

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-016561**Date Inspected:** 28-Aug-2010**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:** Tower 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 11

This QA Inspector randomly observed the following work in progress in Bay 11:

SMAW welding of weld joint WSD1-TL5-4B/F-1 located on PCMK west tower, lift 5, internal connection plate to skin C. Alternating welders were identified as 066401, 066398. QC was identified as ZPMC CWI Qiu Wen (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC CAWI Liu Dao Feng (QCA1), who was not a CWI. Welding variables recorded by QCA1 appeared to comply with WPS-B-T-3213-TC-U4c. Also present and appearing to be monitoring the welding operation was ABF Representative Cui Zheng Hua.

Bay 10

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

SMAW welding of weld joint SSD1-TL5-1B-F-19 located on PCMK south tower, lift 5, internal connection plate to skin D. Alternating welders were identified as 500363, 056200. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Li Peng Fei (QCA2), who was not a CWI. Welding variables recorded by QCA2 appeared to comply with WPS-B-T-3213-TC-U4c.

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SMAW welding of weld joint SSD1-TL5-1B-F-16 located on PCMK south tower, lift 5, internal connection plate to skin C. Alternating welders were identified as 044511, 050289. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was QCA2, who was not a CWI. Welding variables recorded by QCA2 appeared to comply with WPS-B-T-3213-TC-U4c.

SMAW welding of weld joint NSD1-TL5-3B-F-23A located on PCMK north tower, lift 5, external connection plate to skin A at the skin E corner. Welder was identified as 066258. QC was identified as ABF CWI Yang Yi Heng (QC2). Welding variables recorded by QC2 appeared to comply with WPS-B-T-3213-TC-U5b.

SMAW repair welding of weld joint NSD1-TL5-3B-F-17A located on PCMK north tower, lift 5, external connection plate to skin A. Welder was identified as 070432. QC was identified as QC2. Welding variables recorded by QC2 appeared to comply with WPS- B-T-3213-TC-U5b.

SMAW welding of weld joint NSD1-TL5-3B-F-4 located on PCMK north tower, lift 5, internal connection plate to skin D. Alternating welders were identified as 067707, 068924. QC was identified as QC2. Welding variables recorded by QC2 appeared to comply with WPS-B-T-3213-TC-U4c.

SMAW welding of weld joint NSD1-TL5-3B-F-9 located on PCMK north tower, lift 5, internal connection plate to skin C. Alternating welders were identified as 066216, 037996. QC was identified as QC2. Welding variables recorded by QC2 appeared to comply with WPS-B-T-3213-TC-U4c.

FCAW welding of temporary staging brace to PCMK south tower, lift 4, skin D at 144.3M elevation. Welder was identified as 052075. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was QCA2, who was not a CWI. Welding variables recorded by QCA2 appeared to comply with WPS-B-P-4132 and WPS-B-P-4133.

Heavy Dock

This QA Inspector randomly observed the following work being performed on the Heavy Dock:

This QA Inspector observed ZPMC personnel loading various components onto the lift's 3, but no apparent welding related work was being performed on the Heavy Dock. All 4 tower lift's 3 were connected and positioned vertically on a base pedestal at end of the Heavy Dock. East, west and north towers, lift 2 were positioned horizontally near the end of the Heavy Dock.

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

Summary of Conversations:

No significant conversations.

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 Micheal Ng, 159-2184-5703, 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:	Dawson,Paul	QA Reviewer
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