

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017528**Date Inspected:** 23-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 11BW

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as BP160-043, 044, Bottom Plate WT stiffener hold back. The welder is identified as #040736 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-T-2132.

Segment 11CW

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as BP161-039, 040, Bottom Plate WT stiffener hold back. The welder is identified as #040736 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-T-2132.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Segment 11BW/11CW

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 OBW11B-009, Side Plate transverse splice. The welder is identified as #040609 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 OBW11B-007, Side Plate transverse splice. The welder is identified as #053316 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 OBW11B-006, Side Plate transverse splice. The welder is identified as #042218 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-2233T.

Segment 11BE/11CE

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 OBW11E-008, Bottom Plate transverse splice. The welder is identified as #040367 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-T-2231T.

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 OBE11B-003, Bottom Plate transverse splice. The welder is identified as #044515 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-345-SMAW-1G (1F)-FCM-repair-1 for CWR2072 R1, UT repair.

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

Segment 10CW

This QA Inspector observed ZPMC personnel performing Magnetic Particle Testing on the Deck Plate I-rib stiffener hold back fillet welds at the exterior FL3 location at panel points 92-94.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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