

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-012889**Date Inspected:** 07-Mar-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 11

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

SMAW layered repair welding noted as drawing number P169 and PCMK east tower, lift 1, strut plate on ZPMC repair order T-WR3085. Welder was identified as 040655. QC was identified as ZPMC CWI Xu Le Feng (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Li Jun, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-345-SMAW-2G(2F)-repair.

SMAW welding of weld joints ND1-SA4-68-143M-8-1A, ND1-SA4-68-143M-7-1A located on PCMK north tower, lift 4, shear assembly. Welder was identified as 041271. ZPMC QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Li Jun, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-T-3211-TC-U5b-1.

Bay 10

This QA Inspector randomly observed the following work in progress in Bay 10:

SMAW layered repair welding noted as drawing number TD5-9 and PCMK's south tower and west tower, lift 5,

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

stiffener plates on ZPMC repair order T-WR3083. Welders were identified as 040582 and 052930 on SSD1-TL5-1A-F-TD5-9 and 500363 and 500373 on SSD1-TL5-3A-F-TD5-9. QC was identified as ZPMC CWI Du Zhi Qun (QC2). Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Yu Zhi Lai, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-345-SMAW-2G(2F)-repair-1.

SMAW layered repair welding noted as drawing number ED1-A27 and PCMK east tower, stiffener plate on ZPMC the unnumbered repair order. Welder was identified as 053116. QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-345-SMAW-2G(2F)-repair. Also present at this location and appearing to be monitoring the welding related operations was ABF Representative Xie Yan.

Heavy Dock

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

FCAW welding of weld joint SSD1-SA15D/F-9 located on PCMK south tower, lift 1 base, skin A, shear plate stiffener to connection plate. Welder was identified as 053869. QC was identified as ZPMC CWI You Qi Guo (QC3). 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.

FCAW welding of weld joint SSD1-SA17F/G-84 located on PCMK south tower, lift 1 base, skin C, shear plate stiffener to connection plate. Welder was identified as 053870. QC was identified as QC3. Assisting QC3 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 QC3's assistant appeared to comply with WPS-B-T-2333-TC-P4-F.

FCAW welding of weld joint ESD1-SA296B/E-13 located on PCMK east tower, lift 1 base, skin D, shear plate stiffener to connection plate. Welder was identified as 040713. QC was identified as QC3. Assisting QC3 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 QC3's assistant appeared to comply with WPS-B-T-2333-TC-P4-F.

FCAW welding of weld joint WSD1-SA295B/E-22 located on PCMK west tower, lift 1 base, skin D, shear plate stiffener to connection plate. Welder was identified as 040723. QC was identified as QC3. The welding variables recorded by QC appeared to comply with WPS-B-T-2333-TC-P4-F.

FCAW welding of weld joint WSD1-SA225F/H-40 located on PCMK west tower, lift 1 base, skin D, shear plate stiffener to connection plate. Welder was identified as 040759. QC was identified as QC3. The welding variables recorded by QC appeared to comply with WPS-B-T-2333-TC-P4-F.

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

Summary of Conversations:

No significant conversations.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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 |
