

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-019360**Date Inspected:** 07-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 BK004A8-033-002, 007, 130 located on PCMK OBG BK004-033, end plate to bearing plate, deck plate, and edge plate. Welder was identified as 500363. QC was identified as Guo Yan Fei (QC1). Weld variables recorded by QC1 appeared to comply with WPS-B-P-2312-TC-P4 and WPS-B-P-2313-TC-P4 as verbally identified by QC1.

SMAW welding of weld joints BK004A8-033-001, 002, 007 located on PCMK OBG BK004-033, end plate to bearing plate, deck plate, and edge plate. Welder was identified as 056364. QC was identified as QC1. Weld variables recorded by QC1 appeared to comply with WPS-B-P-2312-TC-P4 and WPS-B-P-2313-TC-P4 as verbally identified by QC1.

Bay 11

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

ZPMC workers were performing installation of transverse diaphragms between the grillage connection plates north and east towers, lift 5, skins A. The transverse diaphragms were lowered into place using the overhead crane

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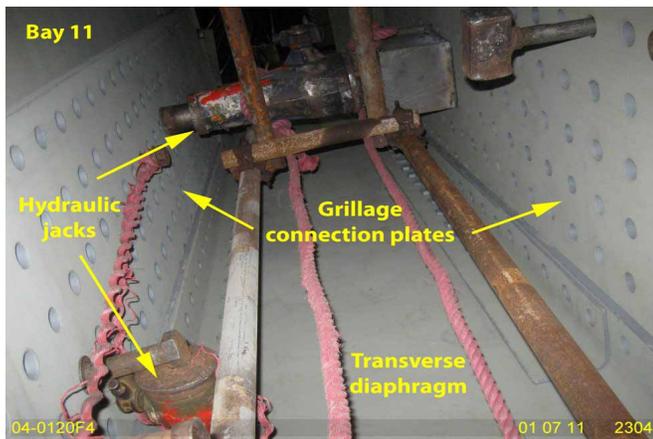
while the grillage connection plates were being influenced apart using hydraulic jacks. Hydraulic jacks were also being used to position the transverse diaphragms laterally between the grillage connection plates. See photo below.

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 CB16 for matched storage during shipping.

ZPMC workers were performing jacking operations under OBG segment 12BW. The matching edge of segment 12CW was positioned approximately 10mm or less from segment 12 BW.

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

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