

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-017552**Date Inspected:** 03-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 tack welding of weld joint BK004A1-020-020-005 located on PCMK BK004A1-020. Welder was identified as 220191. 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 Mao Bin Bin (QCA1), who was not a CWI. Welding variables recorded by QCA1 appeared to comply with WPS-B-T-2112-TC-U4c.

FCAW welding of weld joint BK005B-004-008 located on PCMK BK005B-004. Welder was identified as 040723. 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. Welding variables recorded by QCA1 appeared to comply with WPS-B-T-2231-B-U2-F.

SMAW of weld joint SD1-BRSA5-1-12A located on PCMK south tower, lift 5. Welder was identified as 046792. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Zhao Mao Mao (QCA2), who was not a CWI. Welding variables recorded by QC2 appeared to comply with WPS-B-T-3213-TC-U4b.

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SMAW of weld joint SD1-BRSA5-1-8B located on PCMK south tower, lift 5. Welder was identified as 041271. 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 QC2 appeared to comply with WPS-B-T-3213-TC-U4b.

During random in process inspection of tower member identified as SD1-BRSA5-1 this QA Inspector observed an arc strike on the edge of the stiffener between the welds marked as SD1-BRSA5-1-9A/B located on PCMK SD1-BRSA5-1-BR5-5. The arc strike had been marked in black ink 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 QCA2 of the arc strike. QCA2 informed this QA Inspector that the arc strike would be corrected in a manner compliant with the contract documents.

Bay 10

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

Heavy Dock

This QA Inspector randomly observed the following 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 personnel access elevator made stops at several elevation levels and sounds of drilling could be heard from the deck of 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.

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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
Reviewed By:	Clifford,William	QA Reviewer
