

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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007173**Date Inspected:** 24-May-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 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 6CW

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 SSD9-PP47-003, 004. The welder is identified as #066401 and was observed welding in the 2G (horizontal) position using approved Welding Procedure Specification WPS-B-T-2132-TC-U4b-F.

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 SSD12-PP46-004, 005. The welder is identified as #045240 and was observed welding in the 2G (horizontal) position using approved Welding Procedure Specification WPS-B-T-2132-TC-U4b-F.

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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 SEG031-046. The welder is identified as #066326 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2.

Segment 9EW

This QA Inspector observed Submerged Arc Welding (SAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SEG051A-008. The welder is identified as #250050 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-T-2221-B-L2C-S-2.

Segment 9DW

This QA Inspector observed Submerged Arc Welding (SAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SEG055A-003. The welder is identified as #045265 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-T-2221-B-L2C-S-2.

Segment 10CE

This QA Inspector observed Submerged Arc Welding (SAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SEG064A-001. The welder is identified as #058100 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-T-2221-B-L2C-S-2.

Segment 10AE

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 SEG060A-002. The welder is identified as #050988 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-T-2231-B-U2-F.

Bay 13

Segment 8BW

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 SEG045A-004. The welder is identified as #067656 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-T-2214-B-U2.

Segment 8CW

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 SEG047B-031. The welder is identified as #067656 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-T-2214-B-U2.

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Segment 8BE

This QA Inspector observed Submerged Arc Welding (SAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SEG046-003. 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 Liu Ru Dan. QA Inspector observed QC Inspectors 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
