

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-016260**Date Inspected:** 18-Aug-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 10AW/10BW

This QA Inspector observed Submerged Arc Welding (SAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as OBW10-003, Deck Plate splice. The welders are identified as #042195 and # 040699 and were observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-T-223(2)1T-1.

Segment 10AW

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 OBW10L-004, bottom counter weight connection plate. The welder is identified as #067665 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-TC-U4b-F.

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Segment 9AE

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 OBE9D-054, Diverter Plate. The welder is identified as #048659 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-P-2213-B-U2-FCM-1.

Segment 9BE

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 OBE9D-057, 070 Diverter Plate. The welder is identified as #048659 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-P-2213-B-U2-FCM-1.

Segment 9CE

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 OBE9D-073, Diverter Plate. The welder is identified as #048659 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-P-2213-B-U2-FCM-1.

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 OBE9D-060, Diverter Plate. The welder is identified as #049769 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-P-2213-B-U2-FCM-1.

Segment 9DE

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 OBE9D-061, 064, Diverter Plate. The welder is identified as #049769 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-P-2213-B-U2-FCM-1.

Segment 9EE

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 OBE9D-065, Diverter Plate. The welder is identified as #049769 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-P-2213-B-U2-FCM-1.

Segment 9AE/9BE

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet weld joint. The Weld joint is designated as OBE9D-055, 056, Diverter Plate. The welder is identified as #048659 and was observed

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welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-T-2112-FCM-1.

Segment 9BE/9CE

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet weld joint. The Weld joint is designated as OBE9D-071, 072, Diverter Plate. The welder is identified as #048659 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-T-2112-FCM-1.

Segment 9CE/9DE

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet weld joint. The Weld joint is designated as OBE9D-062, 063, Diverter Plate. The welder is identified as #049769 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-T-2112-FCM-1.

Segment 9DE/9EE

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet weld joint. The Weld joint is designated as OBE9D-066, 067, Diverter Plate. The welder is identified as #049769 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-T-2112-FCM-1.

For the above mentioned welding activities ZPMC Quality Control (QC) Inspector is identified as Zhou Peng and An Qing Xiang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Segment 9DW/9EW

This QA Inspector observed ABF personnel performing Ultrasonic Testing on the Side Plate transverse CJP splice, counter weight side. D scan was performed.

Segment 10AE

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

CB12

This QA Inspector observed match drilling of the Side Panel and bolted splice plate, west side at 9DE.

Segment 9CE/9DE

This QA Inspector observed fit up of Diverter Plate at Deck Plate transverse CJP segment splice.

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

Reviewed By: Peterson,Art

QA Reviewer
