

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-021712**Date Inspected:** 07-Mar-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:

SAW welding of weld joint SEG3019-011 located on PCMK OBG 14E. Welder was identified as 058100. QC was identified as ZPMC QC Cui Zheng Hua (QC1), who was not a CWI. Weld variables recorded by QC1 appeared to comply with WPS-B-T-2221-B-L2c-S as verbally identified by QC1. See photo below of ZPMC worker adjusting electric heating panels prior to welding.

FCAW welding of weld joints SA3013-001-003 located on PCMK OBG 13BE. Welder was identified as 051356. QC was identified as QC1, who was not a CWI. Weld variables recorded by QC1 appeared to comply with WPS-B-T-2232-ESAB as verbally identified by QC1. See photo below of weld joint SA3013-001-003 being welded.

FCAW welding of weld joint SEG3020AW-089 located on PCMK OBG 14W. Welder was identified as 067949. QC was identified as ABF CWI Ji Cai Feng (QC2). Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was QCA2, who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-T-2232-ESAB as verbally identified by QCA2.

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FCAW welding of weld joints SEG3020AJ-221, 255 located on PCMK OBG 14W. Welder was identified as 045175. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was QCA2, who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QCA2.

FCAW welding of weld joint SEG3013R-005 located on PCMK OBG 13AW. Welder was identified as 066038. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was QCA2, who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QCA2.

FCAW welding of weld joint SEG3013F-002 located on PCMK OBG 13AW. Welder was identified as 066421. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was QCA2, who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QCA2.

FCAW welding of weld joints SEG3013Q-022, SEG3013S-002 located on PCMK OBG 13AW. Welder was identified as 067876. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was QCA2, who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QCA3.

SMAW welding of weld joint SEG3013AH-021 located on PCMK OBG 13AW. Welder was identified as 066038. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was QCA2, who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1 as verbally identified by QCA2.

FCAW welding of weld joint DP3120-001-011 located on PCMK OBG 13AW. Welder was identified as 047864. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was QCA2, who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-P-2213-B-U2-FCM as verbally identified by QCA2.

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