

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-015019**Date Inspected:** 05-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-STSA4-6-135M-1-9A located on PCMK east tower, strut assembly. Welder was identified as 044551. QC was identified as ZPMC CWI Yu Dong Ping (QC1). The welding variables recorded by QC1 appeared to comply with WPS-B-T-2212-TC-U5b.

SMAW welding of weld joints ED1-STSA4-6-139M-1-25, 26 located on PCMK east tower, strut assembly. Welder was identified as 040724. QC was identified as ZPMC QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2112.

SMAW welding of weld joints ND1-STSA4-6-131M-2-71, 72 located on PCMK north tower, strut assembly. Welder was identified as 251194. QC was identified as ZPMC 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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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 SEG044A-043 located outside PCMK OBG 8AE/8BE, side plate to bottom plate, south (bike path) side. Welder was identified as 048659. 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 Jie, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-345-SMAW-4G(4F)-repair-1. Also present at this location and appearing to be monitoring the welding operations was ABF Representative Yan Bao Jia.

ABF personnel performing ultrasonic testing outside on the 7CW/7DW transverse joint, deck plates.

FCAW welding of weld joint BK001-032-009 located on bike path cantilever beam flange. Welder was identified as 222396. 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-2231-TC-U4b-F. Also present at this location and appearing to be monitoring the welding operations was ABF Representative Yan Bao Jia.

FCAW welding of weld joints SEG046B-024, 046 located inside PCMK OBG 8BE at panel point 67 longitudinal diaphragm. Welder was identified as 220069. QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2233-TC-U4b-F for weld joint 024 and WPS-B-T-2232-TC-U4b-F for weld joint 046.

Heavy Dock

This QA Inspector randomly observed no welding work being performed on the Heavy Dock. North tower, lift 1 was laying horizontally on the foot of the Heavy Dock and the ZPMC 4000 ton floating crane moored to the foot of the Heavy Dock and was positioned over the other 3 erect lifts 1. Rigging hanging from the 4000 ton floating crane appeared to be connected to the top of west tower, lift 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
