

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-009047**Date Inspected:** 15-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:** Xu Yumin**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

CB4

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 CB201A-013 at the 5BE connection. The welder is identified as #069493 and was observed welding in the 2G (horizontal) position using approved Welding Procedure Specification WPS-B-P-2212-U4b-FCM-1.

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 CB201A-015 at the 5BW connection. The welder is identified as #037780 and was observed welding in the 2G (horizontal) position using approved Welding Procedure Specification WPS-B-P-2212-U4b-FCM-1.

Segment 1AW/1BW

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This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint repair. The Weld joint is designated as OBW1A-007. The welder is identified as #048659 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1 for WR-7252.

This QA Inspector observed ZPMC performing Magnetic Particle Testing (MT) on three excavations that were UT rejects discovered by ZPMC UT technicians in weld OBW1A-007 at the side plate transverse CJP splice. MT was performed prior to repair welding, counter weight side.

Segment 1AAE/1AE

This QA Inspector observed excavating of a UT reject in the side plate transverse CJP splice on the cross beam side, excavating was performed by carbon air arc gouging.

Segment 5BW

This QA Inspector observed the installation of high strength bolts at the lower chevron connection at panel point 34, cross beam side.

Segment 5BE

This QA Inspector observed heat straightening of the longitudinal diaphragm flange between panel points 34 and 35, bike path side using HSR1 (B)-6723.

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

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested by ZPMC MT personnel. This QA Inspector generated an MT report for this date. The following items were tested:

Document number: 004216

2AW:

SEG007F-016, deck plate stiffener

Notification was submitted to Caltrans to perform QA MT and UT verification at 1AE PP8.5, welds SSD34-PP8.5-153 and SSD34A-PP8.5-153. Upon arrival to location This QA Inspector and QA Inspector Bert Madison discovered repair work marked by ABF had not been completed.

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
