

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-014565**Date Inspected:** 05-Jun-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 8BW

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 OBW8A-021. The welder is identified as #045209 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-T-2231T-1.

Segment 8BW/8CW

This QA Inspector observed ABF personnel performing Ultrasonic Testing on the Edge Plate to Deck Plate hold back CJP weld, cross beam side.

Segment 9AE/9BE

This QA Inspector observed ABF personnel performing Magnetic Particle Testing on the Side Plate along the

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transverse CJP splice at locations of removed fit up plates, bike path side.

This QA Inspector observed ABF personnel performing Ultrasonic Testing on the Side Plate transverse CJP, bike path side.

Segment 9AW

This QA Inspector observed Match drilling of the Bottom Plate and Side Plate WT stiffener flanges for bolted splice plates at 8CW/9AW field splice.

Segment 8AE

This QA Inspector observed ZPMC personnel performing Magnetic Particle Testing on the Deck Plate at the 7EE/8AE field splice at locations of removed fit up plates.

Lift 7 East

This QA Inspector observed grit blasting in progress on the exterior of the Lift.

ZPMC Quality Control (QC) Inspector is identified as Wang Zhu. QA Inspector observed QC Inspector verify welding parameters. The welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC MT personnel. The following items were tested:

Bike Path Cantilevers

BK001-030-001, 002, 005, 006, 007, 009

BK001-031-001, 002, 005, 006, 007, 009

BK001-032-001, 002, 005, 006, 007, 009

BK001-033-001, 002, 005, 006, 007, 009

BK001-034-001, 002, 005, 006, 007, 009

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.

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Inspected By:	Hernandez, Dan	Quality Assurance Inspector
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Reviewed By:	Carreon, Albert	QA Reviewer
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