

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-018685**Date Inspected:** 19-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 10

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

SMAW welding of temporary alignment plates located on PCMK OBG BK004-032, at temporary transverse stiffener plate to deck plate and bent edge plate. Welder was identified as 057186. QC was identified as ZPMC CWI Guo Yan Fei (QC1). Welding variables recorded by QC1 appeared to comply with WPS-B-P-2112 and WPS-B-P-2113 as verbally identified by QC1. QC1 informed this QA Inspector that the above noted transverse stiffeners at each end of the bikepath section are in an area which will be removed by torch cutting when all other welding is completed.

SMAW welding of temporary alignment plates located on PCMK OBG BK004-025, at straight edge plate to bottom plate for fit-up. Welder was identified as 057239. QC was identified as ZPMC QC1. Welding variables recorded by QC1 appeared to comply with WPS-B-P-2112 and WPS-B-P-2113 as verbally identified by QC1.

Heat straightening of PCMK Tower ND1-SFSA4-90-5. QC was identified as QC1. Heat treatment observed by this QA Inspector and recorded by QC1 appeared to comply with HSR1(T)-11550 as presented to this QA Inspector by QC1.

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Bay 11

This QA Inspector randomly observed no welding related work in progress in Bay 11.

OBG Trial Assembly Area

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

SMAW repair welding of weld joints SEG070A-012, SEG072A-043 located outside PCMK OBG 11CE/11DE, side plate to bottom plate, holdback welds, south (bikepath) side. Welder was identified as 053871. QC was identified as ZPMC CWI Shi Lei (QC2). Welding variables recorded by QC2 appeared to comply with WPS-345-SMAW-4G(4F)-FCM-repair-1 as displayed on ZPMC Weld Repair Report B-WR17345 presented to this QA Inspector and verbally identified by QC2. ZPMC Weld Repair Report B-CWR17345 referred to ZPMC NDT Report UT-11E-063. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Cao Hai Zhou.

SMAW repair welding of weld joints SEG070A-011, SEG072A-021 located outside PCMK OBG 11CE/11DE, side plate to bottom plate, holdback welds, north (crossbeam) side. Welder was identified as 040320. QC was identified as QC2. Welding variables recorded by QC2 appeared to comply with WPS-345-SMAW-4G(4F)-FCM-repair-1 as displayed on ZPMC Weld Repair Report B-WR17344 presented to this QA Inspector and verbally identified by QC2. ZPMC Weld Repair Report B-CWR17344 referred to ZPMC NDT Report UT-11E-062. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Cao Hai Zhou.

Heat straightening outside of PCMK's OBG 11CW/11DW, side plate, south (crossbeam) side, at transverse joint. QC was identified as QC1. Heat treatment observed by this QA Inspector and recorded by QC2 appeared to comply with HSR1(B)-9863 as presented to this QA Inspector by QC2. A mechanical jack was being employed in the heat straightening process. See photo below. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Cao Hai Zhou.

SMAW welding of weld joint SEG071C-024 located inside PCMK OBG 11DW, longitudinal diaphragm to floor beam, south (crossbeam) side. Welder was identified as 040609. QC was identified as QC2. Welding variables recorded by QC2 appeared to comply with WPS-B-T-2233-TC-U4b-F-1 as displayed on ZPMC Weld Repair Report B-CWR2127 presented to this QA Inspector and verbally identified by QC2. A mechanical jack was being employed to achieve the required the fit-up. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Cao Hai Zhou.

Heavy Dock

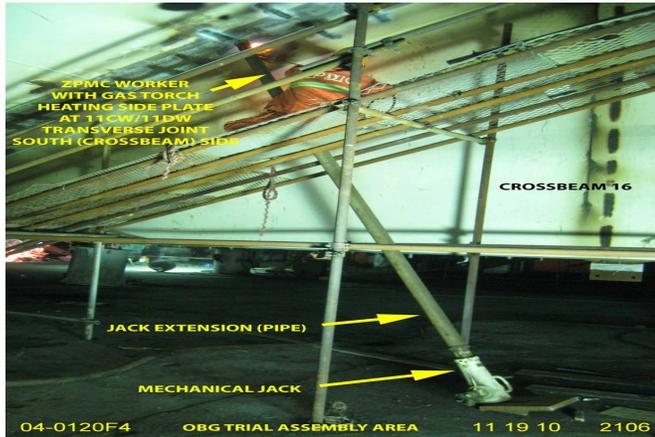
This QA Inspector randomly observed the following on the Heavy Dock:

All 4 towers, lift 4 were positioned on a base pedestal at end of the Heavy Dock. All four towers, lift 5 were positioned on top of the respective lift 4. No work was being performed on the Heavy Dock and no floating crane was in the area of the Heavy Dock.

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

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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
