

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-015110**Date Inspected:** 30-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**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 11

This QA Inspector randomly observed the following work in progress in Bay 11:

SMAW layered repair welding of the ends of 4 plates identified by drawing number 43-S-T-A136-N, 43-S-T-A136-F, 43-S-T-A136-F, 43-S-T-A136-N. Welder was identified as 202100. 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 Mao Bin Bin, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-485-SMAW-1G(1F)-repair-1 as listed on ZPMC Weld Repair Report #T-WR3309. Also present at this location and appearing to be monitoring the welding operations was ABF Representative Li Nan.

SMAW welding of weld joints ND1-STSA4-10-119M-1-26, 31 located on PCMK north tower, strut assembly. Welders were identified respectively as 041271, 040614. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Mao Bin Bin, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-T-2113. Also present at this location and appearing to be monitoring the welding operations was ABF Representative Li Nan.

Bay 10

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

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Blast Shop 2
Inside South - Lift 1
Visual Inspection, 0-9 Meters

ZPMC requested Caltrans personnel to perform visual inspections of south tower, lift 1 from 0 meters to 9 meters at approximately 2030 hours following the initial blast cleaning of the steel surfaces. Caltrans QA Inspector Paul Dawson and this QA Inspector performed random visual inspections of these areas. ABF and ZPMC Inspectors reported to have previously performed visual inspections of the areas noted above. This QA Inspector visually observed several areas that have light areas of rust which indicates the grit blasting was not adequate to prepare the metal surfaces prior to application of paint and approximately 40 locations that required grinding to resolve visual weld spatter, arc strikes, shallow nicks, scrapes, and sharp edges of ground welds. Approximately 4 locations were marked by ZPMC QC, ABF and/or Caltrans Inspectors as needing to be weld repaired. These weld repair areas have been covered by black electrical or similar tape.

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
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Reviewed By:	Dawson,Paul	QA Reviewer
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