

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-018700**Date Inspected:** 07-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:** 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 10

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

FCAW welding of butt weld joint BK004A2-031-018 located on PCMK OBG BK004-031, bottom plate. Welder was identified as 053869. QC was identified as ZPMC CWI Zhao Chen Sun (QC1). Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Li Jun (QCA1), who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2131-ESAB as verbally identified by QCA1.

SMAW welding of joint SSD1-FESA6-1-8 located on PCMK south tower, lift 6, skin E, doubler plate. Welder was identified as 053829. QC was identified as QC1. Assisting QC1 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-T-2132-TC-P4-F as verbally identified by QCA1.

SMAW welding of joints NSD1-FESA6-3-8 located on PCMK north tower, lift 6, skin E, doubler plate. See photo below. Welders were identified as 056364, 040268. QC was identified as QC1. Assisting QC1 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-T-2132-TC-P4-F as verbally identified by

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QCA1.

FCAW repair welding of various weld joints located on PCMK GGL-MQ-2021, splice plates. Welders were identified as 052763, 040367. QC was identified as QC1. Assisting QC1 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-345-FCAW-1G(1F)-ESAB-repair and WPS-345-FCAW-2G(2F)-ESAB-repair as displayed on ZPMC Welding Repair Reports B-WR18407 and B-WR18456 as presented to this QA Inspector and verbally identified by QCA1. The welding repair report did not display the PCMK numbers noted above, however the attached ZPMC Application Forms for NDT B787-UT-17724 listed several pages of PCMK numbers and weld numbers.

Bay 11

This QA Inspector randomly observed no apparent welding related work in progress in Bay 11.

OBG Trial Assembly Area

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

SMAW welding of temporary alignment plates located on PCMK OBG 12AE/12BE, edge plate, south (bikepath) side, across the transverse joint. Welder was identified as 040270. QC was identified as ZPMC CWI Zhu Zhong Hai (QC2). Welding variables recorded by QC2 appeared to comply with WPS-B-P-2114-FCM-1 as verbally identified by QC2.

SMAW welding of temporary alignment plates located on PCMK OBG 12AE/12BE, edge plate, north (crossbeam) side, across the transverse joint. Welder was identified as 044315. QC was identified as QC2. Welding variables recorded by QC2 appeared to comply with WPS-B-P-2114-FCM-1 as verbally identified by QC2.

Heavy Dock

This QA Inspector randomly observed no apparent work being performed on 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 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
