

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-020201**Date Inspected:** 25-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:

SMAW welding of weld joints SA3020A2-412, 413 located on PCMK OBG segment 14W, diagonal beam to side plate between panel point 127.5 and panel point 128. Welder was identified as 037780. QC was identified as ABF CWI Ji Cai Feng (QC1). Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Li Ping (QCA1), who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2113-FCM-1 as verbally identified by QCA1. This QA Inspector observed 2 arc strikes on top of the diagonal beam near the above noted welds and clearly marked them with G+MT and informed QCA1 of the location. QCA1 assured this QA Inspector that the arc strikes would be ground and magnetic particle tested in conformance with contract documents.

FCAW welding of weld joints SA3020A2-414, 415 located on PCMK OBG segment 14W, diagonal beam to side plate between panel point 127 and panel point 127.5. Welder was identified as 068445. QC was identified as QC1.

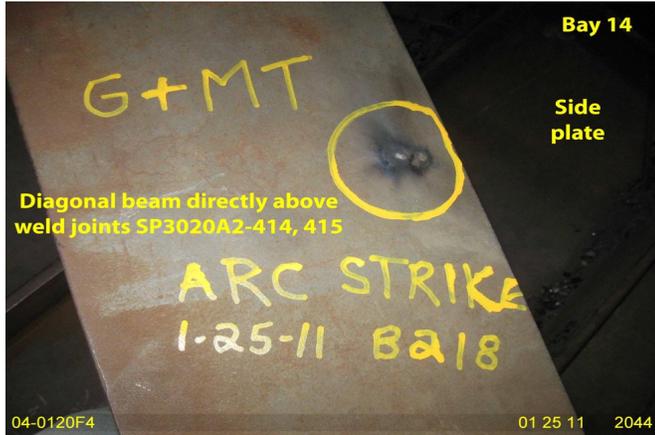
Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2133-ESAB as verbally identified by QCA1. This QA Inspector observed an arc strike on top of the diagonal beam near the above noted welds and clearly marked them with G+MT and informed QCA1 of the location. QCA1 assured this

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QA Inspector that the arc strike would be ground and magnetic particle tested in conformance with contract documents. See photo below of the arc strike and this QA Inspector's marking.

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
