

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-015111**Date Inspected:** 20-Jun-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 10

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

SMAW welding of weld joint NSD1-SPSA5-19-1A located on PCMK north tower, lift 5, inside splice plate assembly. Welder was identified as 050289. QC was identified as ZPMC CWI Ye Yong Jun (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Jiang Xiao Bo, who was not a CWI. Welding variables recorded by QC1's assistant appeared to comply with WPS-B-T-3211-TC-U5b-1. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Liu Cheng.

SMAW welding of weld joint NSD1-TL5-3B-F-24B located on PCMK north tower, lift 5. Welder was identified as 052930. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Li Peng Fei, who was not a CWI. Welding variables recorded by QC1's assistant appeared to comply with WPS-B-P-3213-B-U3b. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Liu Cheng.

Bay 11

This QA Inspector randomly observed no welding related work being performed in Bay 11. However, several

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areas were observed marked as W+G in the base metal on the outside of west tower, lift4, skin C. See photos below.

OBG Trial Assembly Area

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

SMAW welding of weld joint SSD12A-PP070-169 located inside the OBG at PCMK 8CW, FL3 floor beam to deck plate at east end of connection to CB10. Welder was identified as 069896. QC was identified as ZPMC CWI Zhu Zhong Hai (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. Welding variables recorded by QC2's assistant appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1.

SMAW welding of weld joint SSD10A-PP068-170 located inside the OBG at PCMK 8CW, FL3 floor beam to deck plate at west end of connection to CB10. Welder was identified as 067764. 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. Welding variables recorded by QC2's assistant appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1.

SMAW welding of weld joint OBW80-049 located outside the OBG at PCMK 8AW, drip plate to edge plate/side plate joint on south (crossbeam) side. Welder was identified as 066038. 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. Welding variables recorded by QC2's assistant appeared to comply with WPS-B-P-2114-FCM-1.

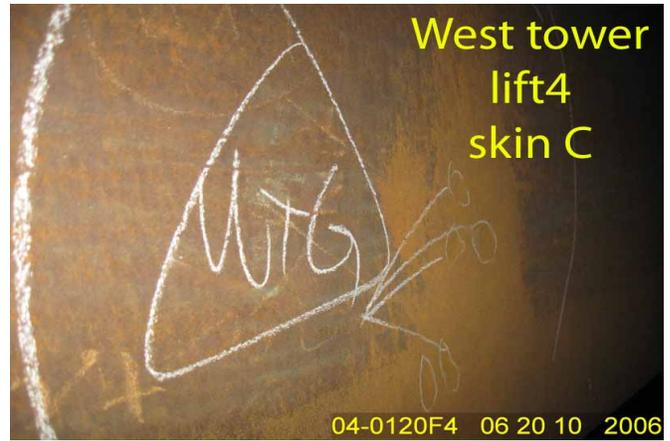
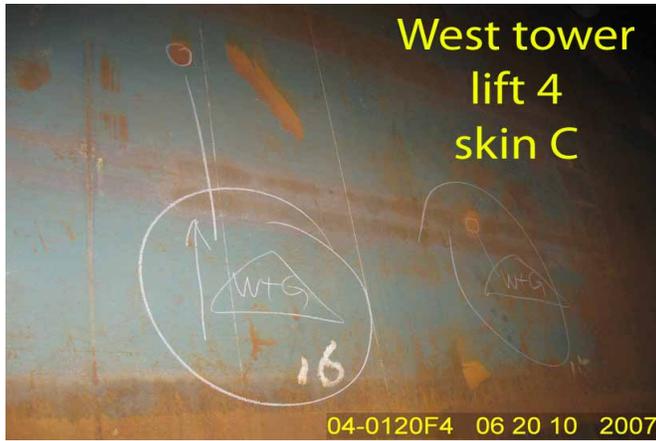
Heavy Dock

This QA Inspector observed no welding related work was being performed on the heavy dock. All 4 tower lifts 2 were erect with south and east lifts 3 attached above, respectively. The worker access elevator was dark. North tower, lift 3 was laying horizontally at the foot of the dock and no ZPMC workers were present. ABF Representative Kang Yi acknowledged that no work was being performed on the Heavy Dock.

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

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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