

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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008993**Date Inspected:** 03-Sep-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:	Li Jia			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 5BE/5CE

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SP332A-001-020 to 030. The welder is identified as #220064 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-2233-B-U2-F.

This QA Inspector observed back gouging of the root pass along the edge plate transverse CJP splice, cross beam side.

Segment 5BE

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SEG024A-005. The welder is identified as #220069 and was observed

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welding in the 1G (flat) position using approved Welding Procedure Specification WPS-345-FCAW-1G (1F)-repair-1.

Segment 5CW

This QA Inspector observed ABF personnel performing Ultrasonic Testing (UT) on the CJP weld joints on the segment lifting lugs to floor beam web at panel point 35.

Segment 3BW

This QA Inspector observed ZPMC personnel performing Magnetic Particle Testing (MT) on repaired areas of the side plate stiffener hold back welds, counter weight side.

Segment 2BE

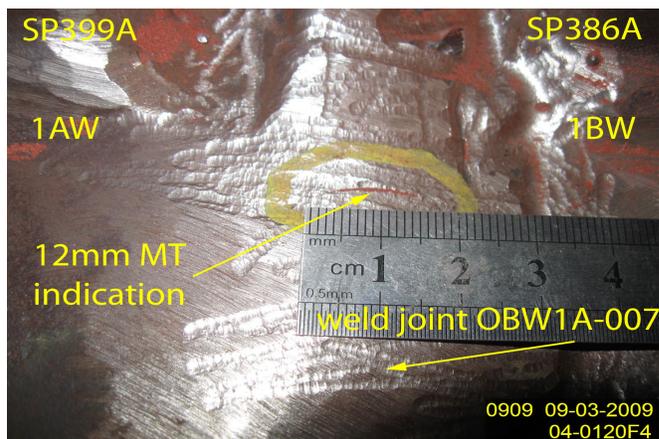
This QA Inspector observed heat straightening in progress on FL2-1 floor beam web and on the floor beam diaphragm at panel point 18, bike path side using HSR (B)-319.

Segment 1AW/1BW

This QA Inspector discovered a transverse linear indication during random QA Magnetic Particle Testing (MT) and visual observations. The transverse indication was located at 1AW to 1BW Transverse Side Plate splice connecting SP399A to SP386A, weld OBW1A-007. The MT indication is approximately 12mm in length on the face of the Complete Joint Penetration weld. It is unknown if this weld was previously tested and accepted by ZPMC QC. An Incident Report was generated for this item.

ZPMC Quality Control (QC) Inspector is identified as Chen Bo. 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.



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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
