

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-022741**Date Inspected:** 11-Apr-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 11

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

SMAW tack welding of rigging rings (padeyes) located on PCMK north tower, lift 6, skins A through F, within approximately 300mm of the top of lift 6. Welder was identified as 057186. QC was identified as ZPMC CWI Yu Dong Ping (QC1). Weld variables recorded by QC1 appeared to comply with WPS-B-P-2212 and WPS-B-P-2214 as verbally identified by QC1. QC1 informed this QA Inspector that no weld numbers could be provided because only fit-up and tack welding was being performed. See photos below of some of the rigging rings before and after tack welding to the north tower skin.

SMAW welding of weld joints WSD1-FGSA6-2-5, 6, 7, 8 located on PCMK tower, lift 6. Welder was identified as 202354. QC was identified as QC1. Weld variables recorded by QC1 appeared to comply with WPS-B-P-2113 as verbally identified by QC1.

OBG Trial Assembly Area

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

SMAW welding of weld joints SEG3007AA-085, 088, 092, 095, 099, 102 located on PCMK OBG Segment 13AE.

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

Welder was identified as 215553. QC was identified as ABF CWI Sheng Qing Quan (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-4113-TC-U4b-2 as verbally identified by QCA2.

SMAW welding of weld joints SEG3007AA-106, 109, 113, 116, 120, 123 located on PCMK OBG Segment 13AE.

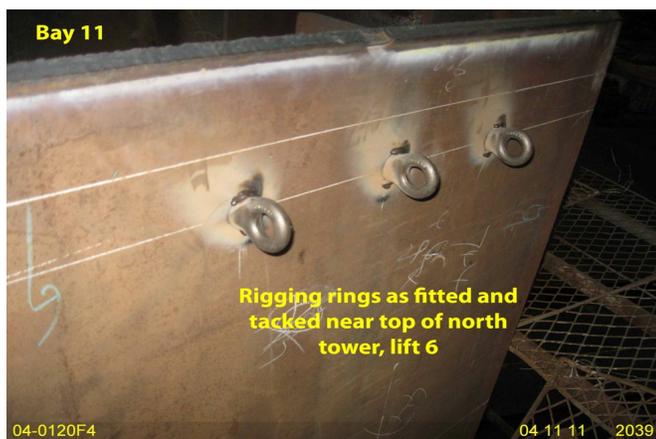
Welder was identified as 216086. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was QCA2, who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-P-4113-TC-U4b-2 as verbally identified by QCA2.

SMAW welding of weld joints SEG3007AH-123, 125, 143, 144 located on PCMK OBG Segment 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-B-P-2214-TC-U4b as verbally identified by QCA2.

SMAW welding of weld joint SEG3013AW-004 located on PCMK OBG Segment 13AW. Welder was identified as 069683. 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-TC-U4b-FCM-1 as verbally identified by QCA2.

SMAW welding of weld joint SEG3013Q-172 located on PCMK OBG Segment 13AW. Welder was identified as 066443. 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-TC-U4b-FCM-1 as 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.

---

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---

## 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.

---

<b>Inspected By:</b>	Goulet,George	Quality Assurance Inspector
----------------------	---------------	-----------------------------

---

<b>Reviewed By:</b>	Riley,Ken	QA Reviewer
---------------------	-----------	-------------