

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-024775**Date Inspected:** 06-Jun-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:

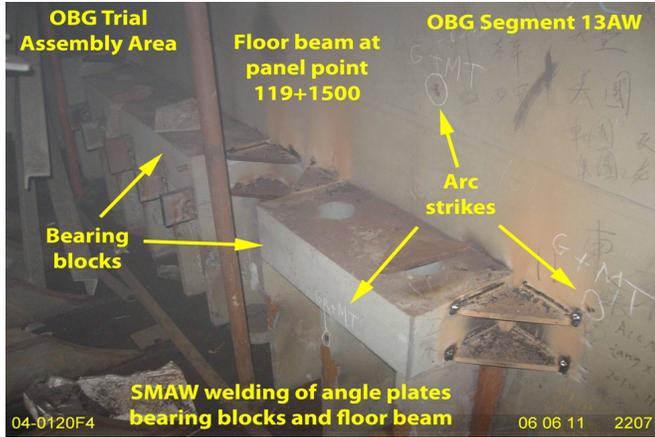
SMAW welding of angle plates to floor beam and angle plates to bearing blocks located on PCMK OBG 13AW at panel point 119+1500. Welders were identified as 068917, 070009. QC was identified as ABF CWI Wang Jun (QC1). Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was Zhang Lin (QCA1), who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2112-FCM-1 and WPS-B-P-2114-FCM-1 as verbally identified by QCA1. QCA1 also informed this QA Inspector that no weld numbers had been assigned to the above noted welds.

SMAW welding of angle plates to floor beam and angle plates to bearing blocks located on PCMK OBG 13AW at panel point 119-1500. Welders were identified as 066673, 066674, 066891, 067275. 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-FCM-1 and WPS-B-P-2114-FCM-1 as verbally identified by QCA1. QCA1 also informed this QA Inspector that no weld numbers had been assigned to the above noted welds. See photo below of typical SMAW welds having been performed at the above noted locations. Note the arc strikes observed and marked for grinding and magnetic particle testing (MT).

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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.

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