DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-007169
Date Inspected: 18-May-2009

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
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 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 14

Segment 7DE

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SEG040A-015, 016. The welder is identified as #067942 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-TC-U4b-FCM.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SEG040B-053, 052, 054, 056. The welder is identified as #069089 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-T-2231-TC-U4b-F.

Segment 7CE

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SSD20-PP55-002, 009. The welder is identified as #051356 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-2233-B-U2-F.

Segment 7BE

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as SSD17A-PP51-009 to 046. The welder is identified as #048038 and was observed welding in the 3F (vertical) position using approved Welding Procedure Specification WPS-B-T-2133.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as SSD17-PP51-032 to 067. The welder is identified as #048038 and was observed welding in the 3F (vertical) position using approved Welding Procedure Specification WPS-B-T-2133.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as SSD17A-PP51-047 to 064. The welder is identified as #048038 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-T-2132.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as SSD17-PP51-014 to 031. The welder is identified as #048038 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-T-2132.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as SSD18A-PP52-010 to 047. The welder is identified as #048038 and was observed welding in the 3F (vertical) position using approved Welding Procedure Specification WPS-B-T-2133.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as SSD16-PP50-032 to 069. The welder is identified as #067888 and was observed welding in the 3F (vertical) position using approved Welding Procedure Specification WPS-B-T-2133.

Segment 6CE

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as CA060-008, 009. The welder is identified as #058551 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-T-2132.

Bay 13

Segment 8CE

This QA Inspector observed Flux Cored Arc Welding (FCAW) of root pass in progress of a Complete Joint

Penetration (CJP) weld joint. The Weld joint is designated as SEG048B-017. The welder is identified as #056205 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-T-2231-B-U2-F.

This QA Inspector observed Submerged Arc Welding (SAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SEG048B-017. The welder is identified as #215993 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-T-2221-B-L2C-S-2.

ZPMC Quality Control (QC) Inspector is identified as Zhang Xian Ji. 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 your project.

Inspected By:	Hernandez,Dan	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer