

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-008488**Date Inspected:** 03-Aug-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.

OBG Trial Assembly Yard

Segment 1AAE/1AE

This QA Inspector observed flame torch cutting of the hold back area at the edge plate to side plate connection, bike path side.

QA Inspector observed preheating and Shielded Metal Arc Welding (SMAW) of temporary fit up brackets along 1AAE and 1AE transverse side plate splice, cross beam side.

Segment 1BE

This QA Inspector observed ZPMC personnel performing Magnetic Particle Testing (MT) at the areas of removed tack welds on the location of the side plate and suspender bracket connection, bike path side.

Segment 5AW

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This QA Inspector observed grinding of welds along the floor beam diaphragm to floor beam connection at panel point 30.

Segment CB1/2AE

This QA Inspector observed ZPMC performing MT of removed tack welds of fit up plates on side vertical bolted splice connection of cross beam and FL3 floor beam.

Segment CB1/2AW

This QA Inspector observed ZPMC performing MT of removed tack welds of fit up plates on deck plate and cross beam bolted splice connection.

Segment CB1

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet weld joint. The Weld joints are designated as SP215-069, 070, 073, 074, 077, 078, 081, 082, 085, 086, 089, 090, 093, 094, 097, 098, 101, 102, 105, and 106. The welders are identified as #067571 and 048617 and were observed welding in the 1F, 3F, 4F positions using approved Welding Procedure Specification WPS-B-P-2114-FCM-1, WPS-B-P-2113-FCM-1 and WPS-B-P-2111-FCM-1.

Segment 1AE/1AEE

This QA Inspector observed fit up in progress of the deck plate transverse splice with the use of a hydraulic jack.

Segment 1BW

This QA Inspector observed grinding and MT by ZPMC personnel of removed tack welds on the suspender bracket at side plate location.

Segment 1BW/2AW

This QA Inspector observed removal of fit up plates by carbon air arc gouging at the side plate transverse splice location, cross beam side.

Segment 3AE

This QA Inspector observed the removal of the strong backs by carbon air arc gouging along the side plate to bottom plate splice at the location of repaired distortion.

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
