

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-017553**Date Inspected:** 04-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 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:

FCAW welding of weld joints BK004A-022-014, 015 located on PCMK BK004A-022. Welder was identified as 042218. QC was identified as ZPMC CWI YeYong Jun (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Shao Hai Lang (QCA1), who was not a CWI. Welding variables recorded by QCA1 appeared to comply with WPS-B-T-2132.

SMAW of weld joint SD1-BRSA5-1-11B located on PCMK south tower, lift 5. Welder was identified as 046769. QC was identified as QC1. Welding variables recorded by QC1 appeared to comply with WPS-B-T-3213-TC-U4b.

SMAW of weld joint SD1-BRSA5-1-8A located on PCMK south tower, lift 5. Welder was identified as 041271. QC was identified as QC1. Welding variables recorded by QC1 appeared to comply with WPS-B-T-3213-TC-U4b.

Bay 10

This QA Inspector randomly observed the following work in progress in Bay 10:

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SMAW repair welding of weld joints BK004A3-032-025, 026, 051, 052 located on PCMK BK004A3-023-8A and 8C. Welder was identified as 056364. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Sun Tian Liang (QCA2), who was not a CWI. Welding variables recorded by QCA2 appeared to comply with WPS-345-SMAW-2G(2F)-repair. QCA2 informed this QA Inspector that these repairs were subsequent to ZPMC visual testing inspection (VT).

SMAW repair welding of weld joints BK004A4-032-014, 015, 040, 041, 066, 067 located on PCMK BK004A4-023-10A, 9C, 9A. Welder was identified as 056364. QC was identified as QC1. Assisting QC1 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-345-SMAW-2G(2F)-repair. QCA2 informed this QA Inspector that these repairs were subsequent to ZPMC VT.

Heavy Dock

This QA Inspector randomly observed the following 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 personnel access elevator made stops at several elevation levels on lift 4. No sounds of drilling were heard from the deck of 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
