

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-015189**Date Inspected:** 14-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 no welding related work being performed in Bay 10.

Bay 11

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

Heavy Dock

This QA Inspector observed no welding related work being performed on the heavy dock. All 4 tower lifts 1 were laying horizontally on the ship moored at the foot of the heavy dock. ZPMC personnel were continuing scaffolding work around the lift 1 sections.

OBG Trial Assembly Area

SMAW repair welding as a result of visual testing of various weld joints located on PCMK PP64 and others traveler rail brackets. Welder was identified as 045204. QC was identified as ZPMC CWI Liu Hua Jie (QC1). Welding variables recorded by QC1 appeared to comply with WPS-345-SMAW-2G(2F)-FCM-repair-1 and WPS-345-SMAW-3G(3F)-FCM-repair-1. Also present at this location and appearing to be monitoring the welding operations was ABF Representative Zhang Xiao Bin.

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SMAW welding of temporary alignment plates onto deck plates at the PCMK OBG 8CW/9AW joint, outside of the segments. Welder was identified as 048619. QC was identified as QC1. Welding variables recorded by QC1 appeared to comply with WPS-B-P-2112. Also present at this location and appearing to be monitoring the welding operations was ABF Representative Zhang Xiao Bin.

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
