

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-015017**Date Inspected:** 03-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 ED1-STSA4-6-139M-1-44 located on PCMK east tower, strut assembly. Welder was identified as 046769. QC was identified as ZPMC CWI Liu Yang (QC1). The welding variables recorded by QC1 appeared to comply with WPS-B-T-2112.

SMAW welding of weld joints ED1-STSA4-6-139M-1-39, 40 located on PCMK east tower, strut assembly. Welder was identified as 040724. QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2112.

SMAW welding of weld joints ED1-STSA4-6-127M-2-81, 81 located on PCMK east tower, strut assembly. Welder was identified as 202100. QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2112.

Bay 10

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

WELDING INSPECTION REPORT

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Heavy Dock

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

SMAW welding of weld joint P475-S-3 located on PCMK south tower, crossbeam plate connection at approximately 48M elevation. Welder was identified as 052910. QC was identified as ZPMC CWI Du Zhi Qun (QC2). The welding variables recorded by QC2 appeared to comply with WPS-B-T-4212-TC-U4c-4.

SMAW welding of weld joint P475-N-3 located on PCMK north tower, crossbeam plate connection at approximately 48M elevation. Welder was identified as 500331. QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-4212-TC-U4c-4.

OBG Trial Assembly Area

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

SMAW repair welding of weld joint OBE8A-003 located outside PCMK OBG 8BE/8CE, deck plate to deck plate, transverse joint. Welder was identified as 053753. QC was identified as ZPMC CWI Liu Hua Jie (QC3). The welding variables recorded by QC3 appeared to comply with WPS-345-SMAW-1G(1F)-FCM-repair-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.

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