearing to be monitoring the welding related operations were ABF Representatives Kong Xian Hui and Kang Yi.

FCAW welding of weld joint ESD1-SA233-20 located outside PCMK east tower, lift 1 base, skin B, shear plate stiffener to connection plate. Welder was identified as 066484. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC He Gen, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2333-TC-P4-F. Also present at this location and appearing to be monitoring the welding related operations were ABF Representatives Kong Xian Hui and Kang Yi.

FCAW welding of weld joint ESD1-SA233-33 located outside PCMK east tower, lift 1 base, skin B, shear plate stiffener to connection plate. Welder was identified as 068206. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC He Gen, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2333-TC-P4-F. Also present at this location and appearing to be monitoring the welding related operations were ABF Representatives Kong Xian Hui and Kang Yi.

FCAW welding of weld joint SSD1-SA17F/G-54 located outside PCMK south tower, lift 1 base, skin C, shear plate stiffener to connection plate. Welder was identified as 054069. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC He Gen, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2333-TC-P4-F. Also present at this location and appearing to be monitoring the welding related operations were ABF Representatives Kong Xian Hui and Kang Yi.

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FCAW welding of weld joint SSD1-SA40B/E-49 located outside PCMK south tower, lift 1 base, skin D, shear plate stiffener to connection plate. Welder was identified as 057244. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC He Gen, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2333-TC-P4-F. Also present at this location and appearing to be monitoring the welding related operations were ABF Representatives Kong Xian Hui and Kang Yi.

FCAW welding of weld joint ESD1-SA227F/H-3 located outside PCMK east tower, lift 1 base, skin E, shear plate stiffener to connection plate. Welder was identified as 066481. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC He Gen, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2333-TC-P4-F. Also present at this location and appearing to be monitoring the welding related operations were ABF Representatives Kong Xian Hui and Kang Yi.

FCAW welding of weld joint ESD1-SA227F/H-9 located outside PCMK east tower, lift 1 base, skin E, shear plate stiffener to connection plate. Welder was identified as 059525. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC He Gen, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2333-TC-P4-F. Also present at this location and appearing to be monitoring the welding related operations were ABF Representatives Kong Xian Hui and Kang Yi.

FCAW welding of weld joint SSD1-SA18-28 located outside PCMK south tower, lift 1 base, skin B, shear plate stiffener to connection plate. Welder was identified as 053869. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC He Gen, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2333-TC-P4-F. Also present at this location and appearing to be monitoring the welding related operations were ABF Representatives Kong Xian Hui and Kang Yi.

FCAW welding of weld joint SSD1-SA18-23 located outside PCMK south tower, lift 1 base, skin B, shear plate stiffener to connection plate. Welder was identified as 040533. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC He Gen, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2333-TC-P4-F. Also present at this location and appearing to be monitoring the welding related operations were ABF Representatives Kong Xian Hui and Kang Yi.

OBG segment 5E was located near the end of the heavy dock. No work was observed being performed on OBG segment 5E.

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

Summary of Conversations:

No significant conversations.

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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
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Reviewed By:	Dawson,Paul	QA Reviewer
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