

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-015191**Date Inspected:** 18-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. Many access holes to the 4 tower, lifts 1 have been sealed with plastic. North tower, lift 3 was being placed horizontally at the foot of the heavy dock.

OBG Trial Assembly Area

Post heat treatment was being applied to weld joint SEG048B-047 located on PCMK 8CE, bottom plate to side plate per ZPMC Weld Repair Report #B-CWR1618, Rev. 2-1 as presented to this QA Inspector by QC, identified as ZPMC CWI Liu Hua Jie (QC1).

SMAW repair welding of weld joints CA049-003, CA053-005 located inside PCMK 8BW and 8CW, respectively, side plate to edge plate. Welder was identified as 045227. QC was identified as ZPMC QC1. Welding variables

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

recorded by QC1 appeared to comply with WPS-345-SMAW-2G(2F)-FCM-repair.

SMAW welding of temporary alignment plates onto deck plates on PCMK OBG8AW to counterweight C62. Welder was identified as 045213. QC was identified as QC1. Welding variables recorded by QC1 appeared to comply with WPS-B-P-2112-FCM-1.

SMAW repair welding as a result of visual testing of various weld joints located on several traveler rail brackets. Welder was identified as 205718. QC was identified as QC1. Welding variables recorded by QC1 appeared to comply with WPS-345-SMAW-1G(4F)-FCM-repair and WPS-345-SMAW-4G(4F)-FCM-repair.

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
