

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-015748**Date Inspected:** 11-Jul-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 tack welding of weld joint SP3081-001-023 located on PCMK OBG side plate. Welder was identified as 057239. QC was identified as ZPMC CWI Yu Dong Ping (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Li Peng Fei (QCA1), who was not a CWI. Welding variables recorded by QCA1 appeared to comply with WPS-B-P-2112.

Bay 11

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

OBG Trial Assembly Area

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

FCAW welding of weld joint OBE9C-004 located on PCMK 9CE/9DE, lower side plate to side plate transverse joint, south (bikepath) side. Welder was identified as 220066. QC was identified as ZPMC CWI An Qing Xiang (QC2). Welding variables recorded by QC2 appeared to comply with WPS-B-T-2233T-1. Also at this location and appearing to be monitoring the welding operation was ABF Representative Wang Zhong Yuan.

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FCAW welding of weld joint OBE9C-005 located on PCMK 9CE/9DE, upper side plate to side plate transverse joint, south (bikepath) side. Welders were identified as 222396, 053742. QC was identified as QC2. Welding variables recorded by QC2 appeared to comply with WPS-B-T-2233T-1. Also at this location and appearing to be monitoring the welding operation was ABF Representative Wang Zhong Yuan.

SMAW repair welding of weld joints EP075-001-011, 012 located on PCMK OBG sections 8BW/8CW transverse joint, edge plate I stiffeners, south (crossbeam) side. Welder was identified as 205098. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Zhou Peng (QCA4), who was not a CWI. Welding variables recorded by QCA4 appeared to comply with WPS-345-SMAW-3G(3F)-FCM-repair as noted on ZPMC Welding Repair Report B-WR13953. The item name was displayed as stiffener and the drawing number was displayed as SEG45, SEG47.

SMAW repair welding of weld joint EP075-001-004 located on PCMK OBG sections 8BW/8CW transverse joint, edge plate I stiffener, south (crossbeam) side. Welder was identified as 045246. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was QCA4, who was not a CWI. Welding variables recorded by QCA4 appeared to comply with WPS-345-SMAW-4G(4F)-FCM-repair as noted on ZPMC Welding Repair Report B-WR13953. The item name was displayed as stiffener and the drawing number was displayed as SEG45, SEG47.

SMAW repair welding of weld joint EP075-001-003 located on PCMK OBG sections 8BW/8CW transverse joint, edge plate I stiffener, north (counterweight) side. Welder was identified as 045196. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was QCA4, who was not a CWI. Welding variables recorded by QCA4 appeared to comply with WPS-345-SMAW-3G(3F)-FCM-repair as noted on ZPMC Welding Repair Report B-WR13953. The item name was displayed as stiffener and the drawing number was displayed as SEG45, SEG47.

SMAW repair welding of weld joint EP063-001-004 located on PCMK OBG sections 8BW/8CW transverse joint, edge plate I stiffener, north (counterweight) side. Welder was identified as 045246. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was QCA4, who was not a CWI. Welding variables recorded by QCA4 appeared to comply with WPS-345-SMAW-4G(4F)-FCM-repair as noted on ZPMC Welding Repair Report B-WR13953. The item name was displayed as stiffener and the drawing number was displayed as SEG45, SEG47.

SMAW repair welding of weld jointS EP075-001-013, 014 located on PCMK OBG sections 8BW/8CW transverse joint, edge plate I stiffener, north (counterweight) side. Welder was identified as 045196. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was QCA4, who was not a CWI. Welding variables recorded by QCA4 appeared to comply with WPS-345-SMAW-3G(3F)-FCM-repair and WPS-345-SMAW-4G(4F)-FCM-repair as noted on ZPMC Welding Repair Report B-WR13953. The item name was displayed as stiffener and the drawing number was displayed as SEG45, SEG47.

Heavy Dock

This QA Inspector randomly observed the following work being performed on the Heavy Dock:

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This QA Inspector observed no apparent work was being performed on the heavy dock. All 4 tower lifts 2 were erect with all 4 tower lifts 3 attached above, respectively. The lifts 2/3 worker access tower elevator was unmanned and dark. This QA Inspector did not observe any ZPMC QC or ABF representative presence anywhere on the Heavy Dock.

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 Eric Tsang, 150-0042-2372, 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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