

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-019612**Date Inspected:** 21-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:** 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 14

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

FCAW welding of weld joint SEG-3007AU-106 located on PCMK OBG segment 13AE. Welder was identified as 037723. QC was identified as ABF CWI Yu Jiao (QC1). Weld variables recorded by QC1 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QC1.

FCAW welding of weld joint SEG-3007AU-102 located on PCMK OBG segment 13AE. Welder was identified as 066733. QC was identified as QC1. Weld variables recorded by QC1 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QC1. See photo below.

SMAW welding of weld joint SEG-3019J-011 located on PCMK OBG segment 14E. Welder was identified as 067656. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was Zhan Hai Feng (QCA1), who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2212-TC-U4b-FCM-1 as verbally identified by QCA1.

FCAW welding of weld joint EP3027-001-019 located on PCMK OBG segment 14E, edge plate. Welder was identified as 066763. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

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-2231-ESAB as verbally identified by QCA1.

SMAW repair welding of weld joint SEG-3019BB-037 located on PCMK OBG segment 14E. Welders were identified as 216086, 215553. 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)-FCM-repair-1 as verbally identified by QCA1 and displayed on ZPMC Welding Repair Report B-CWR2737 presented by QCA1.

SMAW welding of weld joint SEG-3019BB-030 located on PCMK OBG segment 14E. Welder was identified as 067571. 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-2212-TC-U4b-FCM-1 as verbally identified by QCA1.

SMAW repair welding of weld joint SEG-3019E-1-182 located on PCMK OBG segment 14E. Welder was identified as 066416. 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)-FCM-repair-1 as verbally identified by QCA1 and displayed on ZPMC Welding Repair Report B-CWR2677 presented by QCA1.

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 Eric Tsang, 150-0042-2372, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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