

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-023133**Date Inspected:** 24-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:

FCAW welding of weld joint BK009A6-001-070 located on PCMK OBG bike path. Welder was identified as 054069. QC was identified as ZPMC CWI ShuYu (QC1). Weld variables recorded by QC1 appeared to comply with WPS-B-T-2132-ESAB as verbally identified by QC1.

Heat straightening of BK014A-001-013~21 located on PCMK OBG bike path. QC was identified as ZPMC QC1. Heat treatment variables recorded by QC1 appeared to comply with ZPMC document HSR1(B)-10313 as presented to this QA Inspector and verbally identified by QC1. QC1 informed this QA Inspector that not all of the above noted welds had heat treatment performed on this date and none of the welds had more than the approved 3 total applications of heat treatment performed.

FCAW welding of weld joint ESD1-FFSA6-1-029~032 located on PCMK east tower, lift 6. Welder was identified as 502818. QC was identified as QC1. Weld variables recorded by QC1 appeared to comply with WPS-B-T-2132-ESAB as verbally identified by QC1.

OBG Trial Assembly Area

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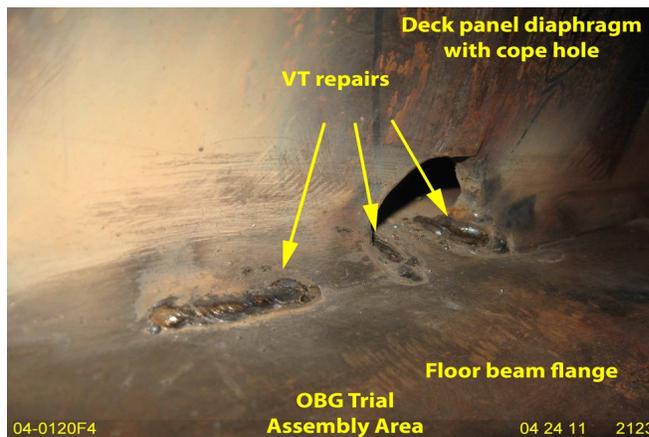
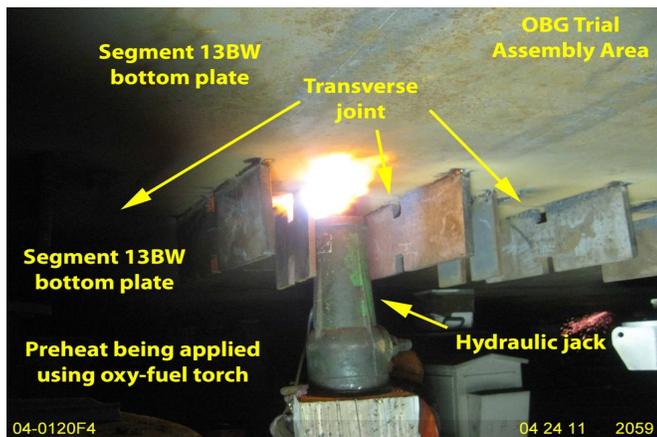
This QA Inspector randomly observed the following work in progress in the OBG Trial Assembly Area:

SMAW welding of temporary alignment plates across the 13AW/13BW transverse joint, bottom plates located on PCMK OBG Segments 13AW/13BW. Welders were identified as 067829, 205098. QC was identified as ABF CWI Ji Cai Fang (QC2). Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Wang Zhu (QCA2), who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-P-2114-FCM-1 as verbally identified by QCA2.

SMAW welding of temporary alignment plates across the 13AW/13BW transverse joint, side plates, north (counterweight) side, located on PCMK OBG Segments 13AW/13BW. Welder was identified as 069896. 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-2114-FCM-1 as verbally identified by QCA2.

SMAW repair welding of various weld joints located inside PCMK OBG Segment 13CW, deck panel diaphragm to floor beam flange at panel points 123, 123.5, 124, and 124.5. Welder was identified as 045196. QC was identified as ABF CWI Wu Ke Wen (QC3). Weld variables recorded by QC3 appeared to comply with WPS-B-P-2212-TC-U4b as verbally identified by QC3. QC3 informed this QA Inspector that this repair was the response to indications observed during ZPMC or ABF visual testing. See photo below of typical weld repairs at a deck panel diaphragm cope hole at panel point 124.5.

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.

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Inspected By:	Goulet, George	Quality Assurance Inspector
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Reviewed By:	Riley, Ken	QA Reviewer
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