

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-018684**Date Inspected:** 17-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 repair welding of weld joints SEG068A-044, SEG070A-014 in multiple locations outside PCMK OBG 11BE/11CE, holdback welds, side plate to bottom plate, south (bikepath) side. See photo below showing ZPMC worker preparing one of the repairs by grinding. Welders were identified respectively as 040265, 044515. QC was identified as ZPMC CWI Shi Lei (QC1). Welding variables recorded by QC1 appeared to comply with WPS-345-SMAW-4G(4F)-FCM-1 as displayed on ZPMC Weld Repair Report B-CWR2217 presented to this QA Inspector and verbally identified by QC1. QC1 informed this QA Inspector that this welding was being performed to correct indications as a result of ZPMC ultrasonic testing (UT). ZPMC Weld Repair Report B-CWR2217 referred to a ZPMC NDT Report as NA, however ZPMC NDT Report UT-11E-0048R3(pre 48) was attached to the ZPMC Weld Repair Report.

SMAW repair welding of weld joints SEG068A-045, SEG070A-013 in multiple locations outside PCMK OBG 11BE/11CE, holdback welds, side plate to bottom plate, north (crossbeam) side. Welder was identified as 067752. QC was identified as QC1. Welding variables recorded by QC1 appeared to comply with WPS-345-SMAW-4G(4F)-FCM-1 as displayed on ZPMC Weld Repair Report B-CWR2216 presented to this QA Inspector and verbally identified by QC1. QC1 informed this QA Inspector that this welding was being performed

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

to correct indications as a result of ZPMC ultrasonic testing (UT). ZPMC Weld Repair Report B-CWR2216 referred to a ZPMC NDT Report as NA, however ZPMC NDT Report UT-11E-0049R3(pre 48) was attached to the ZPMC Weld Repair Report.

SMAW repair welding of weld joints DP205-016-005~008 inside PCMK OBG CB16 at the FL3 area of 11DW, deck plate I-rib to deck plate I-rib, holdback welds. Welder was identified as 062935. QC was identified as QC1. Welding variables recorded by QC1 appeared to comply with WPS-B-P-2114-FCM-1.

SMAW repair welding of weld joints SEG071E-077, 078, 086087 inside PCMK OBG 11DW, FL3 area at CB16, deck plate I-rib to deck plate I-rib, holdback welds. Welder was identified as 062935. QC was identified as QC1. Welding variables recorded by QC1 appeared to comply with WPS-B-P-2114-FCM-1.

SMAW welding of weld joint SSD25-PP105-047 located inside PCMK OBG 11DW, FL3 area at CB16, longitudinal beam flange butt weld adjacent to panel point 104. Welder was identified as 046704. QC was identified as QC1. Welding variables recorded by QC1 appeared to comply with WPS-B-P-2211-B-U2-FCM-1 as verbally identified by QC1.

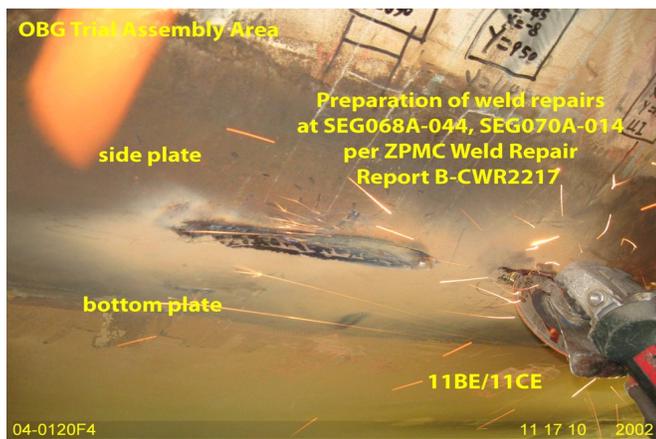
SMAW welding of weld joint SSD25-PP105-223 located inside PCMK OBG 11DW, FL3 area at CB16, vertical beam web to side plate connection plate at panel point 106. Welder was identified as 057333. QC was identified as QC1. Welding variables recorded by QC1 appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1 as verbally identified by QC1.

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. All four towers, lift 5 were positioned on top of the respective lift 4. No apparent work was being performed. The ZPMC 1600 ton floating crane was moored at the head of the Heavy Dock and working on another project.

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



WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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
