

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-009747**Date Inspected:** 15-Oct-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

Segment 1AAW/1AW

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 OBW1-001. The welder is identified as #042092 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-345-SMAW-1G (1F)-repair-1 for CWR829 UT reject at Y location 1872 from cross beam Edge Plate.

Segment 1AW

This QA Inspector observed ZPMC personnel performing Magnetic Particle Testing (MT) on removed tack welds on the Bottom Plate from Traveler Rail Bracket fit up.

Segment 1AW/1BW

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This QA Inspector observed grinding the weld reinforcement flush on the Side Plate Segment CJP splice, counter weight side.

This QA Inspector observed ABF personnel performing Ultrasonic Testing (UT) on the Deck Plate segment CJP splice, D scan was performed.

Segment 2AW/2BW

During random visual inspection this QA Inspector performed Magnetic Particle Testing (MT) of 6 Ultrasonic Testing (UT) reject excavations in the segment CJP splice, counter weight side joining SP184A and SP172A,. ZPMC technicians previously tested and accepted these 6 excavations. During QA verification this QA Inspector discovered a transverse crack in an excavation at Y location 6490mm from Bottom Plate, length of excavation is 180mm. The transverse crack was approximately 3mm in length. An Incident Report was written for this issue.

Segment 5AE

During random visual inspection the Caltrans QA Inspector discovered visual cracks in the fillet welds on the top cope hole cover plates on plates BKX4A and BKX4B of BK1 panel point 29. The visually observed crack on BKX4A is approximately 13mm in length and approximately 15mm in length on BKX4B. An Incident Report was written for this issue.

ZPMC Quality Control (QC) Inspector is identified as Feng Ya Jun. 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
