

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-015652**Date Inspected:** 15-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**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 9CE/9DE

This QA Inspector observed Base Metal Repair using the Shielded Metal Arc Welding (SMAW) process at locations of removed fit up plates along the exterior of the Bottom Plate transverse CJP splice. 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 CWR1679 R1.

Segment 9DE/9EE

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 BP181-001-026, Bottom Plate WT stiffener Web splice at back gouged root pass. The welder is identified as #068793 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-2233T.

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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 BP073-001-020, Bottom Plate WT stiffener Web splice at back gouged root pass. The welder is identified as #068793 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-2233T.

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 BP127-001-028, Bottom Plate WT stiffener Web splice at back gouged root pass. The welder is identified as #067947 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-2233T.

Segment 9BW/9CW

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 OBW9-008, Deck Plate splice. The welder is identified as #066746 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-T-223(2)1T-1.

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 OBW9-007, Deck Plate splice. The welder is identified as #066673 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-T-2231T-1.

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 OBW9B-008, Bottom Plate splice. The welder is identified as #069683 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-T-2231T-1.

For the above mentioned welding activities ZPMC Quality Control (QC) Inspectors are identified as Wang Li Yang and Wang Zhu. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Segment 9DE/9EE

This QA Inspector observed back gouging of the Bottom Plate WT Stiffener web splice.

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

Segment 9BE/9CE

This QA Inspector observed ABF personnel performing Ultrasonic Testing on the Bottom Plate to Side Plate CJP splice at hold back location, bike path side.

Segment 9CE/9DE

This QA Inspector observed ZPMC personnel performing Magnetic Particle Testing at locations of removed fit up

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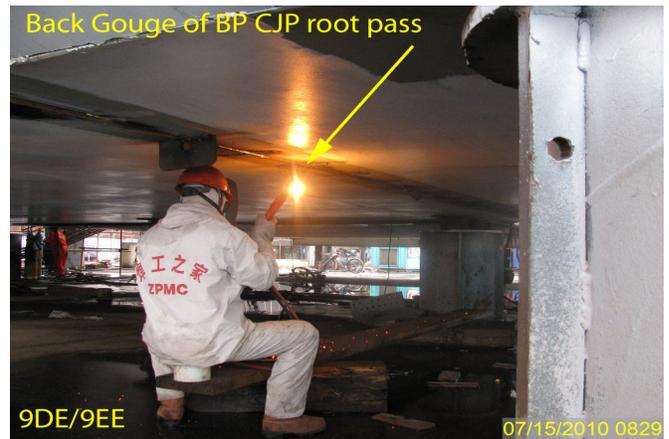
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plates along the Side Plate transverse CJP splice, bike path side.

BK1-038

This QA Inspector observed heat straightening of the Bottom Panel of the bike path cantilever at weld BK001-038-006 following HSR1(B)-8834.

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
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Reviewed By:	Peterson,Art	QA Reviewer
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