

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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006346**Date Inspected:** 13-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Shi Lei**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 Segments**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector Dan Hernandez was present during the times noted above for observations relative to the work being performed.

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dan Hernandez was present during the times noted above to observe the fit up, welding and related activities associated with the fabrication of the San Francisco Oakland Bay Self Anchored Suspension Bridge at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

OBG Assembly

Segment 2AW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SEG007F-106, 109. The welder is identified #058087 and was observed welding in the 3G (vertical) position.

Segment 1BW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Fillet weld joint. The Weld joint is designated as SEG005D-017, 018, 015, 016, 037, 038, 035, and 036. The welder is identified #044779 and was observed welding in the 2F (horizontal) and 4F (overhead) positions.

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This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SSD46-PP11-253. The welder is identified #066258 and was observed welding in the 2G (horizontal) position.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SSD46-PP11-242. The welder is identified #0200113 and was observed welding in the 2G (horizontal) position.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Fillet weld joint. The Weld joint is designated as SEG005D-067, 068, 069, 070, 047, 048, 049, and 050. The welder is identified #066481 and was observed welding in the 2F (horizontal) and 4F (overhead) positions.

An electrode storage oven was observed being used during welding operations.

ZPMC Quality Control (QC) Inspector is identified as Wang Xu. QA Inspector observed QC Inspector verify welding parameters. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Segment 2AE

This QA Inspector performed Ultrasonic Testing (UT) of approximately 10% of Complete Joint Penetration (CJP) welds previously tested and accepted by ZPMC Quality Control personnel. The weld designations are as follows:

Segment Tag #1

SEG008A-031
SEG008A-001
SEG008A-002
SEG008A-032
SEG008A-003
SEG008A-004
SEG008A-020
SEG008A-017
SEG008A-018
SEG008A-019

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

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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 Eric Tsang, 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By:	Hernandez,Dan	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
