

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-019362**Date Inspected:** 09-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:

FCAW welding of weld joints BK009A7-001-283~286 located on PCMK OBG BK009-001, longitudinal slanted T-ribs. Welder was identified as 040302. QC was identified as Fu Guo Gang (QC1). Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was Li Jun (QCA1), who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2232-ESAB and WPS-B-T-2233-ESAB as verbally identified by QCA1.

FCAW welding of weld joints BK009A7-001-057, 058, 098, 099 located on PCMK OBG BK009-001, longitudinal slanted T-ribs. 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-2232-ESAB and WPS-B-T-2233-ESAB as verbally identified by QCA1.

SMAW welding of weld joints BK004ASD1-032-001, 002, 003, 004 located on PCMK OBG BK004-032, corner box closure 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

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variables recorded by QCA1 appeared to comply with WPS-B-T-2211-TC-U4b as verbally identified by QCA1.

SMAW welding of weld joints BK004ASD1-032-022~024, 027 located on PCMK OBG BK004-032, corner box closure plate. Welder was identified as 500363. 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-2211-TC-U4b as verbally identified by QCA1. See photo below of ZPMC shop drawing showing the corner box closure plate welds for this welder and the other SMAW welder noted above.

Bay 11

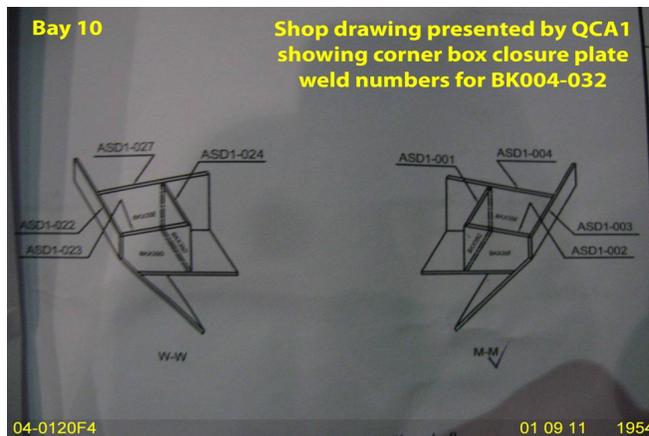
This QA Inspector randomly observed the following work in progress in Bay 11:

ZPMC workers were performing installation of bolt sets connecting the transverse diaphragms to the grillage connection plates of the north tower and east tower, lift 5, skins A and what appeared to be initial tightening to a snug tight condition using an air impact gun. ZPMC workers were creating threads by manually tapping the previously drilled holes in north tower, near the top of skin C and west tower, near the top of skin D. See photo of tapping operations below.

Heavy Dock

This QA Inspector randomly observed no apparent work in progress on the Heavy Dock. Sections CB15 and CB16 were positioned on stanchions on the Heavy Dock. All 4 tower, lift 4's and several bike path sections were on the ship moored at the end of 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 Micheal Ng, 159-2184-5703, 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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