

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-012467**Date Inspected:** 08-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 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-PP045-171. 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-1 for WR10763 UT repair.

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-PP045-174. 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 for WR10784 UT repair.

This QA Inspector observed ZPMC personnel performing Ultrasonic Testing (UT) on FL3 web to bottom flange hold back CJP weld at panel point 45.

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This QA Inspector observed ZPMC personnel performing Magnetic Particle Testing (MT) at locations of removed fit up plates along Side Plate field splice, panel point 47 cross beam side.

Segment 6AW

This QA Inspector observed ZPMC personnel performing Magnetic Particle Testing (MT) on FL3 horizontal stiffener hold back fillet welds at panel point 40.

Segment 6CW

This QA Inspector observed ZPMC personnel performing Ultrasonic Testing (UT) on FL3 web to bottom flange hold back CJP weld at panel points 44, 45, 46.

This QA Inspector observed drilling of bolt holes in FL3 bottom panel for the assembly of traveler rail bracket at panel point 44-45.

Segment 7BW/7CW

This QA Inspector observed grinding of Bottom Plate CJP weld crown flush on interior.

This QA Inspector observed fit up of Edge Plate I-rib splice, counter weight side.

This QA Inspector observed removal of remaining portion of fit up plates along the Side Plate CJP splice by Arc Gouging, cross beam side.

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 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
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Reviewed By:	Miller,Mark	QA Reviewer
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