

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-022349**Date Inspected:** 29-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 10

This QA Inspector randomly observed the following work in progress in the Bay 10:

SMAW repair welding of weld joint 28TR1-001-013 located on PCMK OBG traveler rail. Welders were identified as 040582, 057200. QC was identified as ZPMC CWI Li Jun(QC1). Assisting QC1 at this location and appearing to be monitoring the welding operation and also recording data was ABF CWI Liu Cheng (QCA1). Weld variables recorded by QC1 appeared to comply with WPS-345-SMAW-2G(2F)-repair as displayed on ZPMC Weld Repair Report B-WR20513 as presented to this QA Inspector and verbally identified by QC1. Attached to ZPMC Weld Repair Report B-WR20513 was ZPMC Report of Ultrasonic Examination #20409 as displayed on ZPMC Weld Repair Report B-WR20475. ZPMC Report of Ultrasonic Examination #20409 was two pages long and showed approximately 44 Ultrasonic Testing (UT) indications for weld joint 28TR1-001-013. See the two photos below listing the numerous indications.

SMAW welding of weld joint BK008A3-001-073 located on PCMK OBG bike path deck, hole cover. Welder was identified as 500363. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and also recording data was QCA1. Weld variables recorded by QC1 appeared to comply with WPS-B-P-2112 as verbally identified by QC1.

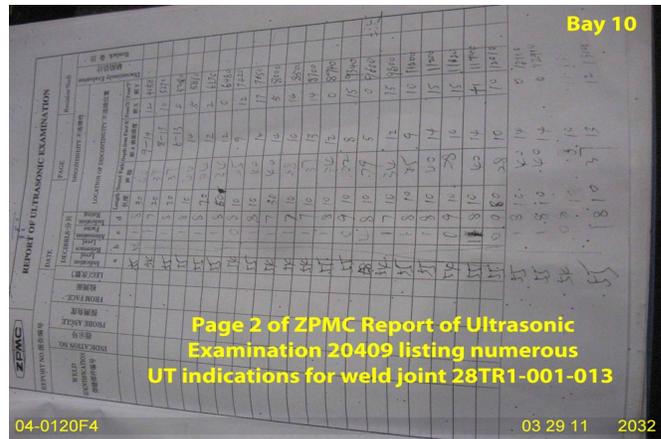
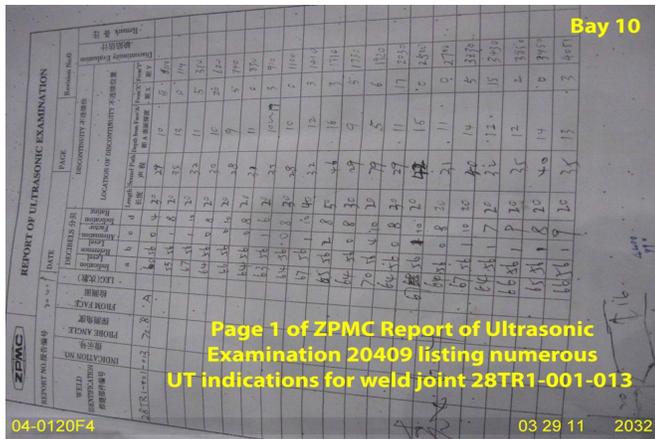
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SMAW welding of weld joint BK014A1-001-044 located on PCMK OBG bike path. Welders were identified as 056364, 044511. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1. Weld variables recorded by QC1 appeared to comply with WPS-B-P-2214-B-U2 as verbally identified by QC1.

SMAW tack welding of weld joint BK12A3-001-017 located on PCMK OBG bike path. Welder was identified as 044541. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and also recording data was QCA1. Weld variables recorded by QC1 appeared to comply with WPS-B-P-2213 and WPS-B-P-2114 as verbally identified by QC1.

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