

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-022753**Date Inspected:** 02-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 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:

SAW welding of weld joint BK17B-001-021 located on PCMK OBG bike path cantilever beam. Welder was identified as 040460. QC was identified as ZPMC CWI Li Jun (QC1). Weld variables recorded by QC1 appeared to comply with WPS-B-T-2221-TC-U4a-S as verbally identified by QC1.

SMAW repair welding of weld joint BK17B-001-021 located on PCMK OBG bike path cantilever beam prior to the above noted SAW welding. Welder was identified as 042336. QC was identified as QC1. Weld variables recorded by QC1 appeared to comply with WPS-B-T-2211-TC-U4c as verbally identified by QC1. QC1 informed this QA Inspector that no ZPMC Weld Repair Report existed because the repair welding was in response to ZPMC visual testing (VT).

SMAW welding of weld joints BK17C-001-065~068 located on PCMK OBG bike path cantilever beam. Welder was identified as 040581. QC was identified as QC1. Weld variables recorded by QC1 appeared to comply with WPS-B-T-2212-TC-U4c, WPS-B-T-2213-TC-U4c, WPS-B-T-2214-TC-U4c as verbally identified by QC1. See photo below showing ZPMC welder 040581 cleaning weld joint BK17C-001-065 between weld passes.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

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 SEG3007B-096; SEG3007D-119 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-repair as presented to this QA Inspector and verbally identified by QCA2.

FCAW welding of weld joints SP3058-001-029, 039 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-2231-ESAB-repair as presented to this QA Inspector and verbally identified by QCA2.

SMAW welding of weld joints SEG3007AH-065, 067 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.

FCAW welding of weld joints SEG3007R-204~221; SEG3007S-213~230 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.

FCAW welding of weld joints SEG3013AP-023~026 located on PCMK OBG 13AW. Welder was identified as 048443. QC was identified as ABF CWI Kasi Wang (QC3). Weld variables recorded by QC3 appeared to comply with WPS-B-T-2132-ESAB as presented to this QA Inspector and verbally identified by QCA3.

FCAW welding of weld joint SEG3013D-042 located on PCMK OBG 13AW. Welder was identified as 048696. QC was identified as QC3. Weld variables recorded by QC3 appeared to comply with WPS-B-T-2233-ESAB as presented to this QA Inspector and verbally identified by QCA3.

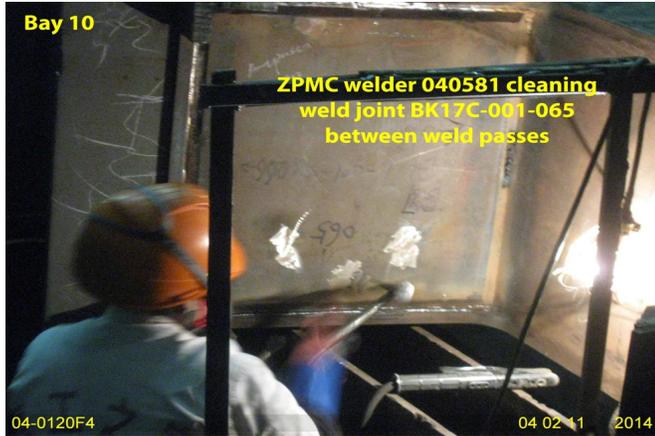
SMAW welding of weld joint SEG3013AD-065 located on PCMK OBG 13AW. Welder was identified as 047864. QC was identified as QC3. Weld variables recorded by QC3 appeared to comply with WPS-B-P-2211-TC-U4b-FCM-1 as presented to this QA Inspector and verbally identified by QCA3.

SMAW welding of weld joints SEG3013Q-086, 091, 096, 101 located on PCMK OBG 13AW. Welder was identified as 037779. QC was identified as QC3. Weld variables recorded by QC3 appeared to comply with WPS-B-P-2211-TC-U4b-FCM-1 as presented to this QA Inspector and verbally identified by QCA3.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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
---------------------	------------	-------------