

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-013429**Date Inspected:** 28-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 10

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

SMAW repair welding of base metal up to 7mm deep at several locations determined by ZPMC visual inspection (VT) on PCMK north tower, lift 4, skin C. Welder was identified as 056200. QC was identified as ZPMC CWI Du Zhi Qun (QC1). The welding variables recorded by QC1 appeared to comply with WPS-345-SMAW-2G(2F)-repair and WPS-345-SMAW-3G(3F)-repair as listed on ZPMC repair order T-WR3103.

Also present at this location and appearing to be monitoring the welding related operation was ABF Representative Li Nan.

Heavy Dock

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

FCAW welding of weld joint NSD1-A112A/H-1 located outside PCMK north tower, lift 1 base, skins B/C corner to shear plate stiffener. Welders were identified as 068753, 066398. QC was identified as ZPMC CWI Gong Liang Zhu (QC2). The welding variables recorded by QC2 appeared to comply with WPS-B-T-2333-TC-P4-F.

FCAW welding of weld joint NSD1-A112A/H-2 located outside PCMK north tower, lift 1 base, skins B/C corner

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

to shear plate stiffener. Welders were identified as 068765, 068916. 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 NSD1-A112A/H-3B located outside PCMK north tower, lift 1 base, skins B/C corner, shear plate stiffener. Welder was identified as 066359. QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2333-TC-U5-F.

FCAW welding of weld joint ESD1-A167A/H-8B located outside PCMK east tower, lift 1 base, skins B/C corner to shear plate stiffener. Welder was identified as 040367. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Yang Mingming, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2333-TC-U5-F.

FCAW welding of weld joint WSD1-SA294F/G-42 located outside PCMK north tower, lift 1 base, skin C, shear plate stiffener to connection plate. Welder was identified as 040723. 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 ESD1-A167A/H-6 located outside PCMK east tower, lift 1 base, skins B/C corner to shear plate stiffener. Welders were identified as 067993, 040349. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Yang Mingming, 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 ESD1-A167A/H-7 located outside PCMK east tower, lift 1 base, skins B/C corner to shear plate stiffener. Welders were identified as 037907, 066825. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Yang Mingming, 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 ESD1-SA296B/E-33 located outside PCMK east tower, lift 1 base, skin D, shear plate stiffener to connection plate. Welder was identified as 070022. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Yang Mingming, 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 ESD1-SA296B/E-15 located outside PCMK east tower, lift 1 base, skin D, shear plate stiffener to connection plate. Welder was identified as 066155. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Yang Mingming, 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-SA40B/E-42 located outside PCMK south tower, lift 1 base, skin D, shear plate stiffener to connection plate. Welder was identified as 066788. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Yang Mingming,

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

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-SA16F/G-58 located outside PCMK south tower, lift 1 base, skin E, shear plate stiffener to connection plate. Welder was identified as 066401. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Yang Mingming, 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-SA16F/G-52 located outside PCMK south tower, lift 1 base, skin E, shear plate stiffener to connection plate. Welder was identified as 053116. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Yang Mingming, 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 ESD1-SA227F/H-36 located outside PCMK east tower, lift 1 base, skin E, shear plate stiffener to connection plate. Welder was identified as 068206. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Yang Mingming, 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 ESD1-SA227F/H-51 located outside PCMK east tower, lift 1 base, skin E, shear plate stiffener to connection plate. Welder was identified as 068923. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Yang Mingming, 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 ESD1-SA294F/G-70 located outside PCMK east tower, lift 1 base, skin C, shear plate stiffener to connection plate. Welder was identified as 068494. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Yang Mingming, 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 NSD1-SA76F/H-7 located inside PCMK north tower, lift 1 base, skin E, shear plate stiffener to connection plate. Welder was identified as 066165. 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 NSD1-SA17F/G-11 located inside PCMK north tower, lift 1 base, skin C, shear plate stiffener to connection plate. Welder was identified as 068865. 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 WSD1-SA294F/G-69 located outside PCMK west tower, lift 1 base, skin C, 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.

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

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.

Inspected By:	Goulet,George	Quality Assurance Inspector
Reviewed By:	Dawson,Paul	QA Reviewer
