

**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-019365**Date Inspected:** 12-Jan-2011**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:

FCAW welding of weld joint BK004-033-013 located on PCMK OBG BK004-033. Welder was identified as 040533. QC was identified as Fu Guo Gang (QC1). Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was Deng Zhi Bing (QCA1), who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2132-ESAB as verbally identified by QCA1.

FCAW welding of weld joint BK004-033-021 located on PCMK OBG BK004-033. Welder was identified as 052075. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2132-ESAB as verbally identified by QCA1.

**Bay 11**

This QA Inspector randomly observed the following work in progress in Bay 11:

Tower, lift 5, top plate had been lifted off lift 5 and was positioned on dunnage at the floor level. ZPMC workers were installing additional plates and appeared to be both snug-tight tightening and final tightening of bolt sets

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connecting the transverse diaphragms to the grillage connection plates as well as other attachments at various locations using an air impact gun.

## OBG Trial Assembly Area

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

SMAW welding of temporary alignment plates located outside PCMK OBG 12BW/12CW, side plate, south(crossbeam) side, across transverse joint. Welder was identified as 500764 QC was identified as Shi Lei (QC2). Welding variables recorded by QC2 appeared to comply with WPS-B-P-2114-FCM-1 as verbally identified by QCA.

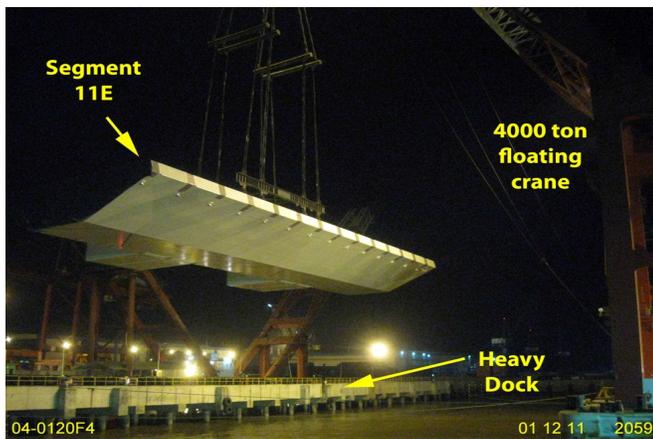
## Heavy Dock

This QA Inspector randomly observed the following work in progress on the Heavy Dock:

The ZPMC 4000 ton floating crane lifted segment 11E from 6 Goldhofer transport/lift vehicles on the Heavy Dock. See photo below of segment 11E being lifted and held over the Heavy Dock.

Four bundles of steel traffic barriers and 3 bike path sections were positioned on the Heavy Dock. All 4 tower, lift 4's; sections CB15 and CB16; several bundles of traffic barrier rails; and 18 bike path sections were on the ship moored at the end of the heavy dock. Several bundles of traffic barrier rails and several other unidentified parts wrapped for shipping were positioned on the Heavy Dock.

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
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<b>Reviewed By:</b>	Riley, Ken	QA Reviewer
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