

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-012337**Date Inspected:** 18-Feb-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 6BW

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as OBW6F-008. The welder is identified as #066439 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-T-2231-T.

This QA Inspector observed back gouging of the root pass on Side Plate CJP segment splice, cross beam and counter weight side.

Segment 6CW

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as OBW6F-010. The welder is identified as #070101 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-T-2231-T.

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Segment 7AW/7BW

This QA Inspector observed removal of remaining portions of fit up plate by arc gouging along the Side Plate CJP segment splice, counter weight side.

Segment 7AW

This QA Inspector observed match drilling of bolt holes in the Side Plate WT stiffener flange, crossbeam side.

This QA Inspector observed ABF personnel performing Ultrasonic Testing (UT) on approximately 300mm of the Side Plate to Bottom Plate CJP splice at the 6CW/7AW field splice location.

Segment 6CW

This QA Inspector observed removal of fit up plate by flame cutting used for dimensional control from the Longitudinal Diaphragm flange at panel point 47, counter weight side.

Segment 5AW

This QA Inspector observed grit blasting in progress on the interior of the segment.

Segment 6BW/6CW

This QA Inspector observed ABF personnel performing UT on the Edge Plate CJP segment splice, counter weight side.

ZPMC Quality Control (QC) Inspector is identified as He Yan Bing. 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.

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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