

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-017509**Date Inspected:** 28-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 weld joints BK005A7-003-093~096 located on PCMK BK005A7-003. Welder was identified as 202319. QC was identified as ZPMC CWI Zhao Chen Sun (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Shao Hai Lang (QCA1), who was not a CWI. Welding variables recorded by QCA1 appeared to comply with WPS-B-P-2114.

Arc strike alongside the welds marked as BK004A3-022-012, BK004A3-022-013, BK004A3-022-014 located on PCMK BK4A. The arc strike had been marked in soapstone with the letter G only, signifying 'grind smooth'.

This QA Inspector clearly marked the visual indication in yellow paint with G+MT, signifying 'grind smooth and magnetic particle test'. See the photo below. This QA Inspector also notified QCA1 of the arc strike. QCA1 informed this QA Inspector that the arc strike would be corrected in a manner compliant with the contract documents.

SMAW repair welding of weld joint ESD1-TL5-2E/F-8A located on PCMK east tower, lift 5, internal connection plates. Welder was identified as 046769. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Mao Bin Bin (QCA2), who was not a

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CWI. Welding variables recorded by QCA2 appeared to comply with WPS-485-SMAW-3G(3F)-repair as listed on ZPMC Weld Repair Report T-WR3664 attached to ZPMC Ultrasonic Testing Report T787-UT-3251 as presented to this QA Inspector and verbalized by QCA2.

Bay 10

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

Eight ABF personnel on top of PCMK north tower, lift 5, preparing to perform ultrasonic testing of vertical stiffener plate weld joints.

OBG Trial Assembly Area

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

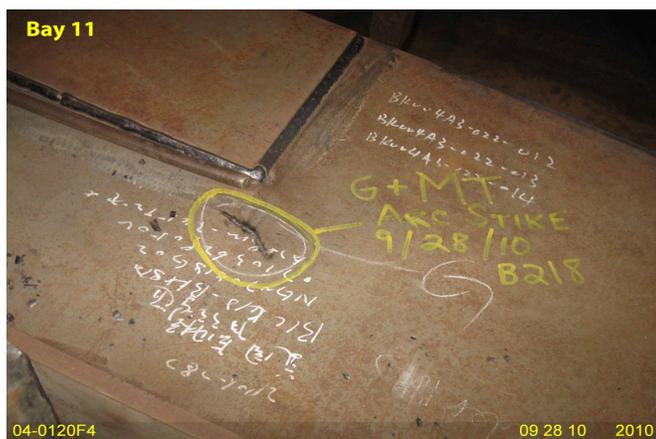
SMAW welding of temporary alignment plates located on OBG 11AE, panel point 95, deck plate to bike path cantilever beam. Welder was identified as 040334. QC was identified as ZPMC CWI Liu Hua Jie (QC2). Welding variables recorded by QC2 appeared to comply with WPS-B-P-2112-FCM-1.

Heavy Dock

This QA Inspector randomly observed the following on the Heavy Dock:

No apparent 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 and 1300 ton floating cranes were moored at or near 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.

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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
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Reviewed By:	Clifford,William	QA Reviewer
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