

**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-019178**Date Inspected:** 28-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 temporary lifting eye to bent edge plate located on PCMK OBG BK004-033. Welder was identified as 052930. QC was identified as Zhao Chen Sun (QC1). Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Shao Hai Lang (QCA1), who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2213 as verbally identified by QCA1. See photo below.

FCAW welding of temporary lifting eye to straight edge plate located on PCMK OBG BK004-033. Welder was identified as 040302. 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. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QCA1.

Heat straightening on PCMK BK004-031. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the heat straightening operation and recording data was QC1. Heat treatment variables recorded by QC1 appeared to comply with ZPMC document HSR1(B)-9685 as presented to this QA Inspector and verbally identified by QC1.

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## Bay 11

This QA Inspector randomly observed the following work in progress in Bay 11:

SMAW tack welding of PCMK OBG BK004-024, end plate to bearing plate, deck plate, and edge plates. Welder was identified as 052641. QC was identified as QC1. Weld variables recorded by QC1 appeared to comply with WPS-B-P-2112 and WPS-B-P-2113 as verbally identified by QC1. QC1 informed this QA Inspector that he did not record the weld numbers because the operation being performed was tack welding only.

Various match drilling operations were being performed including drilling of holes in PCMK ND1-BRS5-2 and various other plates and angles using magnetically attached drill presses.

## OBG Trial Assembly Area

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

Match drilling operations were being performed on various OBG splice plates positioned on pallets using magnetically-attached drill presses.

## 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.

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<b>Inspected By:</b>	Goulet, George	Quality Assurance Inspector
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<b>Reviewed By:</b>	Riley, Ken	QA Reviewer
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