

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-016461**Date Inspected:** 26-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

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet weld joint. The Weld joint is designated as DP688-001-013, 014, Deck Plate I-rib hold back weld. The welder is identified as #067829 and was observed welding in the 4F (overhead) position using approved Welding Procedure Specification WPS-B-P-4114-1.

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 SEG059C-026, Longitudinal Diaphragm web to Floor Beam. The welder is identified as #040609 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-2233-TC-U4b-F.

Segment 10BW

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This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet weld joint. The Weld joint is designated as DP727-001-007, 008, Deck Plate I-rib hold back weld. The welder is identified as #067829 and was observed welding in the 4F (overhead) position using approved Welding Procedure Specification WPS-B-P-4114-1.

Segment 10AE/10BE

This QA Inspector observed Submerged Arc Welding (SAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as OBE10-003, Deck Plate splice. The welders are identified as #050265 and #040460 and were observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-T-223(2)1T-2.

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 OBE10B-001, Side Plate splice. The welder is identified as #040367 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 OBE10B-002, Side Plate splice. The welder is identified as #052763 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 OBE10B-004, Side Plate splice. The welder is identified as #047353 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 OBE10B-005, Side Plate splice. The welder is identified as #202211 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-2233T.

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

Segment 9EW

This QA Inspector observed ABF personnel performing Magnetic Particle Testing on Side Plate to Bottom Plate CJP splice at hold back location, cross beam side west end of segment.

Cross Beam 12

This QA Inspector observed ZPMC personnel performing Magnetic Particle Testing on the Deck Panel I-rib hold back welds.

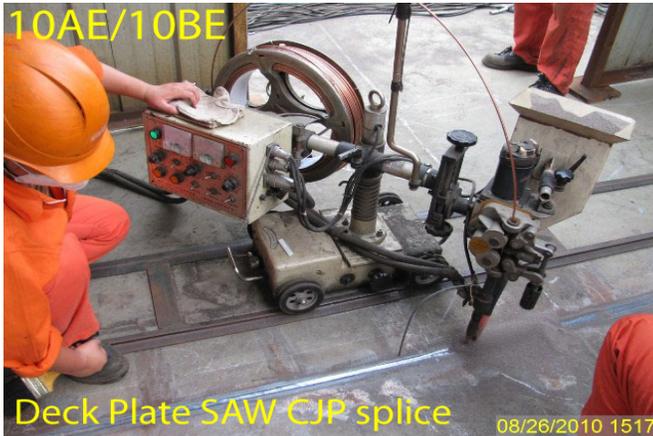
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Segment 9DW/9EW

This QA Inspector observed ABF personnel performing Ultrasonic Testing (UT) on the Deck Plate transverse CJP segment splice at locations of repaired UT rejects.

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
