

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-018463**Date Inspected:** 29-Nov-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 11EE

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated CA094-002, Edge Plate to Deck Plate hold back weld. The welder is identified as #040320 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-TC-U4b-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 CA094-001, Edge Plate to Side Plate hold back weld. The welder is identified as #044515 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-TC-U4b-FCM-1.

Segment 12AE

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This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated CA3001-002, Edge Plate to Deck Plate hold back weld. The welder is identified as #040320 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-TC-U4b-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 CA3001-001, Edge Plate to Side Plate hold back weld. The welder is identified as #044515 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-TC-U4b-FCM-1.

Traveler Rail Bracket

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated TR2A-PP096-002, Traveler Rail Bracket connection plate. The welder is identified as #053486 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-T-2231-TC-U4c-F.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated TR1A-PP107-002, Traveler Rail Bracket connection plate. The welder is identified as #049220 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-2233-ESAB.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated TR1A-PP103-002, Traveler Rail Bracket connection plate. The welder is identified as #053486 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-T-2231-TC-U4c-F.

Segment 11DW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated SEG073C-018, Longitudinal Diaphragm to Floor Beam. The welder is identified as #040611 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-345-SMAW-3G (3F)-FCM-repair-1 for WR17854, UT repair.

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

Segment 11DE/11EE

This QA Inspector observed ABF personnel performing Magnetic Particle Testing along the Side Plate transverse CJP splice, bike path side.

Segment 11DW

WELDING INSPECTION REPORT

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This QA Inspector observed ABF personnel performing Ultrasonic Testing on the Side Plate to Bottom Plate longitudinal splice, counter weight side.

This QA Inspector observed match drilling of bolt holes in the Deck Plate U-ribs with splice plate at the west end of the segment.

Segment 11DW/ Cross Beam 16/11DE

This QA Inspector observed match drilling of the Deck Plate and Cross Beam Deck Panel with splice plate at the Cross Beam to Segment connection.

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:	Dsouza,Christopher	QA Reviewer
