

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-007347**Date Inspected:** 12-Jun-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:** Wu Zhi Cheng**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.

Trial Assembly Yard

Segment 5AE

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 SP538-050 to 061. The welder is identified as #053609 and was observed welding in the 2G (horizontal) position using approved Welding Procedure Specification WPS-B-T-2132.

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 SP308-031 to 042. The welder is identified as #048801 and was observed welding in the 2G (horizontal) position using approved Welding Procedure Specification WPS-B-T-2132.

Segment 4BE

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ZPMC submitted notification # 003386 dated 6-12-09 for QA Verification, Green Tag on Hold Back #1 for 4BE. A Linear Indication approximately 4mm in length discovered by ZPMC MT technician was still present on a fillet weld of a stiffener plate on Floor Beam FB018-02, weld # FB018-02-019.

Counter Weights

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% of areas previously tested and accepted by ZPMC QC personnel on counter weight connection clips. The weld numbers are identified as:

MT

CW001-PP022-128
CW001-PP022-132
CW001-PP012-130
CW001-PP024-129
CW001-PP024-130
CW001-PP028-132
CW001-PP028-133
CW001-PP034-131
CW001-PP034-132
CW001-PP038-132
CW001-PP038-131
CW001-PP040-130
CW001-PP026-130
CW001-PP026-131
CW001-PP012-131

ZPMC Quality Control (QC) Inspector is identified as Pan Wen Long. 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.



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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
