

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-017511**Date Inspected:** 01-Oct-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 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 repair welding of weld joint ESD1-TL5-2B/F-2B located on PCMK east tower, lift 5, external connection plate at skins A/E corner. Welders were identified as 041271, 044541. QC was identified as ZPMC CWI Yu Dong Ping (QC1). Welding variables recorded by QC1 appeared to comply with WPS-485-SMAW-3G(3F)-repair as listed on ZPMC Weld Repair Report T-WR3691 attached to ZPMC Ultrasonic Testing Report T787-UT-3263 as presented to this QA Inspector and verbalized by QC1.

SMAW repair welding of weld joint ESD1-TL5-2B/F-8B located on PCMK east tower, lift 5, external connection plate at skins A/B corner. Welder was identified as 054460. 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-WR3692 attached to ZPMC Ultrasonic Testing Report T787-UT-3263 as presented to this QA Inspector and verbalized by QC1.

SMAW repair welding of weld joint ESD1-TL5-2B/F-7B located on PCMK east tower, lift 5, internal connection plate at skin A. Welder was identified as 040723. 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

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T-WR3693 attached to ZPMC Ultrasonic Testing Report T787-UT-3263 as presented to this QA Inspector and verbalized by QC1.

Bay 10

This QA Inspector randomly observed no apparent work in progress in Bay 10.

Heavy Dock

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

No apparent 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 1300 ton floating crane was moored to 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:

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 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
