

**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-017574**Date Inspected:** 09-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.

Bays 10 and 11

This QA Inspector randomly observed no welding related work in progress in Bays 10 or 11.

OBG Trial Assembly Area

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

FCAW repair welding of weld joints SP712-001-032,036, 040 located on PCMK 10E, side plate I-rib to I-rib at the 10BE/10CE transverse joint. Welder was identified as 044515. QC was identified as ZPMC CWI Shi Lei (QC1). Welding variables recorded by QC1 appeared to comply with WPS-345-FCAW-4G(4F)-repair as listed on ZPMC Weld Repair Reports B-WR15805, B-WR15806, B-WR15807, and not attached to, but displaying the reference ZPMC Ultrasonic Testing Report B787-UT-16261 as presented to this QA Inspector and verbalized by QC1.

ZPMC personnel were performing air arcing to remove temporary alignment plates which were positioned across the transverse weld joints at OBG segments 11AE/11BE at the bottom plate, side plate north (crossbeam) side, and deck plates. Four Goldhofer transport lift vehicles were being positioned under OBG segments 11AE and 11BE as the segments were still adjacent to OBG segment 10CE.

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# WELDING INSPECTION REPORT

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## 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 was dark and no sounds of drilling were heard from the deck of the Heavy Dock. The ZPMC 1300 ton and 4000 ton floating cranes were 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.

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<b>Inspected By:</b>	Goulet, George	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford, William	QA Reviewer

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