

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-020879**Date Inspected:** 20-Feb-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 the Bay 14:

FCAW welding of weld joint DP3160-001-383, 384 located on PCMK OBG 14E, transverse diaphragm to deck plate. Welder was identified as 044824. QC was identified as ZPMC CWI Liu Hua Jie (QC1). Weld variables recorded by QC1 appeared to comply with WPS-B-T-2232-ESAB as verbally identified by QCA1. See photos below of the preheating preparation before welding and interpass cleaning.

SMAW welding of weld joint DP3174-001-018 located on PCMK OBG 14W. Welder was identified as 037780. QC was identified as ABF CWI Li Shi You (QC2). Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Li Ping (QCA2), who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-P-2212-TC-U4b-FCM-1 as verbally identified by QCA2.

SMAW welding of weld joint DP3174-001-019 located on PCMK OBG 14W. Welder was identified as 066480. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was QCA2, who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-P-2212-TC-U4b-FCM-1 as verbally identified by QCA2.

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SMAW repair welding of weld joint SEG3020BB-055 located on PCMK OBG 14W. Welder was identified as 066038. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was QCA2, who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-345-SMAW-2G(2F)-FCM-repair-1 as displayed on ZPMC Weld Repair Report B-CWR2752 presented to this QA Inspector and verbally identified by QCA1.

FCAW welding of weld joint SEG3020BB-114 located on PCMK OBG 14W. Welder was identified as 067949. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was QCA2, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QCA1.

SMAW welding of weld joints SEG3020T-287 located on PCMK OBG 14W. Welder was identified as 067609. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was QCA2, who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-P-2114-FCM-1 as verbally identified by QCA2.

SMAW welding of weld joints SEG3020T-286 located on PCMK OBG 14W. Welder was identified as 067764. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was QCA2, who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-P-2114-FCM-1 as verbally identified by QCA2.

FCAW welding of weld joints SEG3013M-001 located on PCMK OBG 13AW. Welder was identified as 067876. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was QCA2, who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-T-2132-ESAB as verbally identified by QCA2.

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



Summary of Conversations:

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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
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Reviewed By:	Riley,Ken	QA Reviewer
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