

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-008654**Date Inspected:** 15-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wu Zhi Cheng**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 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 Trial Assembly Yard

Segment 2AW

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a plug weld. The Weld joint is designated as SSD40-PP014-172. The welder is identified as #220068 and was observed welding in the 2G (horizontal) position using approved Welding Procedure Specification WPS-345-FCAW-2G (2F)-repair.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet weld joint. The Weld joint is designated as SSD12-PP16-005. The welder is identified as #048159 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-345-SMAW-2G (2F)-FCM-repair.

This QA Inspector observed grinding of MT indications on the fillet welds of the floor beam diaphragm to floor beam connection along panel point 13.

Segment 2BW

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This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet weld joint. The Weld joint is designated as SSD14-PP17-004. The welder is identified as #054467 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-345-SMAW-2G (2F)-FCM-repair.

Segment 2AE

This QA Inspector observed ZPMC personnel performing Magnetic Particle Testing (MT) on stiffener plate fillet welds along the bolted transverse splice connection area of the side plate by panel point 13, cross beam side.

Segment 5CW/5BW

This QA Inspector observed SMAW of fit up plates along deck plate transverse splice joint for fit up of CJP joint.

Segment 5BW

This QA Inspector observed drilling of bolt holes for the cross beam bolted splice connection along the deck plate of 5BW and CB2.

Segment 3AE/3BE

This QA Inspector observed bolting of the longitudinal diaphragms along the bolted splice connection between panel points 22 and 23, cross beam and counter weight sides.

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

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

Summary of Conversations:

No relevant conversations.

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 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
