

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016779**Date Inspected:** 14-Sep-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 10BW

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 OBW10L-008, bottom Counter Weight Connection Plate. The welder is identified as #040609 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-P-2231-TC-U4b-F-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 OBW10L-006, top Counter Weight Connection Plate. The welder is identified as #053486 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-TC-U4b-FCM-1.

For the above mentioned welding activities ZPMC Quality Control (QC) Inspector is identified as Shi Lie. The welding variables recorded by QC appeared to comply with the Applicable WPS.

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Segment 10BW/10CW

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

Segment 10AW/10BW

This QA Inspector observed ABF personnel performing Magnetic Particle Testing on the Deck Plate transverse CJP splice.

Segment 10AW

This QA Inspector observed fit up of the Suspender Bracket at panel point 86.

Segment 10BE

This QA Inspector observed ABF personnel performing Ultrasonic Testing on the Bottom Plate to Side Plate CJP hold back weld, bike path side at 10AE/10BE. D-scan was performed.

Segment 10AE/10BE

This QA Inspector observed ZPMC personnel performing Magnetic Particle Testing on the Side Plate WT Stiffener and Side Plate I-rib Plate hold back fillet welds, cross beam and bike path side.

This QA Inspector observed ZPMC personnel performing Ultrasonic Testing on the Side Plate WT stiffener CJP web splice, cross beam side.

Segment 10BW

This QA Inspector observed match drilling of the Side Plate WT stiffener flange and splice plates, cross beam and bike path side and Deck Plate U-rib and splice plates at 10AW/10BW splice location.

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.

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