

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-013595**Date Inspected:** 28-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/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 DP 656-001-021. The welder is identified as #048659 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-485-SMAW-3G (3F)-FCM-repair-1 for WR 11365 UT repair.

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

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

Segment 7AE

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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 SEG034B-004. 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 WR 11095 UT reject.

This QA Inspector observed approximately 530mm of the Partial Joint Penetration (PJP) and fillet weld of the Longitudinal Diaphragm Flange to web were but due to misalignment at PP49 east cross beam side, WR11363.

Segment 7BE

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as SSD27-PP051-051, 052. The welder is identified as #220066 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-T-2132.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as SSD27-PP051-035, 036. The welder is identified as #222396 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-T-2132.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as SSD27-PP051-059, 060. The welder is identified as #220066 and was observed welding in the 3F (vertical) position using approved Welding Procedure Specification WPS-B-T-2133.

Segment 7BW

This QA Inspector observed fit up and tack welding of the Partial Height diaphragm at panel point 51 – 52.

Segment 7CE

This QA Inspector observed beveling of the Side Plate with the use of a mechanical guided torch, bike path side at the 7CE/7DE splice location.

Segment 7AW

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 SP437-001-019. The welder is identified as #220063 and was observed welding in the 2G (horizontal) position using approved Welding Procedure Specification WPS-345-SMAW-2G (2F)-FCM-repair-1 for WR 11447 UT reject.

Segment 7AE, 7BE, 7CE

This QA Inspector observed the removal of High Strength bolts from the Chevron brace lower connection splice plates cross beam and bike path side.

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ZPMC Quality Control (QC) Inspector is identified as Fang Ya Jun. 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
Reviewed By:	Carreon,Albert	QA Reviewer
