

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-015949**Date Inspected:** 31-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:** welder qual**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.

Bay 11

This QA Inspector observed Welder Qualification using the Flux Cored Arc Welding (FCAW) process for Complete Joint Penetration (CJP) Groove Tests for plate of unlimited thickness in the 3G (vertical) position and Fillet Weld Tack Welder Qualification Test in the 4F (overhead) position.

Position, WPS and Test Plate ID# are as follows:

3G

FCAW

WPS-B-T-2233T

F1-3G

F2-3G (VT Reject)

F3-3G

F4-3G

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

F5-3G
F7-3G
F8-3G
F9-3G
F10-3G
F11-3G
F12-3G
F13-3G
F15-3G

4F
FCAW
WPS-B-T-2134

F1-4F
F2-4F
F3-4F
F4-4F
F5-4F
F7-4F
F8-4F
F9-4F
F10-4F
F11-4F
F12-4F
F13-4F
F14-4F

Bay 10

This QA Inspector observed Welder Qualification using the Flux Cored Arc Welding (FCAW) and Shield Metal Arc Welding (SMAW) process for Complete Joint Penetration (CJP) Groove Tests for plate of unlimited thickness in the 3G (vertical) position and SMAW Fillet Weld Tack Welder Qualification Test in the 3F (vertical) position 4F (overhead) position.

Position, Process, WPS and Test Plate ID# are as follows:

3G
FCAW
WPS-B-T-2233T

6-F-3G
11-F-3G
13-F-3G (VT Reject)

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

17-F-3G

21-F-3G

3G

SMAW

WPS-B-P-2213-B-U2a-1

26-S-3G

28-S-3G

1-S-3G

2-S-3G

7-S-3G

4F

SMAW

WPS-B-P-2114

44486-4F

205616-4F

57184-4F

57251-4F

40562-4F

6200-4F

205758-4F

3F

SMAW

WPS-B-P-2113

40334-3F

44486-3F

ZPMC QC CWI Li Yang and CWI Zhao Chen Fu were present during Welder qualification. 3G test coupons will be sent to ZPMC weld lab for Radiographic Testing and Mechanical Bend Tests.

Visual for CJP test plates and Tack weld Visual and Fracture Testing results were accepted by ZPMC QC unless otherwise noted.

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

WELDING INSPECTION REPORT

(Continued Page 4 of 4)



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