

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-009254**Date Inspected:** 26-Sep-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:** Xu Yumin**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 2AW

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a weld plug weld for a misdrilled bolt holes. The welder is identified as #220068 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-345-FCAW-1G (1F)-repair-misdrilled hole for CWR755, Cable Tray bolt holes in Bottom Plate WT stiffener.

Segment 1AAE/IAE

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 OBE1-001. The welder is identified as #067571 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-345-SMAW-1G (1F)-repair-FCM-1 for WR7834.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Segment 1AAW/1AW

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 OBW1A-001. The welder is identified as #045138 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-345-SMAW-1G (1F)-repair-1 for CWR774.

Segment 5BW/5CW

This QA Inspector observed the removal of the steel backing bar on the Deck Plate segment splice by arc gouging.

Segment 5BW

This QA Inspector observed match drilling of bolt holes for the Traveler Rail brackets on the Side Plate, counter weight side.

Segment 5AW/5BW

This QA Inspector observed ZPMC personnel performing Ultrasonic Testing (UT) on the Deck Plate segment splice and Side Plate segment splice, counter weight side.

Segment 5BE/5CE

This QA Inspector observed grinding of the weld profile on the, Side Plate segment splice, cross beam and bike path side.

Segment 1BW

This QA Inspector observed ABF personnel performing Magnetic Particle Testing (MT) on the Side Plate stiffener hold back welds along the 1BW/2AW segment field splice, counter weight side.

Segment 5AE/5BE

This QA Inspector observed ZPMC personnel performing Ultrasonic Testing (UT) on the Deck Plate segment splice.

ZPMC Quality Control (QC) Inspector is identified as Wang Li Yang. 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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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
---------------------	----------------	-------------