

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-017515**Date Inspected:** 02-Oct-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 ESD1-TL5-2E/F-8A located on PCMK east tower, lift 5, external connection plate at skins A/E corner. Alternating welders were identified as 046769, 044541. QC was identified as ZPMC CWI Yu Dong Ping (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Xu Jie (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 Weld Repair Report T-WR3702 attached to ZPMC Ultrasonic Testing Report T787-UT-3263 as presented to this QA Inspector and verbalized by QC1.

Bay 10

This QA Inspector randomly observed no apparent work in progress in Bay 10.

OBG Trial Assembly Area

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

SMAW repair welding of weld joint SEG064A-044 located on PCMK OBG, segment 10CE, bottom plate to side

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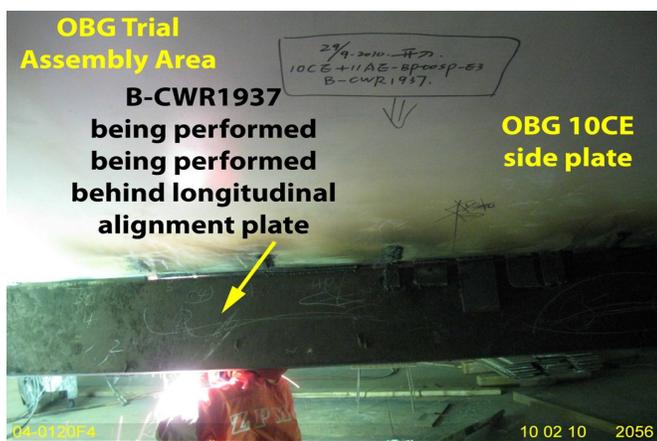
plate joint, south (bikepath) side, at Y+2140 from the 10CE/11AE transverse joint. Welder was identified as 053871. QC was identified as ZPMC CWI Liu Hua Jie (QC2). Welding variables recorded by QC2 appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1 as listed on ZPMC Weld Repair Report B-CWR1937 as presented to this QA Inspector and verbalized by QC1. No nondestructive examination (NDE) report was attached. QC2 informed this QA Inspector that the joint was originally welded in a misaligned condition before this repair was performed.

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 1300 ton floating crane was moored to 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
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Reviewed By:	Clifford, William	QA Reviewer
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