

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-013604**Date Inspected:** 07-Apr-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

BK1-027

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as BK001-027-007. The welder is identified as #220067 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-2233-TC-U4b-F.

BK1-026

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as BK001-026-005. The welder is identified as #220069 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-2233-TC-U4b-F.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Segment 7AE

This QA Inspector observed grit blasting in progress in the interior of the segment.

Segment 7CW

This QA Inspector observed beveling of the Deck Plate with the use of a mechanical guided torch.

Segment 7BW

This QA Inspector observed ABF personnel performing Magnetic Particle Testing (MT) at locations of removed welds of temporary stiffener on FL# panel point 51.

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.

Plate Yard

This QA Inspector selected one (1) 460mm x 355mm plate check sample and assigned a QA Lot number to the following sampled material:

Item 725: 100mm A709M-345F2-X-Z, HT# 09304203N#, Lot# B222-005-10

Samples were marked with Lot number, Item number, material thickness, date and direction of rolling. Samples will be shipped to an Independent Testing lab.

Bolt Testing Room

This QA Inspector observed ZPMC personnel performing Rotational Capacity and Pre-installation torque verification testing with a Skidmore-Wilhelm MS 15865 (cal expiration date 6/1/10) and torque wrench identified as #2 (cal expiration date 3/10/11) on the follow bolts:

#39 Lot DHGM220083 M22x90
#15 Lot DHGM220073 M22x60
#27 Lot DHGM220090 M22x120
#28 Lot DHGM220089 M22x110
#59 Lot DHGM220092 M22x65
#51 Lot DHGM220094 M22x80
#71 Lot DHGM220093 M22x85
#72 Lot DHGM220095 M22x80

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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:	Carreon,Albert	QA Reviewer
