

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-019291**Date Inspected:** 02-Jan-2011**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 11

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

SMAW welding of weld joint BK012A1-001-009 located on PCMK OBG BK012-001. Welder was identified as 052641. QC was identified as ZPMC CWI Yu Dong Ping (QC1). Weld variables recorded by QC1 appeared to comply with WPS-B-P-2211-B-U2b as verbally identified by QC1.

ZPMC workers were performing match drilling operations at the top of east and south towers, lift 5, skin D and drilling various other parts at the floor level, all using magnetically attached drill presses. See photo below.

Bay 10

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

SMAW welding of weld joint NSD1-FDSA6-3 located on PCMK tower, lift 6, skin D. Welder was identified as 057239. QC was identified as 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. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2312-TC-U4b-1 as verbally identified by QCA1.

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FCAW welding of weld joints BK004A6-033-070, 078, 088, 098 located on PCMK OBG BK004-033. Welder was identified as 040434. 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-2332-ESAB as verbally identified by QCA1.

FCAW welding of weld joints BK004A8-033-070, 078, 088, 098 located on PCMK OBG BK004-033. Welder was identified as 052075. 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-2332-ESAB as verbally identified by QCA1.

Bay 14

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

SMAW repair welding of weld joint SEG3007AT-030 located on PCMK OBG segment 13AE. Welder was identified as 215553. QC was identified as ZPMC CWI Yu Jiao (QC2). Weld variables recorded by QC2 appeared to comply with WPS-345-FCAW-2G(2F)-FCM-repair-1 as listed on ZPMC Weld Repair Report B-WR19218 presented to this QA Inspector and as verbally identified by QC2.

SMAW repair welding of weld joint SEG3007U-250 located on PCMK OBG segment 13AE. Welder was identified as 216086. QC was identified as QC2. Weld variables recorded by QC2 appeared to comply with WPS-345-FCAW-1G(1F)-FCM-repair-1 as listed on ZPMC Weld Repair Report B-WR19258 presented to this QA Inspector and as verbally identified by QC2.

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.



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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 Micheal Ng, 159-2184-5703, who represents the Office of Structural Materials for your project.

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