

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-015749**Date Inspected:** 14-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 SSD1-TL5-1B/F-4B located on PCMK south tower, lift 5, skin A connection plate. Welder was identified as 057242. QC was identified as ZPMC CWI Xu Le Feng (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Yu Zhi Lai (QCA1), who was not a CWI. Welding variables recorded by QCA1 appeared to comply with WPS-B-T-3213-TC-U5b.

SMAW tack welding of weld joints SP3083-001-105, 106 located on PCMK OBG side plate. Welder was identified as 057239. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Yuan Hui Gang (QCA2), 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:

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FCAW welding of weld joint OBE9A-007 located on PCMK 9DE/9EE, deck plate to deck plate transverse joint, north (crossbeam) side. Welder was identified as 222396. QC was identified as ZPMC CWI An Qing Xiang (QC2). Assisting QC2 at this location and appearing to be monitoring the welding and recording data was Zhou Peng (QCA3), who was not a CWI. Welding variables recorded by QCA3 appeared to comply with WPS-B-T-2231T-1. Also at this location and appearing to be monitoring the welding operation was ABF Representative Cao Hai Zhou.

FCAW welding of weld joint OBE9A-009 located on PCMK 9DE/9EE, deck plate to deck plate transverse joint, south (bikepath) side. Welder was identified as 220067. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was QCA3, who was not a CWI. Welding variables recorded by QCA3 appeared to comply with WPS-B-T-2231T-1. Also at this location and appearing to be monitoring the welding operation was ABF Representative Cao Hai Zhou.

FCAW welding of weld joint OBE9A-008 located on PCMK 9DE/9EE, deck plate to deck plate transverse joint, middle of deck. Welder was identified as 222396. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was QCA3, who was not a CWI. Welding variables recorded by QCA3 appeared to comply with WPS-B-T-223(2)1T. Also at this location and appearing to be monitoring the welding operation was ABF Representative Cao Hai Zhou.

FCAW welding of weld joint OBE9C-008 located on PCMK 9DE/9EE, bottom plate to bottom plate transverse joint. Welders were identified as 220063, 220069. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was QCA3, who was not a CWI. Welding variables recorded by QCA3 appeared to comply with WPS-B-T-2231T. Also at this location and appearing to be monitoring the welding operation was ABF Representative Cao Hai Zhou.

Heavy Dock

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

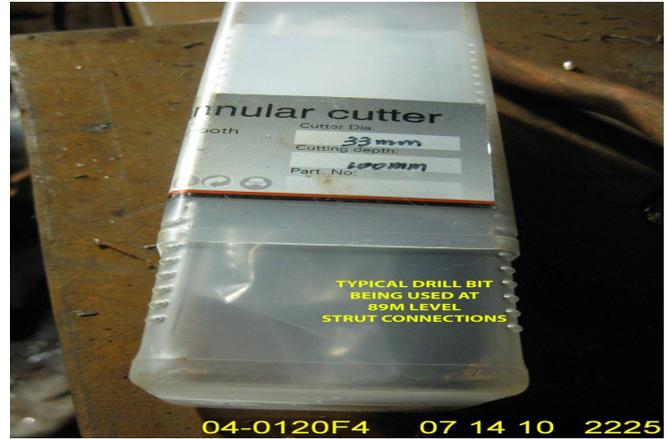
All 4 tower lifts 2 were erect with all 4 tower lifts 3 attached above, respectively. ZPMC workers were observed drilling previously scored holes in various strut flange and web connection plates at the 89M level of lifts 3. See photos below.

OBG segment 7E had been previously loaded onto the forward deck of the ship moored to the end of the Heavy Dock. Crossbeams 7, 8, 9, and 10 were still on the ship, as before. This QA Inspector did not observe any ZPMC QC or ABF representative presence anywhere on the Heavy Dock and the local ABF and ZPMC QC offices were dark.

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