

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-012426**Date Inspected:** 04-Mar-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 6BE/6CE

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of Base Metal Repairs (BMR) of the Side Plates. The welder is identified as #037743 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-345-SMAW-4G (4F)-FCM-repair-1 following CWR1098.

Segment 6CE

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 SSD27-PP044-032. The welder is identified as #048659 and was observed welding in the 2G (horizontal) position using approved Welding Procedure Specification WPS-345-SMAW-2G (2F)-repair-1.

This QA Inspector observed ZPMC QC measuring the bolt hole edge distance on FL3 Floor beam at panel point

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

44-46.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of Base Metal Repairs (BMR) of the Edge Plate. The welder is identified as #066413 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-345-SMAW-4G (4F)-FCM-repair-1 following CWR1098.

This QA Inspector observed ZPMC personnel performing Ultrasonic Testing (UT) of Partial height Diaphragm CJP flange and web Splices.

Segment 6AW

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 CA025-001. The welder is identified as #067183 and was observed welding in the 2G (horizontal) position using approved Welding Procedure Specification WPS-345-SMAW-2G (2F)-repair-1.

Segment 6CW

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 SSD25-PP045-117. 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 following WR10796.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of Base Metal Repairs (BMR) of the Side Plates. The welder is identified as #066413 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-345-SMAW-4G (4F)-FCM-repair-1 following CWR1098.

This QA Inspector observed ABF personnel performing Magnetic Particle (MT) on FL3 web at locations of removed fit up plates, panel point 45 at cross beam connection.

This QA Inspector observed ABF personnel performing MT at locations of removed fit up plates along top Counter Weight Connection plate and Deck Plate CJP splice, at panel points 44-46.

This QA Inspector observed trimming of Bottom Plate WT Stiffener ends, flange and web at field splice location by flame hand cutting.

Segment 6BE

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

ZPMC Quality Control (QC) Inspector is identified as Fang 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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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
---------------------	-------------	-------------