

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-014676**Date Inspected:** 23-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 no apparent welding related work being performed in Bay 11.

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:

SMAW repair welding of weld joint SSD1-A111A/H-3A located outside PCMK south tower, lift 1 base. Welder was identified as 040690. ZPMC QC was identified as CWI Gong Liang Zhu (QC1). The welding variables recorded by QC2 appeared to comply with WPS-345-SMAW-3G(3F)-repair as listed on T-WR3202 presented to this QA Inspector by QC1. Also present at this location and appearing to be monitoring the welding related operations was ABF Representative Zhao Ying Sheng.

OBG Trial Assembly Area

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

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ABF representatives were performing magnetic particle inspection of holdback welds at the bottom plate to stiffeners at the 7CE/7DE joint between panel points 55 and 56.

FCAW welding of weld joint OBW7C-003 located inside PCMK OBG 7CW/7DW, bottom plate to bottom plate transverse joint. Welder was identified as 048714. ZPMC QC was identified as ZPMC CWI Liu Hua Jie (QC2). Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Wang Zhu, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2231T.

FCAW welding of weld joint OBW7C-004 located inside PCMK OBG 7CW/7DW, lower side plate to side plate transverse joint, north (counterweight) side. Welder was identified as 045227. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Wang Zhu, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2233T-1.

FCAW welding of weld joint OBW7C-005 located inside PCMK OBG 7CW/7DW, upper side plate to side plate transverse joint, north (counterweight) side. Welder was identified as 045276. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Wang Zhu, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2233T-1.

FCAW welding of weld joint OBW7C-002 located inside PCMK OBG 7CW/7DW, lower side plate to side plate transverse joint, south (crossbeam) side. Welder was identified as 045143. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Wang Zhu, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2233T-1.

FCAW welding of weld joint OBW7C-011 located inside PCMK OBG 7CW/7DW, upper side plate to side plate transverse joint, south (crossbeam) side. Welder was identified as 067138. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Wang Zhu, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2233T-1.

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

Reviewed By: Dawson, Paul

QA Reviewer