

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-020880**Date Inspected:** 19-Feb-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 the Bay 14:

SMAW welding of weld joint DP3174-001-018 located on PCMK OBG 14W. Welder was identified as 037780. QC was identified as ZPMC CWI Sha Zhi (QC1). Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Shen Jian Bo (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. See photo below of welding operation in progress. Also present at this location and appearing to be monitoring the welding operation and recording data were ABF Representatives C.K. Chan and Li Shi You.

SMAW welding of weld joint DP3174-001-019 located on PCMK OBG 14W. Welder was identified as 066480. 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. Also present at this location and appearing to be monitoring the welding operation and recording data were ABF Representatives C.K. Chan and Li Shi You.

FCAW welding of weld joint SEG3020BB-110 located on PCMK OBG 14W. Welder was identified as 201215. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation

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and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QCA1.

SMAW repair welding of weld joint SEG3020BB-028 located outside PCMK OBG 14W. Welder was identified as 047864. 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 displayed on ZPMC Weld Repair Report B-CWR2752 presented to this QA Inspector and verbally identified by QCA1.

SMAW repair welding of weld joint SEG3020BB-019 located outside PCMK OBG 14W. Welder was identified as 066038. 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 displayed on ZPMC Weld Repair Report B-CWR2752 presented to this QA Inspector and verbally identified by QCA1.

FCAW welding of weld joint SEG3020BB-109 located on PCMK OBG 14W. Welder was identified as 067949. 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-2233-ESAB as verbally identified by QCA1. See photo below of welding in progress.

SMAW welding of weld joints SEG3020W-021, 023 located on PCMK OBG 14W. Welder was identified as 067609. 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-2114-FCM-1 as verbally identified by QCA1.

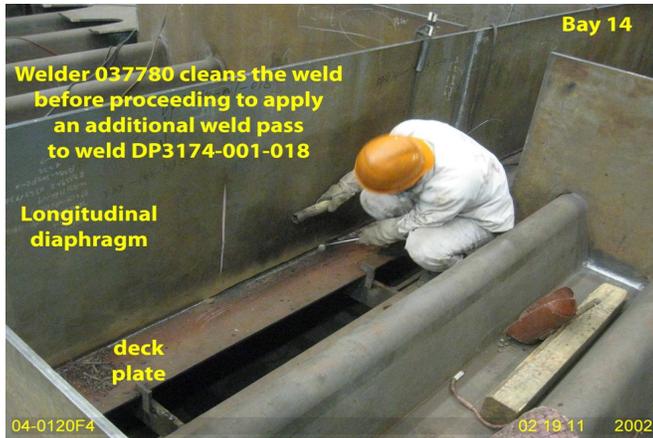
SMAW welding of weld joints SEG3020W-043, 045 located on PCMK OBG 14W. Welder was identified as 067763. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2114-FCM-1 as verbally identified by QCA1.

FCAW welding of weld joint SEG3013M-001 located on PCMK OBG 13AW. Welder was identified as 067876. 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 as verbally identified by QCA1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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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