

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-012962**Date Inspected:** 08-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:

Flame heat straightening of plate assembly marked as P131B/P1850B. 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 Shao Hai Lang, who was not a CWI. ZPMC QC Shao Hai Lang presented the document shown below displaying no documentation number and no Caltrans approval. AWS D1.5/2002 Section 3.7.3 states "Members distorted by welding shall be heat straightened by mechanical means or by carefully supervised application of a limited amount of localized heat as approved by the engineer." This QA Inspector generated a Caltrans Incident Report concerning this issue. Also present at this location and appearing to be monitoring the welding related operations was ABF Representative Lou Lai Quan. This QA Inspector notified ZPMC QC Shao Hai Long and ABF Representative Lou Lai Quan of the above noted Caltrans Incident Report.

SMAW welding of weld joints WD1-SA4-56-123M-1-1A, WD1-SA4-56-123M-2-1A located on PCMK west tower, lift 4, shear link. Welder was identified as 041271. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Mao Bing Bing, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-T-3211-TC-U5b-1. Also present at this location and appearing to be monitoring the welding related

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operations was ABF Representative Xie Yan.

SMAW welding of weld joints WD1-SA4-56-123M-3-1A, WD1-SA4-56-123M-4-1A located on PCMK west tower, lift 4, shear link. Welder was identified as 040667. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Mao Bing Bing, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-T-3211-TC-U5b-1. Also present at this location and appearing to be monitoring the welding related operations was ABF Representative Xie Yan.

QC1 was not observed by this QA Inspector at either of the above locations or anywhere else in Bay 11.

Bay 10

This QA Inspector randomly observed no apparent welding work in progress in Bay 10.

Heavy Dock

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

FCAW welding of weld joint WSD1-S295DB/E-22 located outside PCMK west tower, lift 1 base, skin D, shear plate stiffener to connection plate. Welder was identified as 040723. QC was identified as ZPMC CWI You Qi Guo (QC2). The welding variables recorded by QC2 appeared to comply with WPS-B-T-2333-TC-P4-F.

FCAW welding of weld joint WSD1-S225DF/H-43 located outside PCMK west tower, lift 1 base, skin E, shear plate stiffener to connection plate. Welder was identified as 040759. QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2333-TC-P4-F.

FCAW welding of weld joint SSD1-SA17F/G-84 located outside PCMK south tower, lift 1 base, skin C, shear plate stiffener to connection plate. Welder was identified as 053870. 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.

FCAW welding of weld joint SSD1-SA17F/G-74 located outside PCMK south tower, lift 1 base, skin C, shear plate stiffener to connection plate. Welder was identified as 057244. 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.

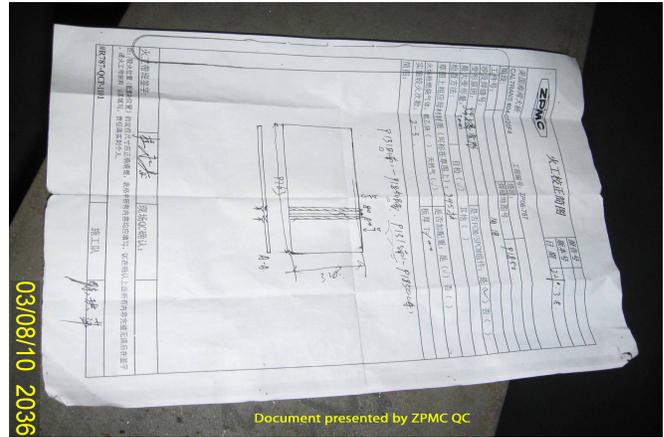
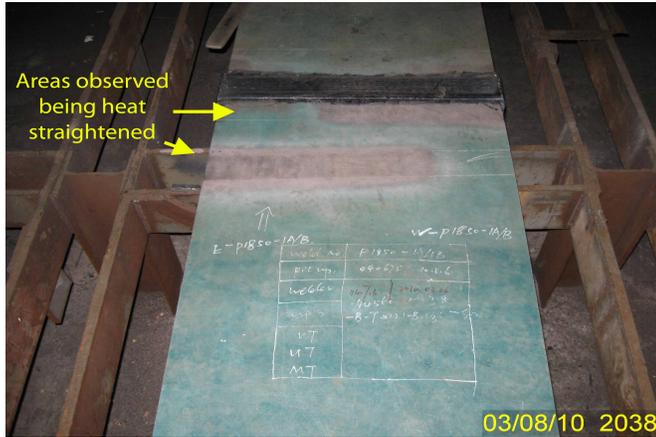
FCAW welding of weld joint SSD1-SA18-34 located outside PCMK south tower, lift 1 base, skin B, shear plate stiffener to connection plate. Welder was identified as 053869. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC 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.

The tower trial assembly elevator appeared to be dark and inoperative.

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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