

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-019179**Date Inspected:** 29-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 11

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

ZPMC workers were performing bolting operations on east and south towers, lift 5, attaching the 2 towers sections at the connection plates from skin E.

ZPMC workers moved the attached north and west towers, lift 5, positioned horizontally onto the ends of skin A connection plates on dunnage on the shop floor using the overhead crane. See photo below of the attached shaft sections being lowered into place.

Bay 10

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

SMAW tack welding of PCMK NSD1-FASA6, north tower, lift 6, skin A to diaphragm. Welder was identified as 052892. 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 Yu Zhi Lai (QCA1), who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2112 as verbally identified by QCA1.

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Heat straightening of PCMK's SA3149B and SA3121A. 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 HSR9996 and HSR9991 respectively as presented to this QA Inspector and verbally identified by QCA1. The HSR documents appeared to be written mostly in Chinese and the HSR numbers were handwritten without the HSR(B)1 notation that is normally part of the the HSR documentation identification. The parts being heat treated appeared to be associated with OBG.

Bay 14

This QA Inspector randomly observed the following work in progress in Bay 14:

FCAW welding of weld joint SEG3013AH-032 located on PCMK OBG segment 13AE. Welder was identified as 207465. QC was identified as ZPMC CWI Bao Qian (QC2). Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Li Ping (QCA2), who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-T-2232-ESAB as verbally identified by QCA1.

OBG Trial Assembly Area

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

Heavy Dock

This QA Inspector randomly observed no apparent work in progress 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

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your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
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Reviewed By:	Riley, Ken	QA Reviewer
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