

**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-014795**Date Inspected:** 08-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 8CE

This QA Inspector observed Base Metal Repair using Shielded Metal Arc Welding (SMAW) in progress at locations of removed fit up plates along the exterior of the Side Plate transverse CJP splice on the East end of the segment. The welder is identified as #062092 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-345-SMAW-4G (4F)-FCM-repair-1 for CWR1414.

Segment 9AE

This QA Inspector observed Base Metal Repair using Shielded Metal Arc Welding (SMAW) in progress at locations of removed fit up plates along the exterior of the Side Plate transverse CJP splice on the West end of the segment. The welder is identified as #062092 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-345-SMAW-4G (4F)-FCM-repair-1 for WR13193.

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# WELDING INSPECTION REPORT

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## Segment 9AW

This QA Inspector observed Longitudinal Diaphragm LD11A has been removed following WR 13499 at panel point 72 west, counter weight side.

## Segment 9AW/9BW

This QA Inspector observed grinding of the Deck Plate transverse CJP root pass after back gouging.

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

## Bolt Testing Room

This QA Inspector observed ZPMC personnel performing Rotational Capacity and Pre-installation torque verification testing of A325 High Strength Bolt assemblies with a Skidmore-Wilhelm Model MS serial number 15866 (calibration expiration date 4/29/11) and torque wrench identified as #2 (calibration expiration date 3/10/11) on the follow bolts:

Lot # DHG60625 3/4"x3 3/4"

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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<b>Inspected By:</b>	Hernandez,Dan	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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