

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-021781**Date Inspected:** 12-Mar-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:** 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 12BE

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 SEG3002M-090, Longitudinal Diaphragm to Bottom Plate. The welder is identified as #040367 and was observed welding in the 2G (horizontal) position using approved Welding Procedure Specification WPS-345-SMAW-2G (2F)-FCM-repair-1, for WR20266.

Segment 12AE

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet weld joint. The Weld joint is designated SEG3001E-131, 132, Floor Beam to Side Plate. The welder is identified as #044504 and was observed welding in the 3F (vertical) position using approved Welding Procedure Specification WPS-B-P-2113-FCM-1.

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Segment 12CE

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet weld joint. The Weld joint is designated DP3022-001-009, Deck Plate Diaphragm to Deck Plate. The welder is identified as #040270 and was observed welding in the 4F (overhead) position using approved Welding Procedure Specification WPS-B-P-2114-FCM-1.

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

Cantilever Brackets

This QA Inspector observed ABF personnel performing Magnetic Particle Testing on the web to flange connection of the east line cantilever brackets.

Segment 12BW/12CW

This QA Inspector observed ABF personnel performing Magnetic Particle Testing on the Deck Plate transverse CJP splice, including locations of removed fit up plates.

QA Verification

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ABF MT personnel. The following items were tested:

Cantilever Brackets

SA6527-001-001
SA6527-001-003
SA6527-002-002
SA6527-002-004
SA6527-003-002
SA6527-003-004
SA6527-004-002
SA6527-004-004

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

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your project.

Inspected By:	Hernandez,Dan	Quality Assurance Inspector
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Reviewed By:	Miller,Mark	QA Reviewer
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