

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-013610**Date Inspected:** 14-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

Segment 7DE

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 SSD27-PP057-171. The welder is identified as #222396 and was observed welding in the 2G (Horizontal) position using approved Welding Procedure Specification WPS-B-T-2232T.

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 SSD27-PP057-138. The welder is identified as #222396 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-2233T.

Segment 8BE

This QA Inspector observed ABF personnel performing Ultrasonic Testing (UT) of the Edge Plate to Deck Plate

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CJP splice, cross beam side. D scan was performed.

This QA Inspector observed beveling of the Side Plate with the use of a mechanical guided torch, cross beam side at east end.

Segment 7DE/7EE

This QA Inspector observed the Deck Plate transverse CJP splice root pass had been removed due to deck plate misalignment.

Segment 7CE/7DE

This QA Inspector observed ZPMC personnel performing Magnetic Particle Testing (MT) on the Side Plate W stiffener hold back fillet welds, cross beam side.

This QA Inspector observed ZPMC personnel performing UT on the Side Plate transverse CJP splice, bike path side. D scan was performed.

This QA Inspector observed ZPMC personnel performing MT along the Bottom Plate transverse CJP splice at locations of removed fit up plates after grinding.

Segment 7AW/7BW

This QA Inspector observed ZPMC personnel performing MT along the Side Plate Transverse CJP splice at locations of removed fit up plates after grinding, cross beam side.

Segment 7EE

This QA Inspector observed fit up and tack welding of the Bike Path Cantilever to Bike Path connection plate at panel point 59.

Segment 8BW

This QA Inspector observed ABF personnel performing UT on the Edge Plate to Deck Plate CJP splice, cross beam side. D scan was performed.

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.

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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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