

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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006492**Date Inspected:** 17-Apr-2009**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:** Shi Lei**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 for observations relative to the work being performed.

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 Assembly

Bay 13

Segment 7CE

This QA Inspector observed Submerged Arc Welding (SAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SEG038-002. The welder is identified as #044755 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-T-2221-B-L2C-S-2.

Segment 7AE

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Fillet weld and Complete Joint

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Penetration (CJP) weld joint combination. The Weld joint is designated as DP466-001-017 to 019, 022 to 024, 031 to 033, 035 to 037, 040 to 042, 044 to 046, and 049 to 051. The welder is identified as #069469 and was observed welding in the 3G/3F (vertical) position using approved Welding Procedure Specification WPS-B-T-2233-TC-U4B-F.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Fillet weld and Complete Joint Penetration (CJP) weld joint combination. The Weld joint is designated as DP466-001-063 to 065, 068 to 070, 071 to 073, 076 to 078, 079 to 081, 084 to 086, 087 to 089 and 092 to 094. The welder is identified as #208035 and was observed welding in the 3G/3F (vertical) position using approved Welding Procedure Specification WPS-B-T-2233-TC-U4B-F.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Fillet weld and Complete Joint Penetration (CJP) weld joint combination. The Weld joint is designated as DP331-001-009 to 011, 015 to 017, 020 to 022, 024 to 026, 029 to 031, and 033 to 034. The welder is identified as #069469 and was observed welding in the 3G/3F (vertical) position using approved Welding Procedure Specification WPS-B-T-2233-TC-U4B-F.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Fillet weld and Complete Joint Penetration (CJP) weld joint combination. The Weld joint is designated as DP331-001-047 to 049, 052 to 054, 057 to 059, 060 to 062, 065 to 067, 068 to 070, 073 to 075, and 076 to 078. The welder is identified as #208035 and was observed welding in the 3G/3F (vertical) position using approved Welding Procedure Specification WPS-B-T-2233-TC-U4B-F.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Fillet weld and Complete Joint Penetration (CJP) weld joint combination. The Weld joint is designated as DP493-001-041 to 033, 027 to 029, 022 to 024, 018 to 020 and 013 to 015. The welder is identified as #069469 and was observed welding in the 3G/3F (vertical) position using approved Welding Procedure Specification WPS-B-T-2233-TC-U4B-F.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Fillet weld and Complete Joint Penetration (CJP) weld joint combination. The Weld joint is designated as DP493-001-057 to 059, 054 to 056, 049 to 051, 046 to 048 and 041 to 043. The welder is identified as #208035 and was observed welding in the 3G/3F (vertical) position using approved Welding Procedure Specification WPS-B-T-2233-TC-U4B-F.

ZPMC Quality Control (QC) Inspector is identified as Zhong Guo Hui. QA Inspector observed QC Inspector verify welding parameters. The welding variables recorded by QC appeared to comply with the Applicable WPS.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

your project.

Inspected By:	Hernandez, Dan	Quality Assurance Inspector
----------------------	----------------	-----------------------------

Reviewed By:	Carreon, Albert	QA Reviewer
---------------------	-----------------	-------------