

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-019358**Date Inspected:** 04-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 10

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

SMAW welding of weld joints BK004A8-032-002, 007, 130 located on PCMK OBG BK004-032, end plate to bearing plate, deck plate, and edge plate. Welder was identified as 500363. QC was identified as Xu Le Feng (QC1). Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was Li Peng Fei (QCA1), who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2312-TC-P4 and WPS-B-P-2313-TC-P4 as verbally identified by QCA1. In the area of the above noted welds, 3 arc strikes were observed. This QA Inspector reported the arc strikes to QCA1 and clearly marked the areas to be ground and magnetic particle testing to be performed.

SMAW welding of weld joints BK004A8-032-001, 002, 007 located on PCMK OBG BK004-032, end plate to bearing plate, deck plate, and edge plate. Welder was identified as 056200. 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-P-2312-TC-P4 and WPS-B-P-2313-TC-P4 as verbally identified by QCA1.

ZPMC workers were gluing 30mm x 700mm x 1283mm rubber pads to the top surface of OBG bikepath cantilever

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beams. As the pads were removed from a crate, they were wiped clean with a cloth. A pasty adherent was spread on the zinc coated surfaces of the cantilever beam with a putty knife before the pads were applied. After placing the pads, the pads were covered with cloth and scrap pieces of steel were laid on top to apply pressure. See photos below.

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 north, west, east and south towers, lift 5, skin D and at the top of north, west towers, lift 5, skin C, all using magnetically attached drill presses.

Bay 8

This QA Inspector randomly observed the following work in progress in Bay 8:

ZPMC workers were performing match drilling operations on a splice plate marked as SP5SH-1 for tower, skin A using magnetically attached drill presses, through a template.

OBG Trial Assembly Area

This QA Inspector randomly observed no apparent welding related work in progress in the OBG Trial Assembly Area. ZPMC workers were installing splice plates in CB15 for matched storage during shipping.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

As noted above.

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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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