

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-015750**Date Inspected:** 16-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:

FCAW welding of weld joints SP3083-001-117, 118 located on PCMK OBG side plate. See photo below.

Welder was identified as 053870. QC was identified as ZPMC CWI Zhao Chen Sun (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Sun Tian Liang (QCA1), who was not a CWI. Welding variables recorded by QCA1 appeared to comply with WPS-B-P-2132.

FCAW tack welding of weld joints SP3078-001-105, 106, 111, 112, 017, 018, 027, 028, 037, 038, 047, 048, 057,

058, 067, 068. located on PCMK OBG side plate. Welder was identified as 053870. QC was identified as QC1.

Assisting QC1 at this location and appearing to be monitoring the welding and recording data was QCA1.

Welding variables recorded by QCA1 appeared to comply with WPS-B-P-2132.

Bay 11

This QA Inspector randomly observed the following work being performed in Bay 11:

SMAW tack welding during fit-up of weld joint ESD1-TL5-2B/F-2A/B located on PCMK east tower, lift 5, skin A connection plate. Welder was identified as 041271. QC was identified as QC1. Assisting QC1 at this location

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and appearing to be monitoring the welding and recording data was ZPMC QC Xu Jie (QCA2), who was not a CWI. Welding variables recorded by QCA2 appeared to comply with WPS-B-T-3213-TC-U5b.

OBG Trial Assembly Area

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

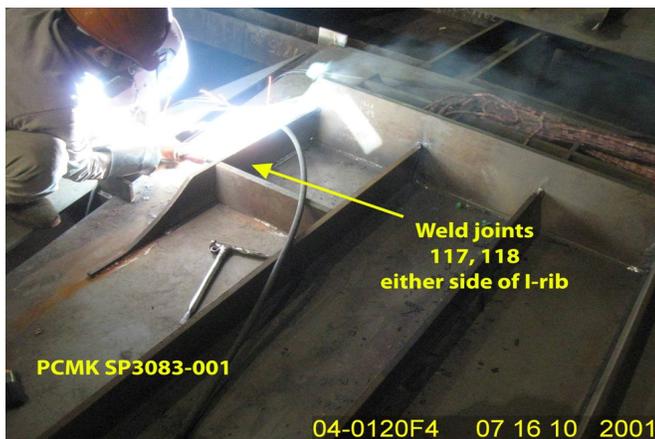
SMAW tack welding of temporary alignment plates on the outside of OBG segment 9DE/9EE transverse weld joint, side plate, north (crossbeam) side. Welder was identified as 220069. QC was identified as ZPMC CWI An Qing Xiang (QC2). Welding variables recorded by QC2 appeared to comply with WPS-B-T-2134.

Heavy Dock

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

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. No ZPMC QC nor ABF representative presence was observed anywhere on the Heavy Dock. The lifts 2/3 worker access tower elevator was unmanned and was dark as were the local ABF and ZPMC QC offices. Crossbeams 7, 8, 9, and 10 were still on the ship moored to the end of the Heavy Dock, as before. OBG segment 7E was positioned on deck, forward of the crossbeam sections with segment 7W positioned on top of 7E.

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.

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Inspected By: Goulet, George

Quality Assurance Inspector

Reviewed By: Dawson, Paul

QA Reviewer