

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-022172**Date Inspected:** 27-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 Hua Jie**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 12CW

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 OBW12C-026, Cantilever Bracket top flange to Edge Plate at panel point 116.5. The welder is identified as #046709 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-345-SMAW-1G (1F)-FCM-repair-1.

Segment 13AE

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated SEG3007Q-040, Plate X2490 to Edge Plate. The welder is identified as #066236 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-2233-ESAB.

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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 OBE12C-030, 033, Cantilever Bracket top and bottom flange to Edge Plate at panel point 112.5. The welder is identified as #067752 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-345-SMAW-4G (4F)-FCM-repair-1 for WR20511.

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 OBE12C-014, Cantilever Bracket top flange to Edge Plate at panel point 113.5. The welder is identified as #067752 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-345-SMAW-4G (4F)-FCM-repair-1 for WR20511.

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 OBE12C-018, Cantilever Bracket bottom flange to Edge Plate at panel point 114.5. The welder is identified as #067752 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-345-SMAW-4G (4F)-FCM-repair-1 for WR20511.

Segment 12CE

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 OBE12C-022, 025, Cantilever Bracket top and bottom flange to Edge Plate at panel point 116.5. The welder is identified as #067752 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-345-SMAW-4G (4F)-FCM-repair-1 for WR20511.

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.

Cross Beam 17

This QA Inspector observed ABF personnel performing Ultrasonic Testing on the Side Panel to Bottom hold back weld at panel point 112.

Segment 12AE

This QA Inspector observed ABF personnel performing Ultrasonic Testing on the FL3 web to Flange hold back weld at panel point 110.

Segment 12AW

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This QA Inspector observed drilling of bolt holes in the Deck Plate at Segment to Cross Beam bolted splice connection.

Segment 13AW

This QA Inspector observed beveling of the Side Plate with the use of a mechanical guided torch, cross beam and counter weight side.

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.

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