

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-022350**Date Inspected:** 28-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 welding of the root pass of weld joint BK17B-001-020 located on PCMK OBG bike path cantilever beam. Welder was identified as 040581. QC was identified as ABF CWI Liu Cheng (QC1). Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Zhu Peng (QCA1), who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2212-TC-U4c as verbally identified by QCA1.

SMAW welding of the root pass of weld joint BK17-001-016 located on PCMK OBG bike path cantilever beam. Welder was identified as 500363. 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-U4c as verbally identified by QCA1. This QA Inspector was unable to verify the root opening size of weld joints BK17-001-016 and BK17B-001-020 because they were almost complete at the time of observance. See photos below of the welding operations in progress.

OBG Trial Assembly Area

This QA Inspector randomly observed the following work in progress in the OBG Trial Assembly Area:

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FCAW welding of weld joints SEG3007K-083, 109, 110; SEG3007M-121, 327, 328 located on PCMK OBG 13AE. Welder was identified as 055564. QC was identified as ABF CWI Bao Qian (QC2). Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Zhan Hai Feng (QCA2), who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-T-2232-ESAB and WPS-B-T-2233-ESAB as verbally identified by QCA2.

FCAW welding of weld joint SEG3007G-003 located on PCMK OBG 13AE. Welder was identified as 050242. 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.

SMAW repair welding of weld joints SEG3007E-057, 058, 062, 063 located on PCMK OBG 13AE. Welder was identified as 068924. 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-345-SMAW-2G(2F)-repair as verbally identified by QCA2. QC2 informed this QA Inspector that no ZPMC Weld Repair Report had been issued for this welding because it was the result of ZPMC magnetic particle testing (MT) only.

Also in OBG Trial Assembly Area, this QA Inspector and QA Inspector Kelley Leavitt obtained clearance measurements for the MEP splices and fit lugs at OBG segments 13E and 13W, panel points 119, 119-1500, and 119+1500. The clearance measurements were communicated to QA Inspector Ken Riley in response to a request by Structural Materials Representative James Devey. See QA Inspector Kelley Leavitt's report of this day for further information.

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



Summary of Conversations:

As noted above.

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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
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Reviewed By:	Riley, Ken	QA Reviewer
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