

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-014049**Date Inspected:** 05-May-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 7DW/7EW

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of fillet weld joint. The Weld joint is designated as SP443-001-011, 012. The welder is identified as #067609 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-T-2112-FCM-1.

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 SP483-001-050. The welder is identified as #037723 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-T-2214-B-U2-FCM-1.

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 SP442-001-056. The welder is identified as #037748 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

WPS-B-T-2214-B-U2-FCM-1.

This QA Inspector observed Base Metal repair using the Shielded Metal Arc Welding (SMAW) in progress at locations of removed fit up plates along the exterior of the Side Plate transverse CJP splice. The welder is identified as #069683 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-345-SMAW-4G (4F)-FCM-repair-1 for WR11052.

BK1-031

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as BK001-031-055, 056. The welder is identified as #220066 and was observed welding in the 3F (vertical) position using approved Welding Procedure Specification WPS-B-T-2133.

BK1-035

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as BK001-035-053, 054. The welder is identified as #222396 and was observed welding in the 3F (vertical) position using approved Welding Procedure Specification WPS-B-T-2133.

BK1-034

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as BK001-034-053, 054. The welder is identified as #220066 and was observed welding in the 3F (vertical) position using approved Welding Procedure Specification WPS-B-T-2133.

Segment 8BW/8CW

This QA Inspector observed back gouging of the root pass on the Bottom Plate transverse CJP splice.

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 LAB

This QA observed Guided Bend Tests on 25mm x 10mm x 150mm Side Bend weld test coupons for Welder Qualifications of the following ZPMC personnel, process and position:

Flux Cored Arc Welding, 4G WPS-B-T-2234-B-U2a-F-1

Guo Hong Bin – Acceptable bend test results

Yu Fang Fu – Acceptable bend test results

Yu Fang Run – Acceptable bend test results

Shen Bin Fa – Acceptable bend test results

Tang Hai Jun – Acceptable bend test results

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Chen Ru Quan – Rejected bend test results
Feng Qi Yuan – Acceptable bend test results
Zhou De Hui – Acceptable bend test results
Xu Da Cai – Acceptable bend test results
Qu Huo Lin – Acceptable bend test results
Zhou De Quan – Acceptable bend test results

Shield Metal Arc Welding, 4G WPS-B-P-2214-B-U2a-1

Sun Cheng Jin – Acceptable bend test results
Cao Yi Hui – Acceptable bend test results
Sun Cheng Zhuo – Acceptable bend test results

ZPMC QA Lay Tao was present during Guided Bend Test.

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
Reviewed By:	Carreon,Albert	QA Reviewer
