

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-017587**Date Inspected:** 18-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 welding of end longitudinal stiffeners to end transverse stiffener and deck plate located on PCMK OBG BK004-020. Welder was identified as 052641. No ZPMC QC, ZPMC CWI, or ABF representative was observed in the area of the welding being performed. The welder stopped welding and all ZPMC personnel left the area within approximately 15 minutes of this QA Inspector's arrival at the work site.

SMAW welding of weld joint BK004A1-017-008 located on PCMK OBG BK004-017, bent edge plate to bottom plate. Welder was identified as 201500. No ZPMC QC, ZPMC CWI, or ABF representative was observed in the area of the welding being performed. The welder stopped welding and all ZPMC personnel left the area within approximately 15 minutes of this QA Inspector's arrival at the work site.

Bay 10

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

OBG Trial Assembly Area

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

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SMAW welding of 16mm x 310mm x 600mm temporary stiffener plate to floor beam and bottom plate located inside on both sides of OBG 11BE, panel point 98. Welder was identified as 052930. QC was identified as ZPMC CWI Liu Hua Jie (QC1). Welding variables recorded by QC1 appeared to comply with WPS-B-P-2112-FCM-1, WPS-B-P-2113-FCM-1345-SMAW-2G(2F)-FCM-repair-1. QC1 informed this QA Inspector that this plate was being installed to brace the bottom plate in the area where a new stanchion would be subsequently placed.

SMAW welding of temporary alignment plates outside and across the OBG 11BE/11CE transverse joint, bottom plate to bottom plate and side plate to side plate, north (crossbeam) side. Welders were identified as 056364, 052930. QC was identified as QC1. Welding variables recorded by QC1 appeared to comply with WPS-B-P-2114-1.

SMAW repair welding of the hold-back welds of deck plate I stiffeners and web I stiffeners located on the south end (eastbound side) of CB13, panel point 86 to panel point 88. Welders were identified as 044504, 040378. QC was identified as QC1. Welding variables recorded by QC1 appeared to comply with WPS-345-SMAW-2G(2F)-FCM-repair-1, WPS-345-SMAW-4G(4F)-FCM-repair-1 as identified by QC1. QC1 informed this QA Inspector that the reason for repair was the result of visual testing (VT). Also present at this location and appearing to be monitoring the welding operation were ABF Representatives Zhang Xi Li and Zang Xiao Bin.

Heavy Dock

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

All 4 towers, lift 4 were positioned on a base separate pedestal at end of the Heavy Dock. South tower, lift 3 was positioned horizontally on stanchions on the deck at the end of the Heavy Dock. No work was being performed on any of the tower components and no ZPMC floating cranes were moored to the Heavy Dock or in the area.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No significant conversations.

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
