

**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-011463**Date Inspected:** 12-Jan-2010**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:** Li Yang**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 Segment**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 5BW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as OBW5G-009. The welder is identified as #066261 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1.

Segment 6BW/6CW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as OBW6C-005. The welder is identified as #068764 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1.

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This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as OBW6C-004. The welder is identified as #049769 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1.

## Segment 6BW/6CW

This QA Inspector observed grinding on the Side Plate at locations of removed fit up plates along the segment CJP splice weld, cross beam side.

## Segment 6AE

This QA Inspector observed ABF personnel performing Ultrasonic Testing (UT) of the Edge Plate to Deck Plate CJP splice, bike path side. D-scan was performed.

## Segment 5CE

This QA Inspector observed ABF personnel performing Ultrasonic Testing (UT) of the Edge Plate to Deck Plate CJP splice, cross beam side. D-scan was performed.

## Segment 7BW

This QA Inspector observed match drilling of bolt holes of FL3 to Bottom Panel at panel point 50, 51, and 52.

## Segment 7BE

This QA Inspector observed beveling of the Side Plate with the use of a mechanical guided torch, cross beam side.

## Segment 6AE/6BE

This QA Inspector observed grinding of the back gouged root pass of the Side Plate CJP segment splice, cross beam side.

## Segment 5CE

This QA Inspector observed fit up of the Traveler Rail bracket to Bottom Plate, cross beam side at panel point 40.

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

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## WELDING INSPECTION REPORT

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remedial efforts please contact Eric Tsang, 150-0042-2372 , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hernandez,Dan	Quality Assurance Inspector
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<b>Reviewed By:</b>	Miller,Mark	QA Reviewer
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