

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-022744**Date Inspected:** 16-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 welding of weld joint BK010-001-044 located on PCMK OBG bike path. Welder was identified as 054547. QC was identified as ZPMC QC Li Jun (QC1). Weld variables recorded by QC1 appeared to comply with WPS-B-P-2214-B-U2 as verbally identified by QC1.

FCAW welding of weld joint BK009A-001-021 located on PCMK OBG bike path. Welder was identified as 040302. QC was identified as QC1. Weld variables recorded by QC1 appeared to comply with WPS-B-T-2132-ESAB as verbally identified by QC1.

SMAW welding of weld joints SSD1-FFSA6-1-13, 14 located on PCMK Tower, lift 6. Welder was identified as 056364. QC was identified as QC1. Weld variables recorded by QC1 appeared to comply with WPS-B-P-2112 as verbally identified by QC1.

FCAW repair welding of weld joints BK16B-001-016, 017 located on PCMK OBG bike path. Welder was identified as 040533. QC was identified as QC1. Weld variables recorded by QC1 appeared to comply with WPS-345-FCAW-1G(1F)-ESAB-repair as displayed on ZPMC Weld Repair Report B-WR20396 as presented to

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this QA Inspector and verbally identified by QC1. See photo below displaying multiple repairs on ZPMC Report of Ultrasonic Examination B787-UT-17976 which was attached to ZPMC Weld Repair Report B-WR20396.

FCAW welding of weld joint BK3001-001-001 located on PCMK OBG bike path. Welder was identified as 040365. QC was identified as QC1. Weld variables recorded by QC1 appeared to comply with WPS-B-T-2231-ESAB as verbally identified by QC1.

FCAW welding of weld joint BK17B-001-016 located on PCMK OBG bike path. Welder was identified as 057266. QC was identified as QC1. Weld variables recorded by QC1 appeared to comply with WPS-B-T-2231-ESAB as verbally identified by QC1.

SMAW welding of weld joint BK017D-001-004 located on PCMK OBG bike path. Welder was identified as 040582. QC was identified as QC1. Weld variables recorded by QC1 appeared to comply with WPS-B-P-2214-TC-U4c as verbally identified by QC1. 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:

SMAW welding of weld joint FB3093-001-012 located on PCMK OBG, segment 12CW. Welder was identified as 057333. QC was identified as ZPMC CWI Li Yang (QC2). Weld variables recorded by QC2 appeared to comply with WPS-B-P-2112-1 as verbally identified by QC2.

SMAW repair welding of weld joint SEG3005M-090 located on PCMK OBG, segment 12CW. Welder was identified as 046709. QC was identified as QC2. Weld variables recorded by QC2 appeared to comply with WPS-345-SMAW-2G(2F)-FCM-repair-1 as displayed on ZPMC Weld Repair Report B-WR20389 as presented to this QA Inspector and verbally identified by QC2.

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



WELD IDENTIFICATION		INDICATION NO.	PROBE ANGLE	FROM FACE	LEG (次数)	DECIBELS 分贝				DISCONTINUITY 不连续性				Discontinuity Evaluation	Remark
焊缝编号	指示号	探伤角度	检测面	检测面	Reference	Amplitude	Attenuation	Indication	Rating	LOCATION OF DISCONTINUITY 不连续位置					
					a	b	c	d	Length	Sound Path	Depth from Face 'A'	From 'X'	From 'Y'	缺陷估计	备注
									长度	声程	距 A 表面深度	距 X	距 Y		
BK17B-001-016	017	63	55	5	3	86	26-30	0-0.3							
BK17B-001-016	017	61	55	5	3	106	86	26-30	0	0					
BK17B-001-016	017	61	55	5	3	148	86	26-30	0	0					
BK17B-001-016	022	61	55	5	3	148	86	26-30	0	0					

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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
