

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-015016**Date Inspected:** 02-May-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 SD1-STSA4-5-135M-1-7A located on PCMK south tower, strut assembly. Welder was identified as 040667. QC was identified as ZPMC CWI Du Zhi Qun (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Xu Jie, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-T-2212-TC-U5b.

SMAW welding of weld joint WD1-STSA4-5-123M-1-8A located on PCMK west tower, strut assembly. Welders were identified as 046704, 040656. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Xu Jie, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-T-2212-TC-U5b.

SMAW welding of weld joint ND1-STSA4-6-131M-2-85 located on PCMK north tower, strut assembly. Welder was identified as 046769. QC was identified as ZPMC CWI Liu Yang (QC2). Assisting QC2 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 QC2's assistant appeared to comply with WPS-B-T-2112.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

SMAW welding of weld joint ND1-STSA4-6-131M-1-79 located on PCMK north tower, strut assembly. Welder was identified as 202100. QC was identified as QC2. Assisting QC2 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 QC2's assistant appeared to comply with WPS-B-T-2112.

SMAW welding of weld joint ND1-STSA4-6-135M-2-29 located on PCMK north tower, strut assembly. Welder was identified as 041271. QC was identified as QC2. Assisting QC2 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 QC2's assistant appeared to comply with WPS-B-T-2112.

SMAW welding of weld joints ND1-STSA4-6-135M-2-31, 32 located on PCMK north tower, strut assembly. Welder was identified as 040655. QC was identified as QC2. Assisting QC2 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 QC2's assistant appeared to comply with WPS-B-T-2112.

Bay 10

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

SMAW welding of temporary alignment plates located outside at the top of PCMK south tower, lift 3, at the C/D corner. Welder was identified as 500373. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Sun Tian Liang, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-P-2214-TC-U5b. See photo below.

Heavy Dock

ABF Representative Li Ke Wei informed this QA Inspector that no welding or drilling work was being performed on the Heavy Dock, but ZPMC personnel were performing fit-up of temporary cross bracing.

OBG Trial Assembly Area

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

ABF personnel were performing magnetic particle inspection on the hold back welds of the bottom plate stiffeners and side plate stiffeners at the 7EE/8AE transverse joints.

SMAW welding of visual testing repairs on various hold back welds on the stiffeners of the south (crossbeam) side at the 7CW/7DW transverse joint, weld joints SP759-001-025~036. Welder was identified as 045196. ZPMC QC was identified as ZPMC CWI Li Yang (QC1). Assisting QC1 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 QC1's assistant appeared to comply with WPS-345-SMAW-2G(2F)-FCM-repair-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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
