

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017442**Date Inspected:** 25-Sep-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 11

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

SMAW welding of weld joint ND1-BRSA5-2-10B, 14B located on PCMK ND1-BRSA5-2. Welders were identified, respectively, as 044541, 054460. QC was identified as ZPMC CWI Qiu Wen (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Mao Bin Bin (QCA1), who was not a CWI. Welding variables recorded by QCA1 appeared to comply with WPS-B-T-3213-TC-U4b.

SMAW repair welding of weld joint WSD1-TL5-4B-F-24 located on PCMK west tower, lift 5, internal connection plates. Welder was identified as 066261. QC was identified as QC1. Welding variables recorded by QC1 appeared to comply with WPS-485-SMAW-3G(3F)-repair as listed on ZPMC Weld Repair Report T-CWR696 attached to ZPMC Ultrasonic Testing Report T787-UT-3236R1 as presented to this QA Inspector and verbalized by QC1. ZPMC Weld Repair Report T-CWR696 also displayed the wording: over 2 times repair and the preheat temperature was displayed as 200°C.

OBG Trial Assembly Area

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

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

SMAW welding of temporary alignment plates located on OBG at the 11AE/11BE transverse weld joint, north (crossbeam) side, side plate. Welder was identified as 056364. QC was identified as ZPMC CWI Liu Hua Jie (QC2). Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Zhou Peng (QCA2), who was not a CWI. Welding variables recorded by QCA2 appeared to comply with WPS-B-P-2114.

SMAW welding of temporary alignment plates located on both sides of the OBG side plate to bottom plate and extending across the 11AW/11BW transverse weld joint, south (crossbeam) side, side plate. Welder was identified as 500443. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was QCA2, who was not a CWI. Welding variables recorded by QCA2 appeared to comply with WPS-B-P-2114.

SMAW welding of temporary alignment plates located on both sides of the OBG side plate to bottom plate and extending across the 11AW/11BW transverse weld joint, north (counterweight) side, side plate. Welder was identified as 500443. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was QCA2, who was not a CWI. Welding variables recorded by QCA2 appeared to comply with WPS-B-P-2114.

Heavy Dock

This QA Inspector randomly observed the following on the Heavy Dock:

No apparent welding related work was being performed on the Heavy Dock. All 4 towers' lift 3 were connected and positioned vertically on a base pedestal at end of the Heavy Dock. East, south, west, and north towers, lift 4 were positioned on top of east, south, west, and north towers, lift 3, respectively, on the Heavy Dock. The ZPMC 4000 ton floating crane was moored to the end of the Heavy Dock and sitting idle.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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 Micheal Ng, 159-2184-5703, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet,George	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
