

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-024232**Date Inspected:** 25-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 DP3156-001-001~010 located on PCMK OBG 13CE at the 13AE/14E transverse joint, holdback welds. Welder was identified as 068097. QC was identified as ABF CWI Cao Hai Zhou (QC1). Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Wang Xiang Pin (QCA1), who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2114-FCM-1 as verbally identified by QCA1.

SMAW welding of weld joints DP3166-001-002~005 located at PCMK OBG 14E at the 13CE/14E transverse joint, holdback welds. Welder was identified as 037723. 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-2114-FCM-1 as verbally identified by QCA1.

Fit-up and SMAW tack welding of barrier diverter to deck plate located on PCMK OBG 13BE, crossbeam side, at approximately panel point 121. Welder was identified as 044749. 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

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CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2112 as verbally identified by QCA1.

FCAW welding of weld joints OBE13AA-003, 004 located on PCMK OBG 13AE. 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. Also present at this location and appearing to be monitoring the welding operation and recording data was ABF Representative Liang Bao.

SMAW welding of weld joints SEG3019V-090, 091, 095, 096 located on PCMK OBG 14E, FL3 area, holdback welds; and corresponding weld joints FB3260-001-048, 049, 053, 054 on PCMK CB19, holdback welds. Welder was identified as 049769. 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 and WPS-B-P-2114-FCM-1 as verbally identified by QCA1.

FCAW welding of weld joints SA3037-(001~006)-002, 004 located at PCMK OBG 13CE. Welder was identified as 052696. 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-2131-ESAB as verbally identified by QCA1.

SMAW repair welding of weld joint DP3161-001-346 located on PCMK OBG 14E. Welder was identified as 501946. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Zhan Hai Feng (QCA2), who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-345-SMAW-3G(3F)-FCM-repair-1 as displayed on ZPMC Weld Repair Report B-WR20985 as presented to this QA Inspector and verbally identified by QCA2.

SMAW repair welding of weld joint SEG3019AY-114, 115, 117 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 QCA2, who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-345-SMAW-3G(3F)-FCM-repair-1 as displayed on ZPMC Weld Repair Report B-WR21029 as presented to this QA Inspector and verbally identified by QCA2.

SMAW repair welding of weld joints SEG3019J-185, 190, 200, 205 located on PCMK OBG 14E. Welder was identified as 037997. QC was identified as QC1. 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-345-SMAW-3G(3F)-FCM-repair-1 as displayed on ZPMC Weld Repair Report B-WR21029 as presented to this QA Inspector and verbally identified by QCA2.

SMAW welding of weld joints VP3007-001-011, 023, 036, 049 located on PCMK OBG 13CE at the 13AE/14E transverse joint, holdback welds; and VP3016-001-001~004 located at PCMK OBG 14E at the 13CE/14E transverse joint, holdback welds. Welder was identified as 058102. QC was identified as ABF CWI Wang 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

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WPS-B-P-2214-TC-U4b-FCM-1 as verbally identified by QCA2.

Bay 11

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

Fit-up and SMAW tack welding of temporary alignment plates and weld joints at longitudinal I-ribs to end plates located on PCMK BK012A. Welder was identified as 202319. QC was identified as ZPMC CWI Yu Dong Ping (QC3). Weld variables recorded by QC3 appeared to comply with WPS-B-P-2212 and WPS-B-P-2113 as verbally identified by QC3. QC1 informed this QA Inspector that the weld joint designated numbers were not available because only fit-up and tack welding was being performed.

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