

**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-016789**Date Inspected:** 12-Sep-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 repair welding of weld joint WSD1-TL5-4B/F-24 located on PCMK west tower, lift 5, internal connection plates. Alternating welders were identified as 067520, 037743. QC was identified as ZPMC CWI Liu Yang (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Li Bin (QCA1), who was not a CWI. Welding variables recorded by QCA1 appeared to comply with WPS-485-SMAW-3G(3F)-repair as listed on ZPMC Repair Report T-WR3581.

**Bay 10**

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

SAW welding of weld joint EP3029-001-001, located on PCMK OBG edge plate. Welder was identified as 050295. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Sun Tian Liang (QCA2), who was not a CWI. Welding variables recorded by QCA2 appeared to comply with WPS-B-T-2221-B-L2c-S-2.

SMAW repair welding of weld joint SSD1-TL5-1B-F-53 located on PCMK south tower, lift 5, internal connection

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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plate to skin E. Alternating welders were identified as 050063, 057258. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC CWI Yu Zhi Lai (QCA3), who was not a CWI. Welding variables recorded by QCA3 appeared to comply with WPS-485-SMAW-3G(3F)-repair as listed on ZPMC Repair Report T-WR3592.

SMAW repair welding of weld joint NSD1-TL5-3F-F-10B located on PCMK north tower, lift 5, internal connection plates. Welder was identified as 500363. QC was identified as QC1. Assisting QC1 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-485-SMAW-3G(3F)-repair as listed on ZPMC Repair Report T-WR3583.

### Heavy Dock

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 towers' lift 3 were connected and positioned vertically on a base pedestal at end of the Heavy Dock. East and south towers, lift 4 were positioned on top of east and south towers, lift 3, respectively, on the Heavy Dock, near the end where the ship was moored. All 4 towers' lift 2 were positioned horizontally on the deck of the ship at the end of the Heavy Dock.

OBG9W was positioned on top of OBG 9E on the deck of the ship. CB11 and CB12 were also positioned on the deck of the the ship.

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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<b>Inspected By:</b>	Goulet,George	Quality Assurance Inspector
<b>Reviewed By:</b>	Dawson,Paul	QA Reviewer

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