

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-019393**Date Inspected:** 17-Jan-2011**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:** Zhou Zhong Hai**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 12BW/12CW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated OBW12E-001, Side Plate transverse splice. The welder is identified as #044551 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 CA3012-011, Side Plate transverse splice. The welder is identified as #040611 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 EP3008-001-013, 014, Edge Plate I-rib splice. The welder is

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identified as #057333 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1.

Segment 12BW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated SEG3005K-090, Longitudinal Diaphragm to Bottom Plate hold back weld. The welder is identified as #046704 and was observed welding in the 2G (horizontal) position using approved Welding Procedure Specification WPS-B-P-2212-TC-U4b-FCM-1.

Segment 12CW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated SEG3006T-035, Longitudinal Diaphragm to Bottom Plate hold back weld. The welder is identified as #046704 and was observed welding in the 2G (horizontal) position using approved Welding Procedure Specification WPS-B-P-2212-TC-U4b-FCM-1.

Segment 12BE/12CE

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated EP3005-001-013, Edge Plate I-rib splice. The welder is identified as #044515 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 SP3018-001-042, Side Plate WT stiffener web splice. The welder is identified as #040320 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 SP3005-001-031, Side Plate I-rib splice. The welder is identified as #050289 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1.

Segment 12AE

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a UT repair on a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated SEG3001X-051, Longitudinal Diaphragm to Bottom Plate hold back weld. The welder is identified as #050289 and was observed welding in the 2G (horizontal) position using approved Welding Procedure Specification WPS-345-SMAW-2G (2F)-FCM-repair-1 for WR20103.

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

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Segment 12AW

This QA Inspector observed the installation of the FL3 Bottom Panel.

Segment 12BW

This QA Inspector observed match drilling of bolt holes for splice plate at the Deck Plate U-ribs at the 12AW/12BW transverse splice.

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
