

**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-015136**Date Inspected:** 26-Jun-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 9BE

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as EP145-001-013, 016. The welder is identified as #220067 and was observed welding in the 4F (overhead) position using approved Welding Procedure Specification WPS-B-T-2134.

Segment 9CE

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as EP146-001-006, 008. The welder is identified as #220067 and was observed welding in the 4F (overhead) position using approved Welding Procedure Specification WPS-B-T-2134.

Segment 9BE/9CE

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SP689-001-056. The welder is identified as #220067 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-2233-B-U2-F.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SP373-001-046. The welder is identified as #222396 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-2233-B-U2-F.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SP139-001-063. The welder is identified as #220063 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-2233-B-U2-F.

This QA Inspector observed Base Metal Repair using Shielded Metal Arc Welding (SMAW) in progress at locations of removed fit up plates along the exterior of the Side Plate transverse CJP splice. The welder is identified as #054467 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-345-SMAW-4G (4F)-FCM-repair-1 for WR13193.

For the above mentioned welding activities ZPMC Quality Control (QC) Inspector is identified as Wang Lu Yang. QA Inspector observed QC Inspector verify welding parameters. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Segment 9BE/9CE

This QA Inspector observed grinding of the root pass on the Side Plate WT stiffener web splice CJP splice, bike path side.

Counter Weight 52

This QA Inspector observed ABF personnel performing Magnetic Particle Testing at locations of removed fit up plate.

Segment 8AW

This QA Inspector observed ABF personnel performing Magnetic Particle Testing on FL3 I-rib stiffener hold back fillet welds at panel points 62 and 63.

QA Verification

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC MT personnel. The following items were tested:

Segment 8AE

SSD16-PP62-166

---

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---

SSD16-PP62-167  
SSD16-PP62-172  
SSD16-PP62-180  
SSD18-PP64-173  
SSD18-PP64-174  
SSD18-PP64-175  
SSD18-PP64-183

OBE8-020  
OBE8-018

Segment 8BW/8CW

CA049-005  
CA053-005

OBW8C-001

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.

---

<b>Inspected By:</b>	Hernandez,Dan	Quality Assurance Inspector
<b>Reviewed By:</b>	Peterson,Art	QA Reviewer

---