

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-013594**Date Inspected:** 27-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 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 SEG036A-043. The welder is identified as #048659 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-345-SMAW-3G (3F)-FCM-repair-1 for WR 11352 UT repair.

Segment 7CE

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 CA010-061, 063. The welder is identified as #050969 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-345-SMAW-3G (3F)-FCM-repair-1 for WR 11081.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

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

This QA Inspector observed ZPMC personnel performing Magnetic Particle Testing (MT) of the Bottom Plate WT stiffener hold back fillet welds.

Segment 7AE/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 OBE7B-003. 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 CWR 1345 UT repair.

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 OBE7B-002. The welder is identified as #054467 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-345-SMAW-3G (3F)-FCM-repair-1 for CWR 1345 UT repair.

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

Segment 7AW

This QA Inspector observed ABF personnel performing MT on the Longitudinal Diaphragm to Bottom Plate connection, approximately 600mm at the 6AW/7AW field splice location cross beam side.

Segment 7BE/7CE

This QA Inspector observed ABF personnel performing Ultrasonic Testing (UT) of the Edge Plate to Deck Plate hold back CJP splice, cross beam side.

Segment 7AE

This QA Inspector observed ABF personnel performing Ultrasonic Testing (UT) of the Edge Plate to Deck Plate hold back CJP splice, cross beam side at field splice location.

This QA Inspector observed ABF personnel performing MT on the Longitudinal Diaphragm hold back fillet weld at the 6AE/7AE field splice location cross beam side.

Segments 7DE 7EE

7DE and 7EE were placed in the Trial Assembly Yard east line up.

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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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
Reviewed By:	Carreon,Albert	QA Reviewer
