

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016989**Date Inspected:** 27-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 11AE

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 CA081-002, Edge Plate to Deck Plate hold back weld. The welder is identified as #044504 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-TC-U4B-FCM-1.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as BP186-001-031, Bottom Plate WT stiffener hold back weld. The welder is identified as #040458 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 SP634-001-003, Side Plate WT stiffener hold back weld. The welder is identified as #052763 and

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was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-T-2132.

Segment 11AW/11BW

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 OBW11C-003, Deck Plate transverse CJP splice root pass. The welder is identified as #053316 and was 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 OBW11B-003, Bottom Plate transverse splice. The welder is identified as #040609 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-T-2231T.

Segment 10CE

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 SEG064*-035, Edge Plate to Deck Plate hold back weld. The welder is identified as #044504 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-TC-U4B-FCM-1.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as SP593-001-045, Side Plate WT stiffener hold back weld. The welder is identified as #052763 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 BP185-001-037, Bottom Plate WT stiffener hold back weld. The welder is identified as #040458 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 Shi Lei and Wang Li Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Segment 11AW

This QA Inspector observed match drilling of bolt holes in the Deck Plate U-ribs for bolted splice plate connection at 10CW/11AW field splice location.

Segment 10BE/10CE

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

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Segment 10BW/10CW

This QA Inspector observed ABF personnel performing Magnetic Particle Testing on the Deck Plate transverse CJP splice and locations of removed fit up plates.

CB17

This QA Inspector observed heat straightening of the Bottom Panel at welds CB3001B-001, 002, 003 and 004 following HSR1(B)-9450.

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
