

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: 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-016393**Date Inspected:** 24-Aug-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 10AW/10BW

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 OBW10-003, Deck Plate splice. The welder is identified as #067589 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-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 DP688-001-037, Deck Plate I-rib splice. The welder is identified as #066268 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-P-3213-B-U3b.

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 DP675-001-0036, Deck Plate I-rib splice. The welder is

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identified as #066459 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-P-3213-B-U3b.

Segment 10AW

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 SEG059A-040, Side Plate to Bottom Plate splice at Hold back location at west end, counter weight side. The welder is identified as #067752 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1.

Segment 9CE

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as Retro-B3-064, 065, Retro Fit Plate at Bottom Plate. The welder is identified as #053609 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 Retro-B3-067, 068, Retro Fit Plate at Side Plate. The welder is identified as #053609 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-T-2132.

For the above mentioned welding activities ZPMC Quality Control (QC) Inspectors are identified as An Qing Xiang and Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Segment 9DW/9EW

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

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

Segment 9EE

This QA Inspector observed ZPMC personnel performing Magnetic Particle Testing at locations of removed fit up plate along the 9EE/10AE field splice, cross beam side.

This QA Inspector observed ZPMC personnel performing Ultrasonic Testing on Longitudinal Diaphragm web to Floor Beam at panel point 85 east, bike path side.

Segment 9BW

This QA Inspector observed ZPMC personnel performing Ultrasonic Testing on the Partial Height Diaphragm flange CJP splice locations at panel points 75-76.

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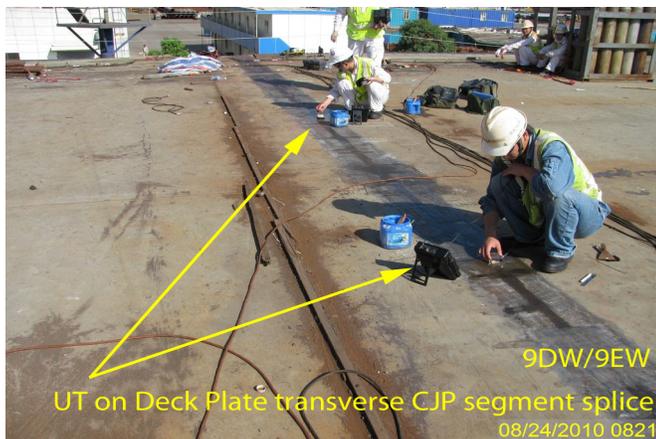
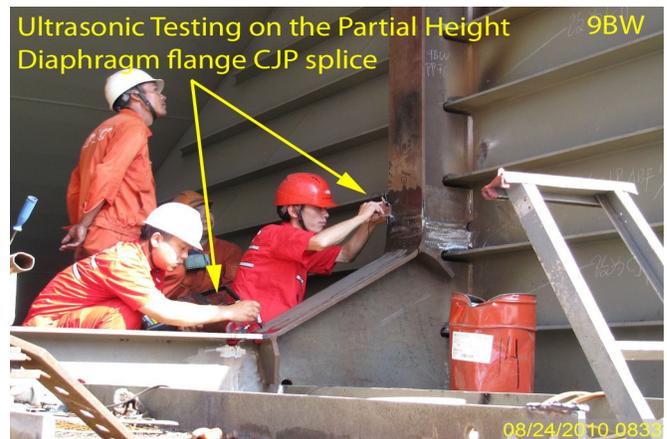
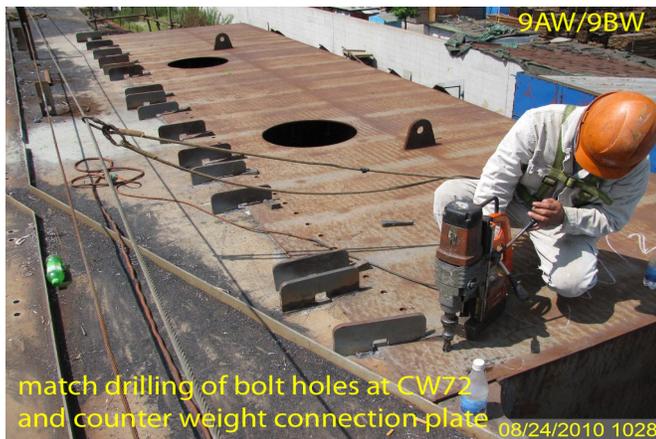
Segment 9DE

This QA Inspector observed ABF personnel performing Ultrasonic Testing on the FL3 I-rib stiffener hold back fillet welds at panel points 81-82.

Segment 9AW/9DW

This QA Inspector observed match drilling of bolt holes at top Counter Weight Connection Plate and Counter Weight 72 at panel points 72-74.

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

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your project.

Inspected By:	Hernandez, Dan	Quality Assurance Inspector
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Reviewed By:	Peterson, Art	QA Reviewer
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