

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-017799**Date Inspected:** 05-Nov-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 joint BK008A6-002-069 located on PCMK OBG BK008-002, longitudinal stiffener web to flange. Welder was identified as 040723. QC was identified as ZPMC CWI Ye Yong Jun (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Wang Chuang Xin (QCA1), who was not a CWI. Welding variables recorded by QCA1 appeared to comply with WPS-B-T-2131 as verbally identified by QCA1.

FCAW welding of weld joint BK008A6-002-075 located on PCMK OBG BK008-002, longitudinal stiffener web to flange. Welder was identified as 205649. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was QCA1, who was not a CWI. Welding variables recorded by QCA1 appeared to comply with WPS-B-T-2131 as verbally identified by QCA1.

FCAW tack welding of weld joints GGL-MQ-1958-079-001, 002 located on PCMK OBG GGL-MQ-1958-079, welded channel splice. Welder was identified as 054460. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was QCA1, who was not a CWI. Welding variables recorded by QCA1 appeared to comply with WPS-B-T-2231-TC-U4b-F as verbally identified by QCA1.

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Bay 10

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

OBG Trial Assembly Area

This QA Inspector randomly observed no work in progress in the OBG Trial Assembly Area. ZPMC CWI Liu Hua Jie and ABF Representative Zhang Xiao Bin informed this QA Inspector that no work was being performed in the Trial Assembly Area.

Heavy Dock

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

All 4 towers, lift 4 were positioned on a base separate pedestal at end of the Heavy Dock. West and north towers, lift 3 and OBG segment 10E were positioned on the deck of the ship moored at the end of the Heavy Dock. OBG segment 10W was positioned on top of OBG segment 10E. OBG CB14 was positioned on the deck of the Heavy Dock. No welding related work was being performed on any of the tower or OBG components. The ZPMC 1600 ton floating crane was moored to the outboard side of the ship.

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:	Carreon,Albert	QA Reviewer
