

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-008997**Date Inspected:** 10-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 OBE5-006. The welder is identified as #220066 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 Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as DP633A-001-024. The welder is identified as #068250 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-3213-B-U3B.

This QA Inspector observed back gouging sections of the root pass along the side plate CJP transverse splice, cross beam side. The weld joint was welded with ceramic backing

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Segment 5BE

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as SP424A-001-021 to 030. The welder is identified as #220066 and was observed welding in the 2G (horizontal) position using approved Welding Procedure Specification WPS-B-T-2132.

Segment 1BW

This QA Inspector observed ABF personnel performing Magnetic Particle Testing (MT) on the side plate stiffener hold back welds at the 1BW/2AW field splice location. MT was performed on the counter weight and cross beam sides.

Segment 5CW

This QA Inspector observed beveling of the side plate transverse CJP field splice edge with a mechanically guided torch, counter weight side.

Segment 5AE

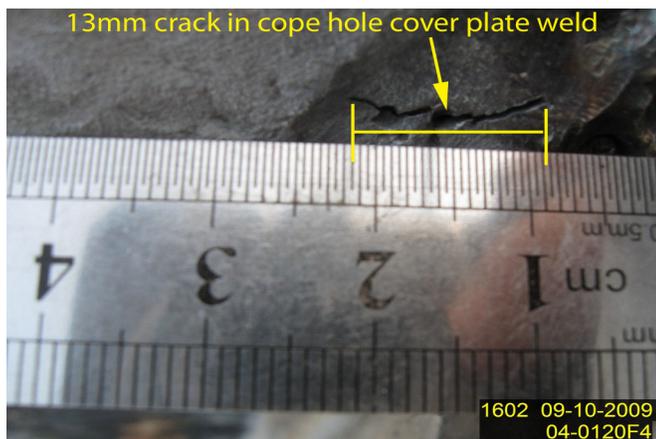
During random visual inspection the Caltrans QA Inspector discovered a visual crack approximately 13mm in length on a fillet weld located at the cover plate for the cope hole of plate Bkx4B. An Incident Report was generated for this item.

Segment 5BE

During random visual inspection the Caltrans QA Inspector discovered that the Side Plate T-Stiffener web splice fit up had a 5mm off set. At the time of QA inspection the welding had already been performed and the root pass had been back gouged. The web splice is at the 5BE/5CE segment splice on Side Plates SP306A (5CE) and SP305A (5BE) weld # SP305A-001-035. An Incident Report was generated for this item.

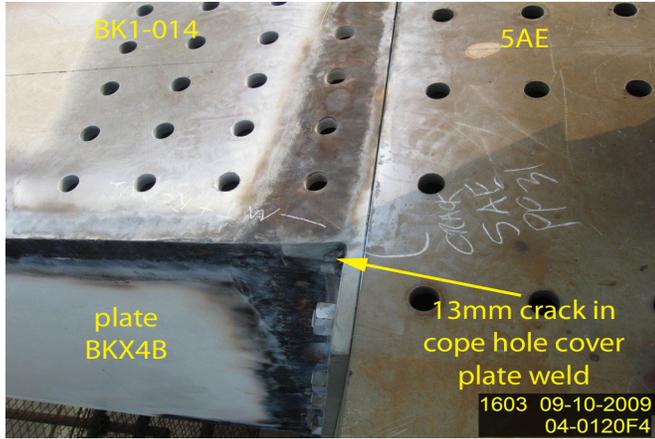
ZPMC Quality Control (QC) Inspector is identified as Chen Bo. QA Inspector observed QC Inspector verify welding parameters. The welding variables recorded by QC appeared to comply with the Applicable WPS.

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



WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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