

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-018692**Date Inspected:** 27-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 joint SEG070A-012 located outside PCMK OBG 11CE/11DE, holdback welds at the transverse joint, side plate to bottom plate, south (bikepath) side. Welder was identified as 040320. QC was identified as ZPMC CWI Liu Hua Jie (QC1). Welding variables recorded by QC1 appeared to comply with WPS-345-SMAW-4G(4F)-FCM- repair-1 as displayed on ZPMC Weld Repair Report B-CWR2268, rev. 2 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-CWR2268, rev 2 referred to ZPMC NDT Report UT-11E-0063R3 and was attached to the ZPMC Weld Repair Report. Also present at this location and appearing to be monitoring the welding operation and recording data was ABF Representative Wang Zhang Yuan.

SMAW repair welding of weld joint SEG072A-043 located inside PCMK OBG 11CE/11DE, holdback welds at the transverse joint, side plate to bottom plate, south (bikepath) side. Welder was identified as 050289. QC was identified as QC1. Welding variables recorded by QC1 appeared to comply with WPS-345-SMAW-1G(1F)-FCM- repair-1 as displayed on ZPMC Weld Repair Report B-CWR2268, rev. 2 presented to this QA Inspector and verbally identified by QC1. QC1 informed this QA Inspector that this welding was being performed to correct

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indications as a result of ZPMC ultrasonic testing (UT). ZPMC Weld Repair Report B-CWR2268, rev 2 referred to ZPMC NDT Report UT-11E-0063R3 and was attached to the ZPMC Weld Repair Report. Also present at this location and appearing to be monitoring the welding operation and recording data was ABF Representative Wang Zhang Yuan.

SMAW repair welding of weld joints SEG070A-011, SEG072A-021 located outside PCMK OBG 11CE/11DE, holdback welds at the transverse joint, side plate to bottom plate, north (crossbeam) side. Welder was identified as 053871. QC was identified as QC1. Welding variables recorded by QC1 appeared to comply with WPS-345-SMAW-4G(4F)-FCM- repair-1 as displayed on ZPMC Weld Repair Report B-CWR2267, rev. 2 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-CWR2267, rev 2 referred to ZPMC NDT Report UT-11E-0062R3 and was attached to the ZPMC Weld Repair Report. Also present at this location and appearing to be monitoring the welding operation and recording data was ABF Representative Wang Zhang Yuan.

SMAW welding of temporary alignment plates outside on PCMK OBG 11EW/12AW, bottom plate to bottom plate. See photo below. Welder was identified as 057333. QC was identified as QC1. Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Zhou Peng (QCA1), who was not a CWI. Welding variables recorded by QCA1 appeared to comply with WPS-B-P-2114-FCM-1. Also present at this location and appearing to be monitoring the welding operation and recording data was ABF Representative Cao Hai Zhou.

SMAW tack welding of the holdback weld joints inside PCMK OBG 11EE/12AE, deck plate to edge plate. Welder was identified as 040532. QC was identified as QC1. Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Welding variables recorded by QCA1 appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1. Also present at this location and appearing to be monitoring the welding operation and recording data was ABF Representative Cao Hai Zhou.

Heavy Dock

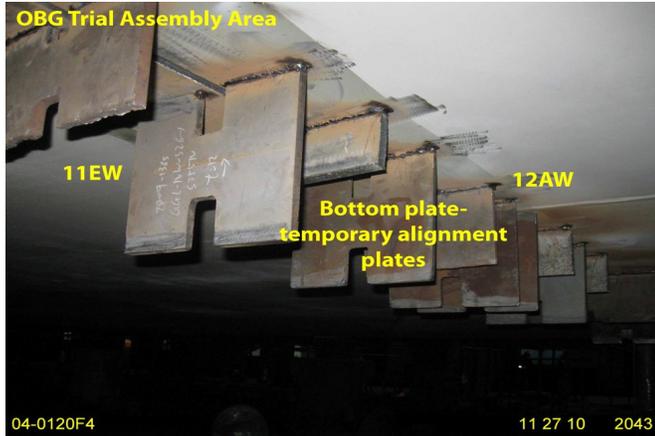
This QA Inspector randomly observed the following on the Heavy Dock:

All four towers, lift 4 were positioned on a base pedestal at end of the Heavy Dock. No apparent work was being performed. No ZPMC floating cranes were in the area of the Heavy Dock.

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

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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
