

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-020202**Date Inspected:** 24-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:** 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 14

This QA Inspector randomly observed the following work in progress in Bay 14:

SMAW repair welding of weld joint SEG-3019F-204 located on PCMK OBG segment 14E. Welder was identified as 067571. QC was identified as ABF CWI Yu Jiao (QC1). Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Zhan Hai Feng (QCA1), who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-345-SMAW-4G(4F)-FCM-repair-1 as verbally identified by QCA1 and displayed on ZPMC Welding Repair Report B-WR20175 presented by QCA1.

SMAW repair welding of weld joint SEG-3019G-200 located on PCMK OBG segment 14E. Welder was identified as 020175. 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-345-SMAW-1G(1F)-FCM-repair-1 as verbally identified by QCA1 and displayed on ZPMC Welding Repair Report B-WR20175 presented by QCA1.

SMAW repair welding of weld joint SEG-3019AV-047 located on PCMK OBG segment 14E. Welder was identified as 067571. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring

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the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-345-SMAW-4G(4F)-FCM-repair-1 as verbally identified by QCA1 and displayed on ZPMC Welding Repair Report B-WR20176 presented by QCA1.

SMAW welding of weld joint SEG-3019BB-059 located on PCMK OBG segment 14E. Welder was identified as 215553. 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-P-2212-TC-U4b-FCM-1 as verbally identified by QCA1.

SMAW welding of weld joint SEG-3019BB-103 located on PCMK OBG segment 14E. Welder was identified as 216083. 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-P-2112-TC-U4b-FCM-1 as verbally identified by QCA1.

FCAW welding of weld joints SEG-3019AG-046~049 located on PCMK OBG segment 14A. Welder was identified as 066763. 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-2231-ESAB as verbally identified by QCA1.

Bay 13

This QA Inspector randomly observed the following work in progress in Bay 13:

FCAW welding of weld joint SA7038C-002 located on OBG segment 13 grillage. Welder was identified as 037723. 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-2231-ESAB as verbally identified by QCA1.

FCAW welding of weld joint SA7038C-007 located on OBG segment 13 grillage. Welder was identified as 066733. 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-2231-ESAB as verbally identified by QCA1. See photo below.

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 Eric Tsang, 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
