

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-016956**Date Inspected:** 18-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 tack welding of T stiffeners to bike path deck located on PCMK BK4A. Welder was identified as 052641.

QC was identified as ZPMC CWI Xu Le Feng (QC1). Welding variables recorded by QC1 appeared to comply with WPS-B-P-2212. QC1 was unable to provide weld numbers to this QA Inspector, claiming the work was only fit-up and tack welding.

SMAW repair welding of weld joint ESD1-TL5-2E/F-20A located on PCMK east tower, lift 5, internal connection plates. Welders were identified as 040723, 046704. QC was identified as QC1. Welding variables recorded by QC1 appeared to comply with WPS-485-SMAW-3G(3F)-repair as listed on ZPMC Repair Report T-WR3629.

SMAW repair welding of weld joint ESD1-TL5-2E/F-33A located on PCMK east tower, lift 5, external connection plate to skin E. Welder was identified as 046704. QC was identified as QC1. Welding variables recorded by QC1 appeared to comply with WPS-485-SMAW-3G(3F)-repair as listed on ZPMC Repair Report T-WR3595. See photo below.

Heavy Dock

WELDING INSPECTION REPORT

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This QA Inspector randomly observed the following 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, south, and north towers, lift 4 were positioned on top of east, south, and north towers, lift 3, respectively, on the Heavy Dock. West tower, lift 4 was positioned horizontally on the deck of the dock. The ship that had been moored at the end of the dock for several days was no longer there. The ZPMC 4000 ton floating crane was moored to the end of the Heavy Dock and sitting idle.

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 Micheal Ng, 159-2184-5703, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
