

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-011647**Date Inspected:** 28-Jan-2010**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 Yang**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 Segment**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 7BE/7CE

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as OBE7C-007. The welders are identified as #220067 and 068596 and were observed welding in the 3G (Vertical) position using approved Welding Procedure Specification WPS-B-T-223T.

Segment 6CW

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of fillet weld joint. The Weld joint is designated as SP477-001-050, 051. The welder is identified as #067949 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-T-2132 for WR10057.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of fillet weld joint. The Weld joint is

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designated as DP515-001-007 thru 012. The welder is identified as #067665 and was observed welding in the 4F (overhead) position using approved Welding Procedure Specification WPS-B-P-2114-FCM-1.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of fillet weld joint. The Weld joint is designated as DP635-001-013 thru 018. The welder is identified as #067665 and was observed welding in the 4F (overhead) position using approved Welding Procedure Specification WPS-B-P-2114-FCM-1.

Segment 6CE

This QA Inspector observed drilling of bolt hole in the Deck Plate for the connection of the Barrier Rails at panel points 43 to 43, cross beam side.

Segment 7AE/7BE

This QA Inspector observed grinding of the Deck Plate CJP segment splice weld Crown.

This QA Inspector observed back gouging of the Side Plate CJP segment splice root pass, cross beam side.

Segment 6BE/6CE

This QA Inspector observed ABF personnel performing Ultrasonic Testing (UT) on the Deck Plate CJP segment splice weld.

Segment 7CE

This QA Inspector observed the removal of paint by disc grinding at the Edge Plate to Deck Plate CJP splice weld for UT verification.

Segment 6BW

This QA Inspector observed ZPMC personnel performing Magnetic Particle Testing (MT) at locations of removed vertical WT stiffeners on the Edge Plate after Base Metal Repairs (BMR) and grinding, cross beam side.

ZPMC Quality Control (QC) Inspector is identified as Wang Li Yang. 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

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your project.

Inspected By:	Hernandez,Dan	Quality Assurance Inspector
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Reviewed By:	Miller,Mark	QA Reviewer
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