

**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-014031**Date Inspected:** 12-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.

Bays 10 and 11

This QA Inspector randomly observed no apparent welding related work in progress in Bays 10 or 11.

OBG Trial Assembly Area

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

SMAW welding of weld joint OBE7C-004 located inside PCMK OBG 7BE/7CE, lower side plate joint. Welders were identified as 067572, 068917. ZPMC QC was identified as ZPMC CWI LKi Yang (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Zhong Yong Gang, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-P-2233T.

SMAW welding of weld joint OBE7C-002 located inside PCMK OBG 7BE/7CE, upper side plate joint. Welder was identified as 037932. ZPMC QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Zhong Yong Gang, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-P-2233T.

Heavy Dock

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# WELDING INSPECTION REPORT

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This QA Inspector randomly observed no apparent welding related work in progress on the Heavy Dock. However, ZPMC workers appeared to be working at the 53M, 65M, and 77M levels. This QA Inspector went to approximately the 27M level to board the tower elevator but observed the elevator to be stopped at the upper levels and unresponsive to the call button for 45 minutes. ABF Representative Zhao Ying Sheng was present on the pier and did not know why the elevator was inoperative.

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

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<b>Inspected By:</b>	Goulet,George	Quality Assurance Inspector
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<b>Reviewed By:</b>	Dawson,Paul	QA Reviewer
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