

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-013593**Date Inspected:** 25-Mar-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 7AE/7BE

This QA Inspector observed Base Metal repair using the Shielded Metal Arc Welding (SMAW) in progress at locations of removed fit up plates along the interior of the Bottom Plate segment CJP splice. The welder is identified as #054467 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-345-SMAW-1G (1F)-FCM-repair-1 for WR11052.

This QA Inspector observed ZPMC personnel performing Magnetic Particle Testing (MT) on exterior of Bottom Plate along segment CJP splice at locations of removed fit up plates.

Segment 7BE

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 SEG036D-074. The welder is identified as #050969 and was

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observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-P-4113-1.

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 CA036-073, 078. The welder is identified as #050969 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-P-4113-1.

This QA Inspector observed ABF personnel performing Ultrasonic Testing (UT) of the Edge Plate CJP segment splice, bike path side.

This QA Inspector observed the removal of overhanging excess Deck Plate material by arc gouging and ground flush after Deck Plate to Edge Plate CJP splice weld was completed., cross beam side at the 7AE to 7BE connection.

Segment 7BE/7CE

This QA Inspector observed ZPMC personnel performing Ultrasonic Testing (UT) of the Side Plate CJP segment splice, bike path side.

This QA Inspector observed back gouging of UT reject on the interior of the Side Plate CJP segment splice at Y location 1220mm and 1530 mm from Bottom Plate.

ZPMC Quality Control (QC) Inspector is identified as Zhang Qiang. 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:	Carreon,Albert	QA Reviewer
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