

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-015287**Date Inspected:** 03-Jul-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 9AW/9BW

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 OBW9B-003. The welder is identified as #067609 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-345-SMAW-4G (4F)-repair-1, UT repair for WR13906.

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 OBW9B-002. 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)-repair-1, UT repair for WR13907.

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 DP671-001-021. The welder is identified as #067588 and was

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observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-3213-B-U3b.

Segment 9AW

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 SEG049B-004. The welder is identified as #045143 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-T-2231-TC-U4b-F.

For the above mentioned welding activities 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.

Lift 7 West

This QA Inspector observed grit blasting in progress on the interior of the segments.

Segment 9AW/9BW

This QA Inspector observed grinding of weld profiles on the WT stiffener and I-rib stiffener hold back fillet welds and web CJP splice welds of the Deck Plates, Side Plates and Bottom Plates.

QA Verification

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:

7BW

RETRO-G1-01-7BW-A1-018
RETRO-G1-01-7BW-A1-019
RETRO-G1-01-7BW-A1-007
RETRO-G1-01-7BW-A1-008
RETRO-G1-01-7BW-A2-007
RETRO-G1-01-7BW-A2-008
RETRO-G1-01-7BW-A3-007
RETRO-G1-01-7BW-A3-008

7CW

RETRO-G1-01-7CW-A1-018
RETRO-G1-01-7CW-A1-019
RETRO-G1-01-7CW-A1-007
RETRO-G1-01-7CW-A1-008

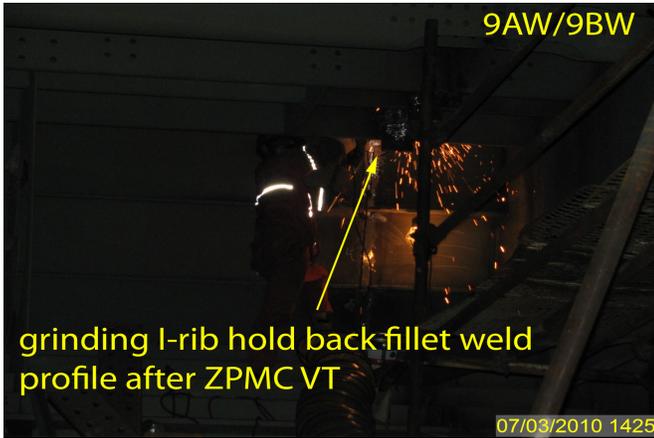
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RETRO-G1-01-7CW-A2-007
RETRO-G1-01-7CW-A2-008
RETRO-G1-01-7CW-A3-007
RETRO-G1-01-7CW-A3-008

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

Due to inclement Weather work in the OBG Trial Assembly yard was limited.



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:	Peterson,Art	QA Reviewer
