

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-019366**Date Inspected:** 14-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 repair welding of weld joint GTSA5-B/G-12B located on PCMK tower, lift 5, top plate. Welders were identified as 040365, 057220. QC was identified as ZPMC CWI Xu Le Feng (QC1). Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Zhu Feng (QCA1), who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-345-SMAW-2G(2F)-repair as listed on ZPMC Welding Repair Report with the hand written number T-WR3785 and as verbally identified by QCA2. Attached to that report was a ZPMC Report of Ultrasonic testing, also hand written with no indentifying report number. Listed on the report were the above noted weld number and the weld number appearing in the following paragraph.

SMAW repair welding of weld joint GTSA5-B/G-13A located on PCMK tower, lift 5, top plate. Welder was identified as 040582. 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-345-SMAW-2G(2F)-repair as listed on ZPMC Welding Repair Report with the hand written number T-WR3783 and as verbally identified by QCA2.

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ZPMC workers were dismantling and removing the scaffolding surrounding tower, lift 5. A sandblasting crew was removing sandblasting equipment from Bay 11. Tower, lift 5 was later removed from Bay 11.

Heavy Dock

This QA Inspector randomly observed no apparent work in progress on the Heavy Dock. Several bundles of steel traffic barriers, several unidentified bundles of parts wrapped for shipping, and 1 bike path section were positioned on the Heavy Dock. OBG segments 11E and 11W; four tower, lift 4's; sections CB15 and CB16; several bundles of steel traffic barriers; and 18 bike path sections were on the deck of the ship moored at the end of the heavy dock.

See the photo below showing part of the deck of the ship.

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.

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