DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-016054
Date Inspected: 04-Aug-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
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 Components

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 9CW

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as SP493-001-036, Side Plate WT stiffener hold back weld. The welder is identified as #046706 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-T-22132.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as SP671-001-021, Side Plate WT stiffener hold back weld. The welder is identified as #046706 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-T-22132.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet weld joint. The Weld joint is designated as EP113-001-012, Edge Plate I-rib hold back weld. The welder is identified as #067765 and

was observed welding in the 4F (overhead) position using approved Welding Procedure Specification WPS-B-P-2114-FCM-1.

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 CA061-005, Edge Plate to Side Plate hold back weld. The welder is identified as #067765 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-P-2211-TC-U4b-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 OBW9K-007, top counter weight connection plate to Deck Plate. The welder is identified as #207465 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-T-2231T-1.

Segment 9DW

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as SP494-001-042, Side Plate WT stiffener hold back weld. The welder is identified as #046706 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-T-22132.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as SP672-001-021, Side Plate WT stiffener hold back weld. The welder is identified as #046706 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-T-22132.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet weld joint. The Weld joint is designated as EP114-001-008, Edge Plate I-rib hold back weld. The welder is identified as #067765 and was observed welding in the 4F (overhead) position using approved Welding Procedure Specification WPS-B-P-2114-FCM-1.

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 CA062-001, Edge Plate to Side Plate hold back weld. The welder is identified as #067765 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-P-2211-TC-U4b-FCM-1.

Segment 9DW/9EW

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 BP134-001-026, Bottom Plate WT stiffener web splice. The welder is identified as #040609 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-2233-B-U2-F.

Segment 9CW/9DW

WELDING INSPECTION REPORT

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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 SP731-001-044, Side Plate WT stiffener web splice. The welder is identified as #067609 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1.

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

Segment 9CW/9DW

This QA Inspector observed ZPMC personnel performing Ultrasonic Testing on the Deck Plate transverse CJP splice, D scan was performed.

Segment 9DE

This QA Inspector observed the fit up of the Suspender Bracket at panel point 82.

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