

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-023929**Date Inspected:** 15-May-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.

OBG Trial Assembly Area

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

SMAW welding of weld joints SEG3019AE-005, 012, 019, 026, 033, 040, 072 located on PCMK OBG 14E.

Welder was identified as 215553. QC was identified as ZPMC CWI Sha Zhi (QC1). Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Xie Ming Feng (QCA1), who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-4213-TC-U4b-1 as verbally identified by QCA1.

SMAW welding of weld joints SEG3019AE-006, 013, 020, 027, 034, 041, 073 located on PCMK OBG 14E.

Welder was identified as 044779. 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-FCM as verbally identified by QCA1.

FCAW repair welding of weld joints SEG3009B-093, 097, 103, 105, 109, 113, 117, 121, 125, 129, 133, 137;

SEG3011K-096, 101, 106, 111, 116, 121, 126, 131, 141, 146, 151 located on PCMK OBG 13BE/13CE. Welder was identified as 050977. 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

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QCA1 appeared to comply with WPS-345-FCAW-3G(3F)-repair as displayed on ZPMC Weld Repair Report B-WR20996 as presented to this QA Inspector and verbally identified by QCA1.

FCAW welding of temporary alignment plates located across the PCMK OBG 13CE/14E transverse joint, deck plates. Welder was identified as 055564. 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-2132-ESAB as verbally identified by QCA1. See photo below of welding operation in progress.

Heat straightening of OBE13-002 located on PCMK OBG Segment 13AE/13BE, transverse joint. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the heat treating operation and recording data was QCA, who was not a CWI. Heat treatment variables recorded by QCA1 appeared to comply with ZPMC document HSR1(B)-10349 as presented to this QA Inspector and verbally identified by QCA1. See photo below of heat straightening operation in progress.

SMAW welding of temporary alignment plates located across the PCMK OBG 13AW/13BW transverse joint, deck plates, at weld joint OBW13-001 in preparation to perform B-WR20682. Welder was identified as 067275. 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-2112-FCM-1 as verbally identified by QCA1.

SMAW repair welding of weld joints VP3005-001-023, 024 located on PCMK OBG 13BE. Welder was identified as 044772. 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-345-SMAW-3G(3F)-repair-1 as displayed on ZPMC Weld Repair Report B-WR20983 as presented to this QA Inspector and verbally identified by QCA1.

FCAW welding of weld joints SEG3013U-104, 106 located on PCMK OBG 13AW. Welder was identified as 070101. QC was identified as QC. Assisting QC1 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-B-T-2233-ESAB as verbally identified by QCA2.

FCAW welding of weld joints SEG3013Y-389, 390, 393, 394 located on PCMK OBG 13AW. Welder was identified as 037705. QC was identified as QC. Assisting QC1 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 SEG3013P-230, 231 located on PCMK OBG 13AW. Welder was identified as 067876. QC was identified as QC. Assisting QC1 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 SEG3007B-110, 401 located on PCMK OBG 13AW. Welder was identified as 055491. QC was identified as QC. Assisting QC1 at this location and appearing to be monitoring the welding

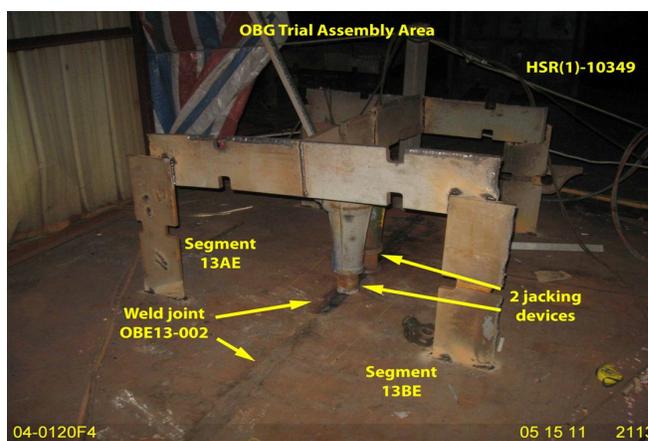
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operation and recording data was ZPMC QC Wang Xiang Pin (QCA3), who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-B-T-2232-ESAB and WPS-B-T-2233-ESAB, respectively, as verbally identified by QCA3.

FCAW welding of weld joints SEG3007J-125, 130, 135, 140, 145 located on PCMK OBG 13BW. Welder was identified as 052696. QC was identified as QC. Assisting QC1 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-T-2233-ESAB as verbally identified by QCA3.

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