

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4
Cty: SF/Ala Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT**Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014675**Date Inspected:** 21-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 runoff plates to the ends of SD1-STSA4-5-127M-1 located on PCMK south tower, strut.

Welder was identified as 202314. QC was identified as ZPMC CWI An Qing Xiang (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Liu Dao Feng, who was a CAWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-T-4113-1. Also present at this location and observing the welding operation was ABF Representative Zhang Hui Long.

Bay 10

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

Heavy Dock

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

FCAW welding of weld joint SSD1-SA16F/G-37 located outside PCMK south tower, lift 1 base, skin E, shear plate stiffener to connection plate. Welder was identified as 057266. ZPMC QC was identified as CWI Gong Liang Zhu (QC2). The welding variables recorded by QC2 appeared to comply with WPS-B-T-2333-TC-P4-F.

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Also present at this location and appearing to be monitoring the welding related operations was ABF Representative Zhao Ying Sheng.

FCAW welding of weld joint SSD1-SA16F/G-53 located outside PCMK south tower, lift 1 base, skin E, shear plate stiffener to connection plate. Welder was identified as 057244. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2333-TC-P4-F. Also present at this location and appearing to be monitoring the welding related operations was ABF Representative Zhao Ying Sheng.

FCAW welding of weld joints ESD1-SA227F/H-28, 54 located outside PCMK east tower, lift 1 base, skin E, shear plate stiffener to connection plate. Welder was identified as 040736. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2333-TC-P4-F. Also present at this location and appearing to be monitoring the welding related operations was ABF Representative Zhao Ying Sheng.

FCAW welding of weld joint ESD1-SA227F/H-38 located outside PCMK east tower, lift 1 base, skin E, shear plate stiffener to connection plate. Welder was identified as 076706. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2333-TC-P4-F. Also present at this location and appearing to be monitoring the welding related operations was ABF Representative Zhao Ying Sheng.

A moderate rain was falling during the above noted welding operations. Tarps were being used to shield the welding areas. This QA Inspector discussed the importance of keeping the rain away from the welding operations with QC2.

OBG Trial Assembly Area

This QA Inspector randomly observed no apparent welding related work being performed in the OBG Trial Assembly Area.

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.

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