

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-012430**Date Inspected:** 28-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 6AW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SSD11A-PP039-168. The welder is identified as #054467 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-345-SMAW-4G (4F)-repair-1 for WR10688 UT repair.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as OBW6F-003. The welder is identified as #037840 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-TC-U4b-FCM-1.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SSD12A-PP046-169. The welder is identified as #054467 and

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was observed welding in the 2G (horizontal) position using approved Welding Procedure Specification WPS-345-SMAW-2G (2F)-FCM-repair-1 for WR10775 UT repair.

Segment 6AE

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SSD11A-PP038-170. The welder is identified as #067183 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-345-SMAW-4G (4F)-repair-1 for WR10682 UT repair.

This QA Inspector observed ZPMC personnel performing Magnetic Particle Testing (MT) on the Bottom Panel Stiffener plate hold back fillet welds at panel points 38-40 at exterior FL3 Location.

Segment 7AW/7BW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as OBW7B-003. The welder is identified as #067752 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-TC-U4b-FCM-1.

Segment 7CE

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

Segment 6CE

This QA Inspector observed grinding of Deck Plate stiffener plate ends at cross beam connection exterior FL3 PP44-46.

Lift 5 West

This QA Inspector observed grit blasting of interior components in progress.

Segment 7AW

This QA Inspector observed ZPMC personnel performing UT on Longitudinal Diaphragm Flange to Floor Beam CJP connection at panel point 48.

Segment 6BW/6CW

This QA Inspector observed ZPMC personnel performing Magnetic Particle Testing (MT) on the Bottom Plate WT stiffener hold back fillet welds and along interior Deck Plate CJP splice at areas of removed fit up plates.

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This QA Inspector observed fit up of Counter Weight Assembly to Edge Plate at panel points 42-44.

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