

**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-025112**Date Inspected:** 11-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:

FCAW welding of weld joint SEG3007W-113 located on PCMK OBG 13AE. Welder was identified as 050240. 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 ZPMC QC Wang Xiang Pin (QCA1), who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QCA1.

SMAW tack welding of stiffeners to bottom plate I-rib splice plates located at PCMK OBG 13AE/13BE transverse joint, on the bike path side of the south longitudinal diaphragm. Welder was identified as 050240. 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-2211-FCM-1 as verbally identified by QCA1. QCA1 informed this QA Inspector that weld numbers were not provided because only tack welding was being performed.

QCA1 informed this QA Inspector that no other welding work was being performed on this night shift. Various drilling and grinding operations were being performed, but no other welding was observed.

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# WELDING INSPECTION REPORT

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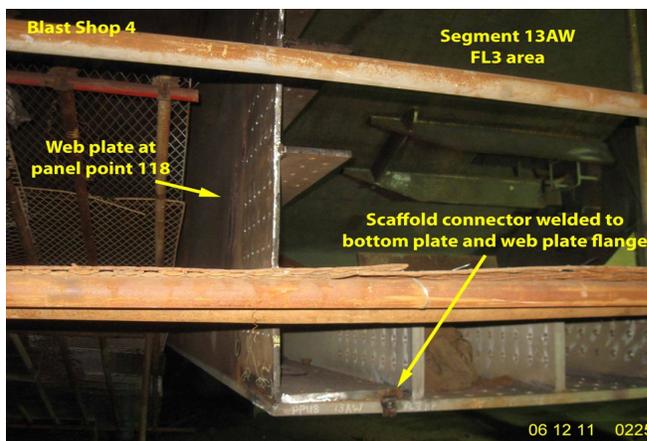
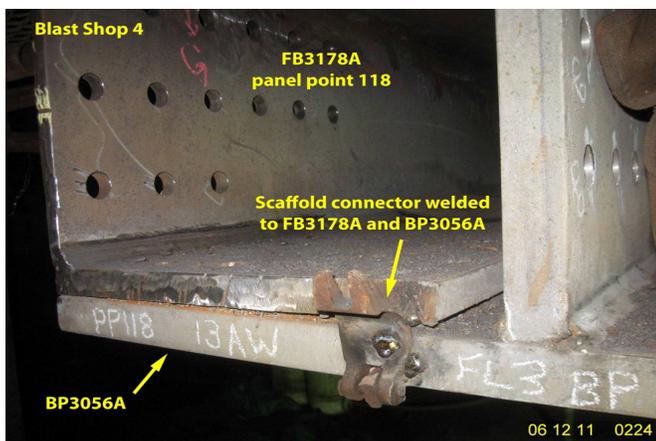
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## Blast Bay 4

During random observations of the fabrication of OBG Segment 13AW, this QA Inspector discovered the following issue. ZPMC had temporarily welded a scaffold connector to the outer edge of the bottom plate and the floor beam bottom flange of the FL3 area without Engineer's approval. The tack welding was performed without an approved WPS. The approved shop drawings do not specify any temporary attachment in these areas. The components are identified as BP3056A and FB3178A. The components are not SPCM. The location of Segment 13AW is in Blast Shop 4. The material composition of the scaffold connector is not known. This QA Inspector generated an Incident Report concerning the above noted issues. See that report and photos below for more information.

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