

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-011643**Date Inspected:** 24-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 7BE/7CE

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as OBE7C-008. The welder is identified as #068596 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-T-2213T.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as OBE7A-008, 009, 007. The welders are identified as #220066 and were observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-T-223(2)1T-2.

Segment 7AE

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of Complete Joint Penetration

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(CJP) weld joint. The Weld joint is designated as SEG036-049. The welder is identified as #068764 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-TC-U4b-FCM-1.

Segment 7BE

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as CA034-006. The welder is identified as #068764 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-TC-U4b-FCM-1.

Segment 6CE

This QA Inspector observed drilling of bolt holes in Deck Plate for connection of Suspender Brackets at panel point 44 and 46.

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.

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested by ZPMC MT personnel. The following items were tested:

CB4: Hold back welds

DP204-001-005, 006
DP202-001-027, 028
DP201-001-015, 016
DP203-001-027, 028
DP205-001-007, 008
SP209-001-026, 027
SP207-001-113, 114
SP208-001-022, 023
FB203-001-015, 016
FB201-001-034, 035
FB202-001-007, 008
SP203-001-042, 043
SP201-001-023, 024
SP202-001-018, 019
BP204-001-003, 004
BP202-001-009, 010
BP201-001-007, 008
BP206-001-009, 010
BP205-001-003, 004

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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
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Reviewed By:	Miller,Mark	QA Reviewer
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