

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-018699**Date Inspected:** 05-Dec-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:** 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 10

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

FCAW welding of joints NSD1-FCSA6-3-3,4 located on PCMK north tower, lift 6, skin C, I-rib stiffener to skin plate. Welders were identified as 040434, 057258. QC was identified as ZPMC CWI Yu Dong Ping (QC1). Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Li Peng Fei (QCA1), who was not a CWI. Welding variables recorded by QCA1 appeared to comply with WPS-B-T-2132-ESAB as verbally identified by QCA1.

Heat straightening of weld joint BK004A2-025-025 located on PCMK BK004-025. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the heat straightening operation and recording data was QCA1, who was not a CWI. Heat treatment variables recorded by QCA1 appeared to comply with ZPMC document HSR1(B)-9672 as presented to this QA Inspector and verbally identified by QCA1.

Bay 11

This QA Inspector randomly observed no apparent welding in progress in Bay 11. However, ZPMC personnel were observed moving the attached south and east tower, lift 5 sections to a location on the shop floor while in an upright manner and detached from north and west tower, lift 5 sections.

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OBG Trial Assembly Area

This QA Inspector randomly observed no apparent welding work in progress in the OBG Trial Assembly Area.

Heavy Dock

This QA Inspector randomly observed no apparent work was being performed on the Heavy Dock.

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 Eric Tsang, 150-0042-2372, who represents the Office of Structural Materials for your project.

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