

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-024585**Date Inspected:** 31-May-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.

OBG Trial Assembly Area

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

SMAW welding of weld joint DP3172-001-017 located on PCMK OBG 13CW. Welder was identified as 067275.

QC was identified as ZPMC CWI Li Peng Fei (QC1). Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Wang Xian Pin (QCA1), who was not a CWI.

Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1 as verbally identified by QCA1.

SMAW welding of weld joints SEG3007AH-061~064 located on PCMK OBG 13AE. Welders were identified as 068859, 200113. QC was identified as ZPMC QC Zhan Hai Feng (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,

WPS-B-P-2213-TC-U4b-FCM-1, and WPS-B-P-2214-TC-U4b-FCM-1 as verbally identified by QCA2.

FCAW repair welding of weld joint SEG3020D-038 located on PCMK OBG 14W. Welder was identified as 058245. 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

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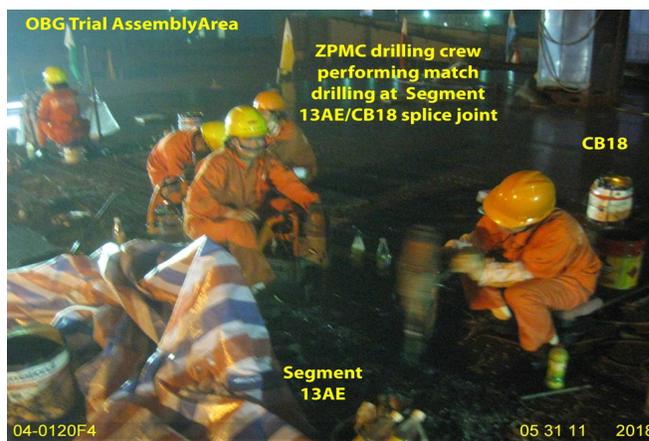
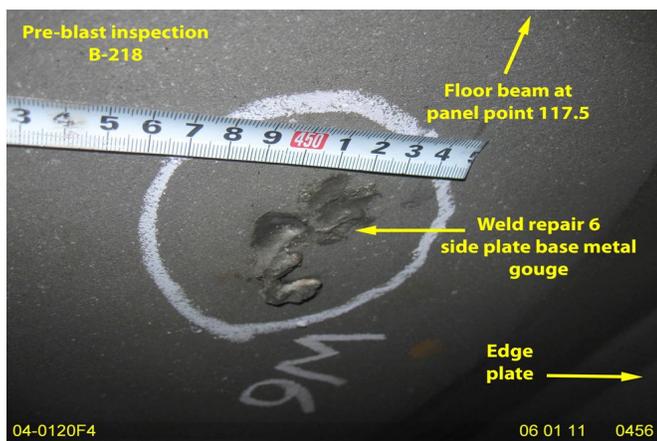
comply with WPS-345-FCAW-2G(2F)-FCM-repair-1 as displayed on ZPMC Weld Repair Report B-CWR2997 as presented to this QA Inspector and verbally identified by QCA1.

Match drilling into deck plate of PCMK crossbeam 18 through previously drilled holes in splice plate at the 13AE/CB18 longitudinal joint. See photo below of drilling crew continuing to work during a light to moderate rainfall.

SMAW repair welding of various side plate I-rib to floor beam weld joints located on PCMK OBG 13BE at panel points 121 to 121.5, crossbeam side. Welder was identified as 069866. QC was identified as ZPMC QC1. Assisting QC1 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-3G(3F)-FCM-repair-1 as verbally identified by QCA2.

This QA Inspector and QA Inspector Paul Dawson (QA2) responding to phone notification from ABF Inspectors performed a pre-final sandblast inspection of Segment 13AW, side plate, south (crossbeam) side, between panel points 117.3 and 118. This QA Inspector and QA2 observed 7 indications appearing to require weld repair as well as surface irregularities requiring grinding. These areas were marked and documented. See photo below of one of the 7 indications of a 4mm to 5mm gouge in the side plate base metal approximately 600mm from the panel point 117.3 edge of Segment 13AW and 300mm from the edge plate.

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 James Devey 15000026784, who represents the Office of Structural Materials for your project.

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