

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-015035**Date Inspected:** 19-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 8CW

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 at 8CW/9AW field splice counter weight side. The welder is identified as #068097 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 Deck Plate transverse CJP splice at 8CE/9AE field splice. The welder is identified as #062092 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-345-SMAW-1G (1F)-FCM-repair-1 for WR13193.

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For the above mentioned welding activities ZPMC Quality Control (QC) Inspector is identified as Zhang Hai Tao. QA Inspector observed QC Inspector verify welding parameters. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Segment 7DW

This QA Inspector observed ABF personnel performing Ultrasonic Testing on the FL3 partial Height Diaphragm CJP welds at panel points 56 to 58.

Segment 8BW

This QA Inspector observed ZPMC personnel performing Magnetic Particle Testing at removed fillet welds on WT stiffener flange to Floor beam web connection clip on east side of floor beam at panel point 67.

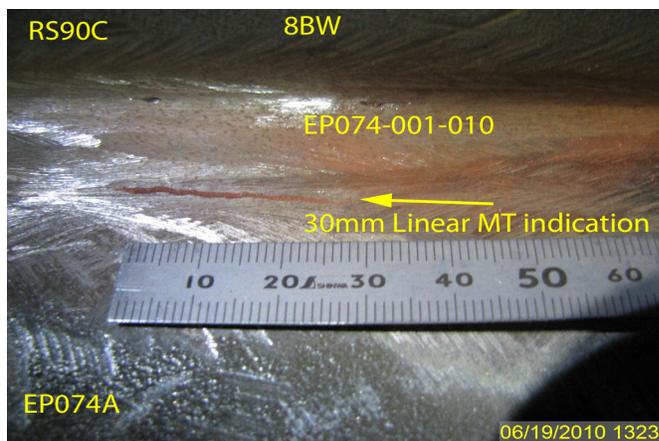
QA Verification

During the Quality Assurance Magnetic Particle Testing (MT) review of hold back welds located on Segment 8BW, this Quality Assurance Inspector (QA) discovered the following issues:

- Four Longitudinal linear indications measuring approximately 30mm, 3mm, 5mm and 12mm in length.
- The weld is identified as: EP074-001-010.
- The weld is a 6mm Fillet Weld joining the I-Rib RS90C to Edge Plate EP074A in the Corner Assembly (cross beam side).
- The Notice of Witness Inspection Number (NWIT) is 006009. The indication is located within the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

An Incident Report was written for this issue.

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



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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
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Reviewed By:	Peterson,Art	QA Reviewer
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