

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-012420**Date Inspected:** 25-Feb-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 7AW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SEG033B-001. The welder is identified as #048659 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-345-SMAW-1G (1F)-repair for WR10697 UT repair.

Segment 6CW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SEG031D-011. The welder is identified as #054467 and was observed welding in the 2G (horizontal) position using approved Welding Procedure Specification WPS-345-SMAW-2G (2F)-repair for WR10686 UT repair.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Segment 5E

This QA Inspector observed grit blasting in progress of the interior of Lift 5 East.

CB5

This QA Inspector observed drilling of bolt holes in the East Side Panel.

Segment 6AE/6BE

This QA Inspector observed ABF personnel performing Magnetic Particle Testing (MT) at locations of removed fit up plates along the Bottom Plate segment CJP splice.

Segment 6BW/6CW

This QA Inspector observed ZPMC personnel performing Ultrasonic Testing (UT) on the Bottom Plate WT-stiffener web splice.

This QA Inspector observed ZPMC personnel performing MT at locations of removed fit up plates along the Side Plate CJP segment spliced, counter weight side.

Segment 6CE/7AE

This QA Inspector observed removal of bolted splice plates along the Deck Plate and Side Plate field splice.

ZPMC Quality Control (QC) Inspector is identified as Zhang Sheng 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:	Miller,Mark	QA Reviewer
---------------------	-------------	-------------