

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-018999**Date Inspected:** 25-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 and Tower 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:

SMAW welding of weld joints BK004-031-015, 017 located on PCMK OBG BK004-031. Welders were identified respectively as 040434, 044511. QC was identified as ZPMC CWI Guo Yan Fei (QC1). Weld variables recorded by QC1 appeared to comply with WPS-B-P-2112-Plug as verbally identified by QC1.

SMAW tack welding of weld joint BK004-031-013 located on PCMK OBG BK004-031. Welder was identified as 057242. QC was identified as QC1. Weld variables recorded by QC1 appeared to comply with WPS-B-P-2112 as verbally identified by QC1.

SMAW repair welding of weld joint BK004A5-033-008 located on PCMK OBG BK004-033. Welder was identified as 500363. QC was identified as QC1. Weld variables recorded by QC1 appeared to comply with WPS-345-SMAW-2G(2F)-repair as verbally identified by QCA1. A ZPMC Weld Repair Report displaying no identification number. However, the report did list a related NDT report number as B787-UT-7838.

Bay 11

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

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However, various match drilling operations were being performed including drilling of PCMK SD1-BRS5-1 through a template using a magnetically attached drill press. See photo below.

OBG Trial Assembly Area

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

However, match drilling operations were being performed on various OBG splice plates using a magnetically-attached drill press.

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.



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
