

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-016958**Date Inspected:** 19-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:

FCAW tack welding of weld joints BK004A5-021-076, 077, 082, 083 located on PCMK BK4A, T-stiffeners to bike path deck. Welders were identified as 040736, 049220. 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 CWI Li Bin (QCA1), who was not a CWI. Welding variables recorded by QCA1 appeared to comply with WPS-B-T-2132.

SMAW tack welding of T-stiffeners to bike path deck located on PCMK BK4A1-017. Welder was identified as 220191. 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. When asked, QCA1 was unable to provide weld numbers to this QA Inspector in a timely manner. Welding variables recorded by QCA1 appeared to comply with WPS-B-P-2112.

Bay 10

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

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

FCAW tack welding of weld joints BK004A5-026-056, 057, 062, 063 located on PCMK BK4A, T-stiffeners to bike path deck. Welders were identified as 052075, 033116, 057180, 054069. 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 (QCA2), who was not a CWI. Welding variables recorded by QCA2 appeared to comply with WPS-B-T-2132.

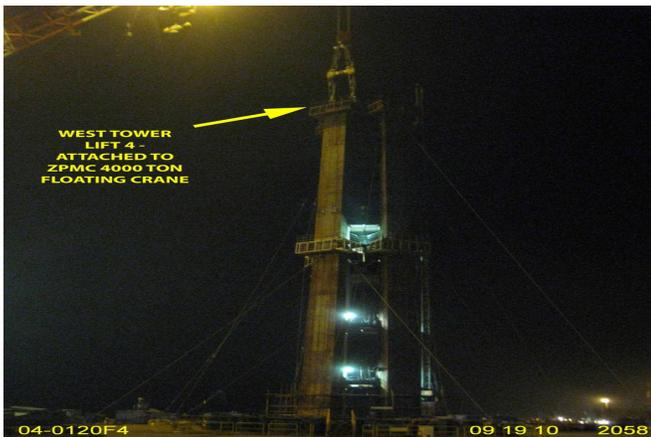
SMAW tack welding of joints BK004A2-027-018, 019 located on PCMK BK4A2, T-stiffeners to bike path deck. Welder was identified as 057242. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was QCA2, who was not a CWI. Welding variables recorded by QCA2 appeared to comply with WPS-B-P-2112.

Heavy Dock

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, west, and north towers, lift 4 were positioned on top of east, south, west, and north towers, lift 3, respectively, on the Heavy Dock. The ZPMC 4000 ton floating crane was rigged to the top of west tower, lift 4 as it was positioned on top of west tower, lift 3, but no apparent work was being performed on the tower sections. See photo below.

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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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