

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-017926**Date Inspected:** 09-Nov-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.

OBG Trial Assembly Area

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

SMAW welding of weld joint OBE11A-010 located inside PCMK OBG 11DE/11EE, transverse joint, edge plate to edge plate, south (bikepath) side. Welder was identified as 053871. QC was identified as ZPMC CWI Liu Hua Jie (QC1). Welding variables recorded by QC1 appeared to comply with WPS-B-P-2214-B-U2-FCM-1 as verbally identified by QC1. Also present and appearing to be monitoring the welding operation and recording data was ABF Representative Wang Zhang Yuan.

SMAW welding of weld joints SP716-001-034, 035 located inside PCMK OBG 11CE/11DE, transverse joint, deck plate I-rib to deck plate I-rib, south (bikepath) side. Welder was identified as 044565. QC was identified as QC1. Welding variables recorded by QC1 appeared to comply with WPS-B-P-2214-B-U2-FCM-1 as verbally identified by QC1.

SMAW repair welding of weld joint OBE11B-007 located inside PCMK OBG 11BE/11CE, transverse joint, side plate and side plate, north (crossbeam) side. Welder was identified as 040484. QC was identified as QC1. Welding variables recorded by QC1 appeared to comply with WPS-345-SMAW-3G(3F)-FCM-repair-1 as displayed on ZPMC Weld Repair Report B-WR15743 presented to this QA Inspector and verbally identified by

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QC1. The ZPMC Weld Repair Report also referred to and was attached to NDT Report UT-11E-045 also listing the repair area.

SMAW repair welding of weld joint OBW11A-021 located outside PCMK OBG 11CW, upper counterweight connection plate to edge plate. Welder was identified as 052935. QC was identified as QC1. Welding variables recorded by QC1 appeared to comply with WPS-345-SMAW-4G(4F)-FCM-repair-1B-T-4114-1 as verbally identified by QC1. QC1 informed this QA Inspector that this repair welding was the result of ZPMC visual testing.

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. OBG segment 10E was positioned on the deck of the ship moored to the end of the Heavy Dock. OBG segment 10W was positioned on top of OBG segment 10E. All four towers, lift 3 were positioned horizontally on the deck of the ship. OBG CB 13 and CB14 were positioned on the deck of the ship. No work was being performed on any of the tower or OBG components on the Heavy Dock or the ship. No ZPMC floating crane was 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.

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