

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-020198**Date Inspected:** 29-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 joints DP3160-134, 135, 142, 143, 150, 151, 158, 159, 180, 181, 188, 189, 196, 197, 204, 205 located on PCMK OBG segment 14E, deck plate longitudinal diaphragm to deck plate I-rib. Welders were identified as 037723, 066733. QC was identified as ABF CWI Yu Jiao (QC1) and ABF CWI Ji Cai Feng (QC2). Weld variables recorded by QC2 appeared to comply with WPS-B-T-2133-ESAB as verbally identified by QC2.

FCAW welding of weld joints DP3160-133, 136, 141, 144, 149, 152, 157, 160, 179, 182, 187, 190, 195, 198, 203, 206 located on PCMK OBG segment 14E, deck plate longitudinal diaphragm to deck plate I-rib. Welders were identified as 066733. QC was identified as QC1 and QC2. Weld variables recorded by QC2 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QC2.

FCAW welding of weld joints DP3167-210, 211, 218, 219, 226, 227, 234, 235 located on PCMK OBG segment 14E, deck plate longitudinal diaphragm to deck plate I-rib. Welders were identified as 037723, 066733. QC was identified as QC1 and QC2. Weld variables recorded by QC2 appeared to comply with WPS-B-T-2133-ESAB as verbally identified by QC2.

WELDING INSPECTION REPORT

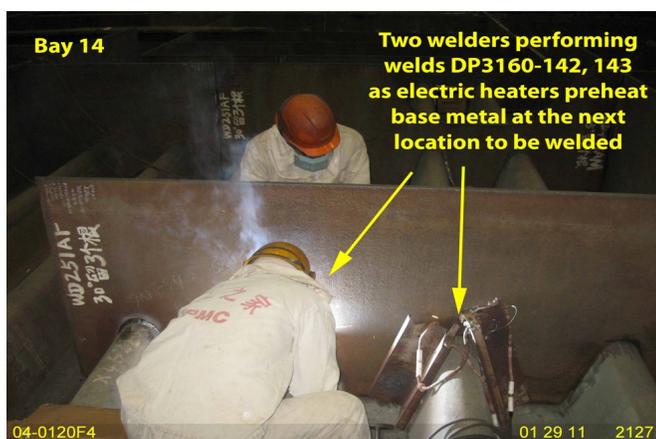
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FCAW welding of weld joints DP3167-209, 212, 217, 220, 225, 228, 233, 236 located on PCMK OBG segment 14E, deck plate longitudinal diaphragm to deck plate I-rib. Welders were identified as 066733. QC was identified as QC1 and QC2. Weld variables recorded by QC2 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QC2.

FCAW welding of weld joints DP3161-203, 204 located on PCMK OBG segment 14E, deck plate longitudinal diaphragm to deck plate I-rib. Welders were identified as 037723, 066733. QC was identified as QC1 and QC2. Weld variables recorded by QC2 appeared to comply with WPS-B-T-2133-ESAB as verbally identified by QC2.

FCAW welding of weld joints DP3161-202, 205 located on PCMK OBG segment 14E, deck plate longitudinal diaphragm to deck plate I-rib. Welders were identified as 066733. QC was identified as QC1 and QC2. Weld variables recorded by QC2 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QC2.

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.

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