

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-015097**Date Inspected:** 16-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 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 10

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

FCAW layered repair welding of on shear plate WD1-A1 located on PCMK west tower. Welders were identified as 057180, 053116. QC was identified as ZPMC CWI Li Lin (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Yuan Hui Gang, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-345-FCAW-2G(2F)-repair as listed on a ZPMC repair order written in Chinese characters only and no repair order number. Also present at this location and appearing to be monitoring the welding operations was ABF Representative Zhao Ying Sheng.

FCAW welding of base metal on plate ED1-A1 located on PCMK east tower. Welders were identified as 054069, 052075. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Yuan Hui Gang, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-345-FCAW-2G(2F)-repair as listed on a ZPMC repair order written in Chinese characters only and no repair order number. Also present at this location and appearing to be monitoring the welding operations was ABF Representative Zhao Ying Sheng.

FCAW welding of weld joints ED1-A27B/B-34, 36 located inside PCMK east tower, base shear plate. QC was

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2332-TC-P4-F.

Bay 11

This QA Inspector randomly observed no welding related work in progress in Bay 11.

Heavy Dock

ABF Representative Zhao Ying Sheng informed this inspector that no work was being performed on the Heavy dock.

Bay 10 - MT

In response to ZPMC Notification Inspection #005750 for magnetic particle testing (MT) inspection of tower shear plate A26, this QA Inspector performed random visual testing (VT) and then MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member was identified as ND1-A26B/B. The weld designations reviewed were: 48, 50. No relevant indications were observed.

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 Skyler Guest, 150-0042-2360, who represents the Office of Structural Materials for your project.

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