

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-022351**Date Inspected:** 27-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 and Tower 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 BK16B-001-001 located on PCMK OBG bike path cantilever beam. Welder was identified as 040365. 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-345-SMAW-2G(2F)-repair as displayed on ZPMC Weld Repair Report B-WR20515 as presented to this QA Inspector and verbally identified by QCA1.

SMAW repair welding of weld joint BK16-001-013 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-345-SMAW-3G(3F)-repair as displayed on ZPMC Weld Repair Report B-WR20514 as presented to this QA Inspector and verbally identified by QCA1.

SMAW tack welding of temporary stiffeners across the top plate of BK17 located on PCMK OBG bike path cantilever beam. Tack welder was identified as 216001. QC was identified as QC1. Assisting QC1 at this

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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-2112 as verbally identified by QCA1.

FCAW welding of weld joint BK014A-001-044 located on PCMK OBG bike path. Welder was identified as 053869. 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.

SMAW welding of weld joint BK014A-001-043 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, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2211-B-U2 as verbally identified by QCA1.

SMAW welding of weld joint BK17B-001-017 located on PCMK OBG bike path cantilever beam. Welder was identified as 040582. 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 as verbally identified by QCA1.

SMAW welding of weld joint BK17B-001-021 located on PCMK OBG bike path cantilever beam. Welder was identified as 057220. 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 as verbally identified by QCA1.

Heat straightening of 37TR2 located on PCMK OBG traveler rail. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the heat straightening operation and recording data was QCA1, who was not a CWI. Heat treatment variables recorded by QCA1 appeared to comply with ZPMC document HSR1(B)-10186 as presented to this QA Inspector and verbally identified by QCA1. See photo of document below as presented to this QA Inspector.

Bay 11

This QA Inspector randomly observed the following work in progress in the Bay 11:

SMAW welding of weld joints WSD1-TL6-4C/D-23A located on PCMK west tower, lift 6. Welder was identified as 046769. 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-2213-TC-U4b as verbally identified by QCA1. See photo below of welding in progress.

OBG Trial Assembly Area

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

FCAW welding of weld joints SEG3007M-115, 120 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-2233-ESAB as verbally identified by

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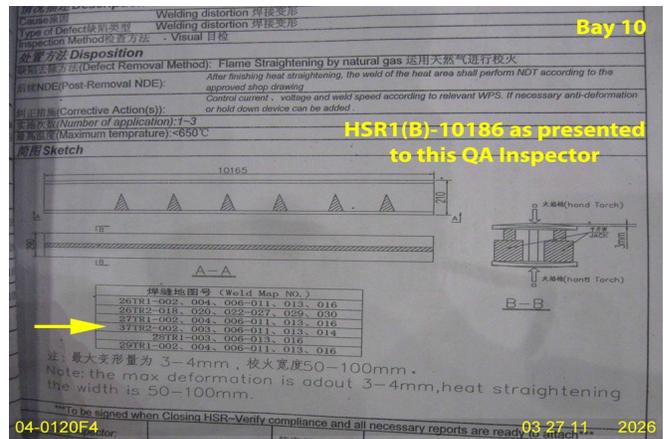
QCA2.

FCAW welding of weld joints SEG3007AD-126, 128, 130, 132 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-2132-ESAB as verbally identified by QCA2.

SMAW welding of weld joint SEG3007S-236 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-B-P-2211-TC-U4b-FCM-1 as verbally identified by QCA2.

SMAW repair welding of weld joint SEG3007X-509 located on PCMK OBG 13AE. Welder was identified as 200113. 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-1G(1F)-repair as displayed on ZPMC Weld Repair Report B-WR20183 as presented to this QA Inspector and verbally identified by QCA2.

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

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Reviewed By: Riley, Ken

QA Reviewer