

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-022747**Date Inspected:** 20-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:

SMAW welding of weld joints BK010A6-001-044 located on PCMK OBG bike path. Welders were identified as 056364, 057258. QC was identified as ZPMC CWI Zhao Chen Sun (QC1). Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Zhu Feng (QCA1), who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2214-B-U2 as verbally identified by QCA1.

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. 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-2221-TC-U4a-S as verbally identified by QCA1. See photos below of the cantilever beam being rotated using the overhead crane and then weld joint BK15B-001-004 being preheated before SAW welding began.

FCAW welding of weld joints BK010A8-043, 044 located on PCMK OBG bike path. Welder was identified as 040302. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding

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operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2133-ESAB as verbally identified by QCA1.

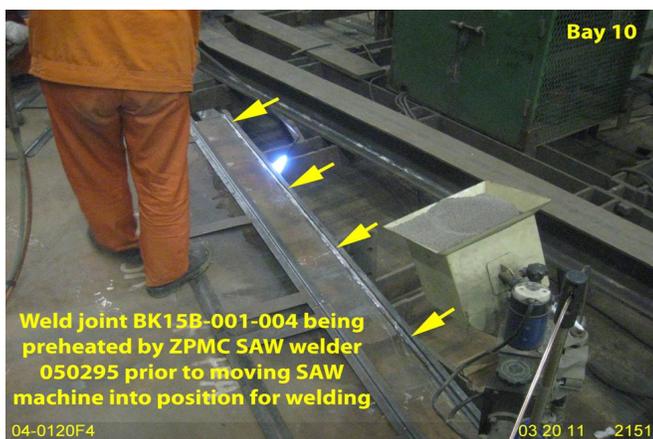
SMAW welding of weld joints 31TR1-001-051, 052 located on PCMK OBG traveler rail. Welder was identified as 040581. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2211-B-U2 as verbally identified by QCA1.

SMAW welding of weld joints 31TR2-001-053, 056 located on PCMK OBG traveler rail. Welder was identified as 040365. 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-2211-B-U2 as verbally identified by QCA1.

SMAW welding of weld joint 31TR1-001-016 located on PCMK OBG traveler rail. Welder was identified as 057220. 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-U5b as verbally identified by QCA1.

SMAW repair welding of multiple areas at weld joints 26TR1-008, 016 located on PCMK OBG traveler rail. Welder was identified as 044511. 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-2G(2F)-repair as displayed on ZPMC Weld Repair Report B-WR20420 as presented to this QA Inspector and verbally identified by QCA1.

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



Summary of Conversations:

As noted above.

Comments

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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
