

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-022984**Date Inspected:** 22-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:

SMAW welding of weld joints BK014A-001-001, 002, 003, 004 located on PCMK OBG bike path. Welder was identified as 040581. QC was identified as ZPMC CWI Shi Yu (QC1). Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Yu Zhi Lai (QCA1), who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2211-TC-U4b as verbally identified by QCA1.

FCAW welding of weld joint X3305K-032-001 located on PCMK OBG splice plate assembly. Welder was identified as 206701. 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-2233-ESAB as verbally identified by QCA1.

FCAW welding of weld joint X3305K-031-002 located on PCMK OBG splice plate assembly. Welder was identified as 054117. 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-2233-ESAB as verbally identified by QCA1.

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FCAW welding of weld joint X3305K-029-001 located on PCMK OBG splice plate assembly. Welder was identified as 054069. 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-2233-ESAB as verbally identified by QCA1.

SMAW welding of weld joint X3305K-013-001 located on PCMK OBG splice plate assembly. 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-2213-TC-U4b as verbally identified by QCA1.

SMAW welding of weld joint X3305K-015-002 located on PCMK OBG splice plate assembly. Welder was identified as 053829. 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.

SMAW welding of weld joint X3305K-022-001 located on PCMK OBG splice plate assembly. Welder was identified as 053829. 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.

Heat straightening of BK014-002-013~21 located on PCMK OBG bike path. QC was identified as ZPMC QC2. 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)-10313 as presented to this QA Inspector and verbally identified by QCA1. See photo below of the heat straightening operation 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 joint SEG3013K-118 located inside PCMK OBG 13AW. Welder was identified as 048696. QC was identified as ZPMC CWI Li Yang (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-2233-ESAB as verbally identified by QCA2.

FCAW welding of weld joints SEG3013E-056, 059, 061, 064 located inside PCMK OBG 13AW. Welder was identified as 048433. 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-2233-ESAB as verbally identified by QCA2.

SMAW welding of weld joint SEG3013AA-117 located inside PCMK OBG 13AW. Welder was identified as 066398. 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.

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SMAW welding of weld joint SEG3013D-142 located inside PCMK OBG 13AW. Welder was identified as 047864. 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-FCM-1 as verbally identified by QCA2.

SMAW welding of weld joint SEG3014B-229 located inside PCMK OBG 13BW. Welder was identified as 045196. 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-2212-TC-U4a-FCM-1 as verbally identified by QCA2.

SMAW welding of weld joint SEG3015K-268 located inside PCMK OBG 13CW. Welder was identified as 067588. 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-2212-TC-U4a-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.

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.

Inspected By: Goulet, George

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer