

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-013591**Date Inspected:** 23-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 7AE/7BE

This QA Inspector observed ZPMC personnel performing Magnetic Particle Testing (MT) of Bottom Plate WT stiffener hold back fillet welds after removal of previously marked MT indications by grinding.

This QA Inspector observed ZPMC personnel performing Magnetic Particle Testing (MT) of Deck plate along interior segment CJP splice at locations of removed fit up plates..

This QA Inspector observed ZPMC personnel performing Ultrasonic Testing (UT) of Edge Plate CJP splice, bike path side. D scan was performed.

Segment 7BW/7CW

This QA Inspector observed back gouging of the Deck Plate I rib CJP web splice root pass, cross beam side.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Segment 7AW

This QA Inspector observed ZPMC personnel performing MT of removed temporary welds at strong back attachment along Side Plate to Bottom Plate CJP splice, counter weight side west of panel point 48.

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.

Weld Test Lab

This QA Inspector observed Side Bend testing of 3G test coupons. Twenty four (24) plates were tested with 2 coupons per plate. The following results were observe

#54- Zhang De Xia - FCAW- Accepted
#64- Yang Shi Ge - FCAW- Accepted
#65- Yang Ming Li -FCAW- Accepted
#53- Guo Jia Lin - FCAW- Accepted
#51- Ma Ming Hu - FCAW- Accepted
#61- Zhang Qiang - FCAW- Accepted
#63- Wang Zhi Fen - FCAW- Accepted
#60- Dai Ming Hui - SMAW- Accepted
#65- Yang Ming Li - SMAW - Failed
#66- Li Meng Qiang - SMAW- Accepted
#17- Jiao An Lei - FCAW- Accepted
#15- Li Fu Meng - FCAW- Accepted
#14- Han Wei Xian - FCAW- Accepted
#47- Qu Qing Shan - FCAW- Accepted
#4- Wang Xian Ming - SMAW- Accepted
#10- Li Yu Chao - SMAW- Accepted
#5- Xu Nai Jun - SMAW- Accepted
#2- Xu Nai Shen - SMAW- Accepted
#8- Li Jia Jun - SMAW- Accepted
#12- Cheng Chong Lang - SMAW- Accepted
#7- Hong Jiang - SMAW- Accepted
#1- Wang Pei SMAW- Accepted
#9- Xia Zheng Guo - SMAW- Accepted
#6- Li Ji Tang - SMAW- Accepted

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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:	Carreon,Albert	QA Reviewer
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