

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-015517**Date Inspected:** 11-Jul-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 9CE/9DE

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 OBE9C-003, Bottom Plate splice. The welders are identified as #037932, 067765 and 066179 and were observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1.

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 SP374-001-046, Side Plate WT stiffener web splice. The welder is identified as #068923 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-2233T.

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 SP347-001-050, Side Plate WT stiffener web splice. The welder is

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identified as #037907 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-2233T.

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 SP320-001-055, Side Plate WT stiffener web splice. The welder is identified as #066443 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-2233T.

This QA Inspector observed Base Metal Repair using the Shielded Metal Arc Welding (SMAW) process at locations of removed fit up plates along the exterior of the Bottom Plate transverse CJP splice. The welder is identified as #067765 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-345-SMAW-4G (4F)-FCM-repair-1 for CWR1679 (R1).

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 SP708-001-031, I-rib stiffener splice. The welder is identified as #037907 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-2233-B-U2-F.

Segment 9BE/9CE

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 OBE96-003, Edge Plate splice. 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, UT repair for CWR1701.

For the above mentioned welding activities ZPMC Quality Control (QC) Inspectors are identified as Wang Li Yang and Liu Hua Jie. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Segment 9BE/9CE

This QA Inspector observed ABF personnel performing Ultrasonic Testing on the Side Plate transverse CJP splice, cross beam side. D scan was performed.

Segment 9DE

This QA Inspector observed beveling of the Side Plates with the use of a mechanical guided torch at the 9DE/9EE transverse CJP splice, cross beam and bike path side.

Segment 9AW/9BW

This QA Inspector observed ABF personnel performing Magnetic Particle Testing on the Side Plate WT stiffener hold back fillet welds, counter weight side.

Segment 9EE

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This QA Inspector observed segment 9EE being placed in the 9 East trial assembly line up.

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: Peterson,Art

QA Reviewer
