

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-024776**Date Inspected:** 05-Jun-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 FB3329-001-010; CB3003A-019-003 located on PCMK OBG 14W and CB19, respectively. Welder was identified as 057795. QC was identified as ABF CWI Wang Jun (QC1). Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was Zhang Lin (QCA1), who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2212-U4b-FCM-1 as verbally identified by QCA1.

SMAW welding of weld joints OBW14A-010~015 located on PCMK OBG 14W. Welders were identified as 067275, 070009, 068917, 066881. 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-FCM-1 and WPS-B-P-2214-FCM-1 as verbally identified by QCA1. See photo below of the 4 above noted welders performing SMAW of the above noted weld joints.

FCAW welding of weld joints SEG3020V-027, 029, 031 located on PCMK OBG 14W. Welder was identified as 067876. 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

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comply with WPS-B-T-2232-ESAB as verbally identified by QCA1.

SMAW repair welding of weld joint OBE13B-003 located on PCMK OBG 13AE/13BE. Welder was identified as 043661. 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-4G(4F)-FCM-repair-1 as displayed on ZPMC Weld Repair Report B-CWR2992 as presented to this QA Inspector and verbally identified by QCA1.

FCAW welding of weld joints SA3032B-001-005, 006; SA3032B-002-005, 006 located on PCMK OBG 13BE. Welder was identified as 066442. 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-2231-ESAB as verbally identified by QCA1.

FCAW welding of weld joints SA3032D-001-007, 008; SA3032B-002-007, 008 located on PCMK OBG 13BE. Welder was identified as 066746. 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-2231-ESAB as verbally identified by QCA1.

Eight transport/lift vehicles were observed being positioned under OBG Segment 13W. No movement of the segment was observed.

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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