

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-022745**Date Inspected:** 18-Mar-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 10

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

FCAW welding of weld joint BK010A1-001-043 located on PCMK OBG bike path. Welder was identified as 040302. QC was identified as ZPMC CWI Yin Chun Fang (QC1). Weld variables recorded by QC1 appeared to comply with WPS-B-T-2232-ESAB as verbally identified by QC1. See photo below of ZPMC welder 040302 removing slag from weld joint BK010A1-001-043 immediately after applying the previous weld pass.

SMAW welding of weld joint BK010A1-001-044 located on PCMK OBG bike path. Welders were identified as 056364, 057258. QC was identified as QC1. Weld variables recorded by QC1 appeared to comply with WPS-B-P-2211-B-U2 as verbally identified by QC1.

SAW welding of weld joint BK15B-001-004 located on PCMK OBG bike path, cantilever beam. Welder was identified as 050295. QC was identified as QC1. Weld variables recorded by QC1 appeared to comply with WPS-B-P-2221-TC-U4a-S as verbally identified by QC1. See photo below showing ZPMC welding leader applying preheat to weld joint BK15B-001-004 using oxy-fuel torch prior to SAW welding.

FCAW welding of weld joint BK3001-001-002 located on PCMK OBG bike path. Welder was identified as

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040365. QC was identified as QC1. Weld variables recorded by QC1 appeared to comply with WPS-B-T-2231-ESAB as verbally identified by QC1.

FCAW welding of weld joints BK17B-001-016, 017 located on PCMK OBG bike path. Welder was identified as 057266. QC was identified as QC1. Weld variables recorded by QC1 appeared to comply with WPS-B-T-2231-ESAB as verbally identified by QC1.

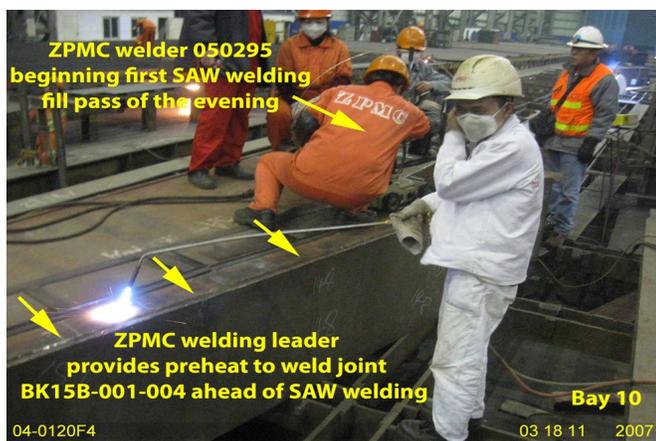
SMAW welding of weld joint BK17B-001-014 located on PCMK OBG bike path. Welder was identified as 040581. QC was identified as QC1. Weld variables recorded by QC1 appeared to comply with WPS-B-P-2213-TC-U4c as verbally identified by QC1.

OBG Trial Assembly Area

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

SMAW repair welding of base metal located on PCMK OBG, segment 13AE, bottom side of bottom plate. Welder was identified as 200113. QC was identified as ZPMC CWI Zhu Zhong Hai (QC2). Weld variables recorded by QC2 appeared to comply with WPS-345-SMAW-4G(4F)-FCM-repair-1 as displayed on ZPMC Weld Repair Report B-CWR2861 as presented to this QA Inspector and verbally identified by QC2.

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

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Inspected By: Goulet, George

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer