

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-023222**Date Inspected:** 26-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 11

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

SMAW repair welding of weld joint ESD1-TBSA7-3-19 located on PCMK east tower, lift 7. Welder was identified as 202354. QC was identified as ZPMC CWI Li Jun (QC1). Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Wang Chuan Xin (QCA1), who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-345-SMAW-1G(1F)-repair as displayed on ZPMC Weld Repair Report T-WR3783 as presented to this QA Inspector and verbally identified by QCA1.

OBG Trial Assembly Area

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

SMAW repair welding of weld joint SP3103-001-184 located on PCMK OBG 13AW. Welder was identified as 037779. QC was identified as ZPMC CWI Liu Hua Jie (QC2). Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Shen Jian Bo (QCA2), who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-345-SMAW-3G(3F)-repair as displayed on ZPMC Weld Repair Report B-WR20812 as presented to this QA Inspector and verbally identified by QCA2.

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SMAW repair welding of weld joint SEG3013H-055 located on PCMK OBG 13AW. Welder was identified as 066019. 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-345-SMAW-3G(3F)-repair as displayed on ZPMC Weld Repair Report B-WR20577 as presented to this QA Inspector and verbally identified by QCA2.

SMAW repair welding of weld joint SEG3013AA-114 located on PCMK OBG 13AW. Welder was identified as 047866. 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-345-SMAW-2G(2F)-repair as displayed on ZPMC Weld Repair Report B-WR20579 as presented to this QA Inspector and verbally identified by QCA2.

SMAW repair welding of base metal where temporary welds had been removed located on PCMK OBG 13BW bottom plate. 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-345-SMAW-4G(4F)-FCM-repair-1 as displayed on ZPMC Weld Repair Report B-CWR2879 as presented to this QA Inspector and verbally identified by QCA2.

SMAW repair welding of weld joint SEG3013Q-200 located on 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-345-SMAW-3G(3F)-repair as displayed on ZPMC Weld Repair Report B-WR20693 as presented to this QA Inspector and verbally identified by QCA2.

SMAW repair welding of weld joint SEG3013Q-178 located on PCMK OBG 13AW. Welder was identified as 066326. 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-345-SMAW-3G(3F)-repair as displayed on ZPMC Weld Repair Report B-WR20693 as presented to this QA Inspector and verbally identified by QCA2.

SMAW welding of weld joint SEG3015A-009 located on PCMK OBG 13CW. Welder was identified as 045213. 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-B-U2-FCM-1 as verbally identified by QCA2.

Fit-up and FCAW welding of temporary alignment plates at the 13AE/13BE transverse joint, deck plates located outside PCMK OBG Segments 13AE/13BE. Welder was identified as 066687. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Wang Zhu (QCA3), who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-B-T-2132-ESAB as verbally identified by QCA3. See photo below of base metal preheating at this location.

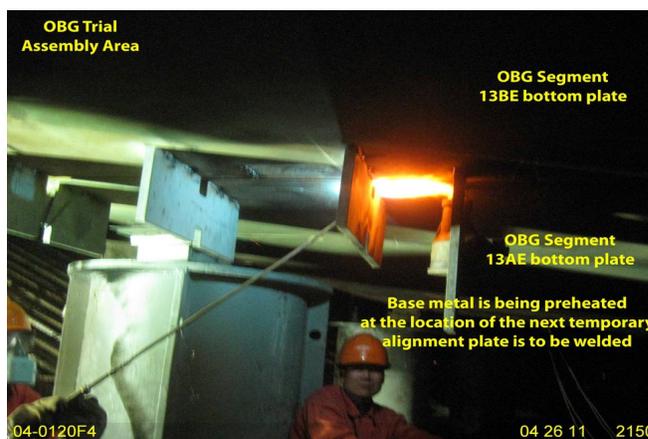
Fit-up and SMAW welding of temporary alignment plates across the 13AW/13BW transverse joint, bottom plates located on PCMK OBG Segments 13AW/13BW. Welder was identified as 055482. QC was identified as QC2.

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Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was QCA3, who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-B-P-2114-FCM-1 as verbally identified by QCA3. See photo below of base metal preheating at this location.

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