

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-016621**Date Inspected:** 30-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 and 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 11

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

SMAW welding of weld joint WSD1-TL5-4B/F-5 located on PCMK west tower, lift 5, internal connection plate to skin D. 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.

SMAW welding of weld joint WSD1-SPSA5-7-2A located on PCMK west tower, lift 5, internal splice plate assembly. Welder was identified as 046769. QC was identified as QC1. Welding variables recorded by QC1 appeared to comply with WPS-B-T-3212-TC-U5b-1.

SMAW welding of weld joint ESD1-TL5-2B/F-18 located on PCMK east tower, lift 5, internal connection plate to skin D. Alternating welders were identified as 040614, 202100. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was QCA1, who was not a CWI. Welding variables recorded by QCA1 appeared to comply with WPS-B-T-3213-TC-U4c.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

SMAW welding of weld joint ESD1-TL5-2B/F-15 located on PCMK east tower, lift 5, internal connection plate to skin C. Alternating welders were identified as 041271, 040667. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was QCA1, who was not a CWI. Welding variables recorded by QCA1 appeared to comply with WPS-B-T-3213-TC-U4c.

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.

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-5 located on PCMK north tower, lift 5, internal connection plates. Alternating welders were identified as 066361, 066258. QC was identified as QC2. 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-10 located on PCMK north tower, lift 5, internal connection plates. Alternating welders were identified as 066236, 037996. QC was identified as QC2. 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.

Trial Assembly Area

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

SMAW welding of temporary alignment stiffener plate located on PCMK OBG 10CW, bottom plate at the 10BW/10CW longitudinal joint between side plate and bottom plate on the north (counterweight) side. Welder was identified as 218707. QC was identified as ZPMC CWI Zhao Chen Sun (QC2). Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Fu Wei Min (QCA3), who was not a CWI. Welding variables recorded by QCA3 appeared to comply with WPS-B-P-2114-FCM-1.

SMAW welding of temporary alignment stiffener plate located on PCMK OBG 10BW, bottom plate at the 10BW/10CW longitudinal joint between side plate and bottom plate on the south (crossbeam) side. See photo below. Welder was identified as 500433. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was QCA3, who was not a CWI. Welding variables recorded by QCA3 appeared to comply with WPS-B-P-2114-FCM-1.

Heavy Dock

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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

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. All 4 tower, lift's 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.

Inspected By:	Goulet,George	Quality Assurance Inspector
Reviewed By:	Dawson,Paul	QA Reviewer
