

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-013613**Date Inspected:** 20-Apr-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

BK1-030

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 BK001-030-009. The welder is identified as #067609 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-TC-U4b-FCM-1.

This QA Inspector observed Base Metal repair using the Shielded Metal Arc Welding (SMAW) in progress at locations of removed fit up plates on the Cantilever Side Plates. The welder is identified as #067571 and was observed welding in the 2G (horizontal) position using approved Welding Procedure Specification WPS-345-SMAW-2G (2F)-FCM-repair-1 for WR11791.

BK1-029

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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 BK001-029-009. The welder is identified as #069841 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-TC-U4b-FCM-1.

This QA Inspector observed Base Metal repair using the Shielded Metal Arc Welding (SMAW) in progress at locations of removed fit up plates on the Cantilever Side Plates. The welder is identified as #067571 and was observed welding in the 2G (horizontal) position using approved Welding Procedure Specification WPS-345-SMAW-2G (2F)-FCM-repair-1 for WR11791.

BK1-028

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 BK001-028-009. The welder is identified as #069841 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-TC-U4b-FCM-1.

This QA Inspector observed Base Metal repair using the Shielded Metal Arc Welding (SMAW) in progress at locations of removed fit up plates on the Cantilever Side Plates. The welder is identified as #067571 and was observed welding in the 2G (horizontal) position using approved Welding Procedure Specification WPS-345-SMAW-2G (2F)-FCM-repair-1 for WR11791.

Segment 7EE

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet weld joint. The Weld joint is designated as DP666-001-013. The welder is identified as #037932 and was observed welding in the 4F (overhead) position using approved Welding Procedure Specification WPS-B-P-4114-2.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet weld joint. The Weld joint is designated as BP174-001-031. The welder is identified as #070140 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-T-2132.

Segment 8AE

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet weld joint. The Weld joint is designated as DP667-001-012. The welder is identified as #037932 and was observed welding in the 4F (overhead) position using approved Welding Procedure Specification WPS-B-P-4114-2.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet weld joint. The Weld joint is designated as BP175-001-031. The welder is identified as #070140 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-T-2132.

Segment 7CE/7DE

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This QA Inspector observed ZPMC personnel performing Magnetic Particle Testing on the Deck Plate CJP transverse splice after grinding weld crown flush, exterior portion.

Segment 7BW/7CW

This QA Inspector observed ZPMC personnel performing Magnetic Particle Testing on the Deck Plate CJP transverse splice after grinding weld crown flush, exterior portion.

This QA Inspector observed ZPMC personnel performing Ultrasonic Testing on the Side Plate WT stiffener CJP web splice, cross beam side.

This QA Inspector observed match drilling of bolt holes in the Deck Plate U-rib splice plates.

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
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Reviewed By:	Carreon,Albert	QA Reviewer
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