

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-017801**Date Inspected:** 27-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**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 lifting pad located on PCMK OBG BK005A-003, at bent side plate below corner insert. Welder was identified as 202319. QC was identified as ZPMC CWI Fu Guo Gang (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Zhao Mao Mao (QCA1), who was not a CWI. Welding variables recorded by QCA1 appeared to comply with WPS-B-P-2113 and WPS-B-P-2114 as identified by QCA1.

FCAW welding of weld joint BK004A2-018-013 located on PCMK OBG BK004-018, bent side plate to bottom plate. Welder was identified as 205649. 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-2132 as identified by QCA1.

FCAW welding of weld joints BK004ASD1-021-022, 023, 024, 027 located on PCMK OBG BK004-021, at end of bearing plate. Welder was identified as 205649. 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-2132 as identified by QCA1.

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Bay 10

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

FCAW welding of weld joints GGL-MQ-1958-018-001, 002 located on PCMK OBG GGL-MQ-1958-018, welded channel splice. Welder was identified as 052763. QC was identified as ZPMC CWI Zhao Chen Sun (QC2). Assisting QC2 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-T-2231-TC-U5-F as verbally identified by QCA2.

OBG Trial Assembly Area

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

SMAW welding of longitudinal temporary alignment plate located on PCMK OBG 11CE/11DE, side plate to side plate, north (crossbeam) side, across transverse joint. Welder was identified as 048262. QC was identified as ZPMC CWI Liu Hua Jie (QC3). Welding variables recorded by QC3 appeared to comply with WPS-B-P-2214-FCM-1 as verbalized by QC3.

SMAW welding of weld joint OBW11B-010 located on PCMK OBG 11BW/11CW transverse joint, side plate to side plate, south (crossbeam) side. Welder was identified as 057333. QC was identified as QC3. Welding variables recorded by QC3 appeared to comply with WPS-B-P-2214-B-U2-FCM-1 as verbalized by QC3.

SMAW repair welding of weld joints SEG068A-028 located inside PCMK OBG 11AE/11BE, side plate to edge plate. Welder was identified as 500363. QC was identified as QC3. Welding variables recorded by QC3 appeared to comply with WPS-345-SMAW-2G(2F)-FCM-repair-1 as displayed on ZPMC Weld Repair Report B-WR16264 and verbalized by QC3.

Heavy Dock

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

All 4 towers, lift 4 were positioned on a base pedestal at 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:

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.

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Inspected By:	Goulet, George	Quality Assurance Inspector
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Reviewed By:	Carreon, Albert	QA Reviewer
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