

**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-022894**Date Inspected:** 15-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 10**

This QA Inspector randomly observed the following work in progress in the Bay 10:

SMAW welding of weld joints X3305K-006-001, 002 located on PCMK OBG channels. Welder was identified as 040581. QC was identified as ZPMC CWI Shi Yu (QC1). Weld variables recorded by QC1 appeared to comply with WPS-B-T-2211-TC-U4b as verbally identified by QC1. See photo below showing this part during the welding operation.

FCAW welding of weld joints X3305K-008-001, 002 located on PCMK OBG channels. Welder was identified as 040533. QC was identified as QC1. Weld variables recorded by QC1 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QC1.

Heat straightening of 31TR1-001-002, 004, 007~011, 013, 016 and 31TR2-001-018, 020, 022~027, 029, 030 located on PCMK OBG traveler rail. QC was identified as QC1. Heat treatment variables recorded by QC1 appeared to comply with ZPMC document HSR1(B)-10292 as presented to this QA Inspector and verbally identified by QC1.

**Bay 11**

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

SMAW welding of weld joint ESD1-TL6-2B/D-6 located on PCMK tower, lift 6. Welder was identified as 040614. QC was identified as QC1. Weld variables recorded by QC1 appeared to comply with WPS-B-P-2112 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:

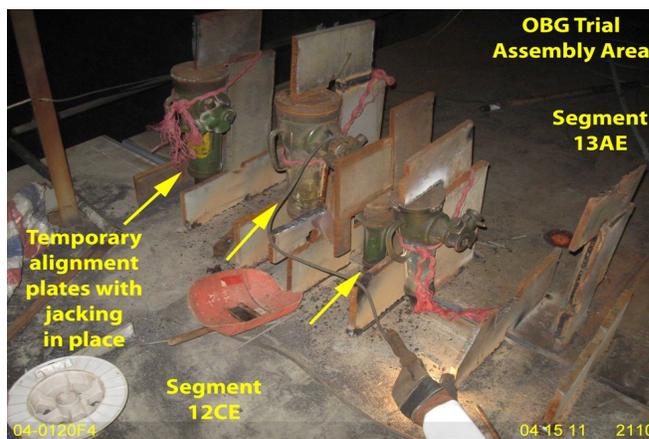
FCAW welding of weld joint BK017A-001-001 located on PCMK OBG bike path. Welder was identified as 204868. QC was identified as ZPMC CWI Li Yang (QC2). Weld variables recorded by QC2 appeared to comply with WPS-B-T-2232-ESAB as verbally identified by QC2.

SMAW welding of weld joints SEG3006B-168 located on PCMK OBG Segment 12CW. Welder was identified as 066674. QC was identified as QC2. Weld variables recorded by QC2 appeared to comply with WPS-B-P-2213-TC-U4b-1 as verbally identified by QCA2.

FCAW welding of weld joints BP3025-032~043 located on PCMK OBG Segment 12CW. Welder was identified as 048696. QC was identified as QC2. Weld variables recorded by QC2 appeared to comply with WPS-B-T-2132-ESAB as verbally identified by QC2.

SMAW welding of temporary alignment plates at the 12CE/13AE transverse joint, deck plates located on PCMK OBG Segments 12CE/13AE. Welder was identified as 205616. QC was identified as QC2. Weld variables recorded by QC2 appeared to comply with WPS-B-P-2112-1 as verbally identified by QC2. See photo below of some of the alignment plates and hydraulic jacks at the deck plate transverse joint.

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



## Summary of Conversations:

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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 James Devey 15000026784, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Goulet,George	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley,Ken	QA Reviewer

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