

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017217**Date Inspected:** 04-Oct-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 Segments**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 11AW/11BW

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 OBW11B-004, Side Plate transverse splice. The welder is identified as #067609 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-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 OBW11B-005, Side Plate transverse splice. The welder is identified as #040656 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-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 OBW11-001, Edge Plate transverse splice. The welder is

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identified as #040611 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 OBW11-005, Edge Plate transverse splice. The welder is identified as #041713 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-P-2213-B-U2-FCM-1.

Segment 11AE/11BE

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 OBE11-005, Edge Plate transverse splice. The welder is identified as #500363 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-P-2213-B-U2-FCM-1.

Segment 11AW

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 SEG065A-011, Side Plate to Bottom Plate hold back weld. The welder is identified as #067609 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1.

Segment 11BW

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 SEG067A-043, Side Plate to Bottom Plate hold back weld. The welder is identified as #067609 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1.

Segment 10AE

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 FB014-040-053, Web plate insert spliced at location of replaced damaged section of web. The welder is identified as #044504 and was observed welding in the 2G (horizontal) position using approved Welding Procedure Specification WPS-345-SMAW-2G (2F)-FCM-repair-1, UT repair for WR15480.

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

Segment 10AW

This QA Inspector observed back drilling of bolt holes in the Side Plate for the placement of the Suspender Bracket at panel point 86.

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CB 17

This QA Inspector observed heat straightening of the Bottom Panel following HSR1(B)-9449.

Bay 10

QA Verification

This QA Inspector observed Tack Welder Qualification using the Shielded Metal Arc Welding (SMAW) process.

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

3F - WPS-B-P-2113

4F - WPS-B-P-2114

SMAW

Crew 1

1-Liu Zhenhai 3F, 4F

2-Sun LiBen 3F, 4F

4-Zhang Qizhong 4F

5-Lu Shuanggen 3F, 4F

6-Song Xinguang 3F, 4F

7-Wang Tao 3F, 4F

8-Zhu Hairong 4F

11-Sui Xiaobiao 3F, 4F

12-Zhang Guangtian 3F

14-Liu Hongjun 3F, 4F

15-Bai Fayang 3F, 4F

16-Xiao Chaofeng 3F

17-Wu Liuyuan 3F, 4F

18-Tian Ziwei 4F

Crew 2

7-Ding Wenan 3F

8-Chen Jung 3F, 4F

9-Wang Xiaorong 4F

10-Liu Xiang 3F, 4F

12-Yang Youli 3F

14-Bia Yinan 3F, 4F

For the above mentioned welder test plates, both visual and fracture test were accepted by ZPMC CWI Li Yang.

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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
Reviewed By:	Peterson,Art	QA Reviewer
