

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-014030**Date Inspected:** 10-Apr-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 11

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

SMAW welding of weld joint WSTL4-2J/L-44 located on PCMK west tower, lift 4, skin E to the bottom of 139M double diaphragm at A/E corner. Welder was identified as 049220. QC was identified as ZPMC CWI Li Lin (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Xiao Hai Long, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-T-4333-TC-P4-F.

Bay 10

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

Heavy Dock

This QA Inspector randomly observed no apparent welding related work in progress on the Heavy Dock.

However, ZPMC workers were performing drilling operations on the struts at the 47M, 53M, 65M, and 77M levels.

OBG Trial Assembly Area

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This QA Inspector randomly observed the following work in progress in the OBG Trial Assembly Area:

SMAW welding of weld joint OBE7D-008 located outside PCMK OBG 7CE/7DE, bottom plate joint. Welder was identified as 037743. ZPMC QC was identified as CWI Sha Zhi (QC2). The welding variables recorded by QC2 appeared to comply with WPS-B-P-2114-FCM-1.

FCAW welding of weld joint OBE7C-009 located inside PCMK OBG 7CE/7DE, side plate joint, south (bike path) side. Welder was identified as 066283. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-P-2233T.

FCAW welding of weld joint OBE7C-009 located inside PCMK OBG 7CE/7DE, side plate joint, south (bike path) side. Welder was identified as 066743. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-P-2233T.

FCAW welding of weld joint OBE7C-010 located inside PCMK OBG 7CE/7DE, side plate joint, south (bike path) side. Welder was identified as 067947. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-P-2233T.

FCAW welding of weld joint OBE7C-007 located inside PCMK OBG 7CE/7DE, side plate joint. Welder was identified as 066912. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-P-2233T.

FCAW welding of weld joint OBE7C-007 located inside PCMK OBG 7CE/7DE, side plate joint. Welder was identified as 066443. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-P-2233T.

FCAW welding of weld joint OBE7C-006 located inside PCMK OBG 7CE/7DE, side plate joint. Welder was identified as 066279. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-P-2233T.

FCAW welding of weld joint OBE7C-006 located inside PCMK OBG 7CE/7DE, side plate joint. Welder was identified as 220069. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-P-2233T.

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 Eric Tsang, 150-0042-2372, who represents the Office of Structural Materials for your project.

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