

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-017602**Date Inspected:** 25-Oct-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 Segments**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 11BW/11CW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated SP141-001-048, Side Plate WT stiffener web splice. The welder is identified as #040656 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 SP114-001-053, Side Plate WT stiffener web splice. The welder is identified as #044551 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-P-2213-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 OBW11-010, Edge Plate transverse splice. The welder is identified

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as #040611 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 Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated OBW11B-009, Side 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-2233T-1.

Segment 10CW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet weld joint. The Weld joint is designated OBW10E-046, 047, Drip Plate. The welder is identified as #046709 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 OBW10E-045. The welder is identified as #046709 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-P-2213-B-U2-FCM-1.

Segment 11BE/11CE

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated OBE11-010, Edge Plate transverse splice. The welder is identified as #044515 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 OBE11-006, Edge Plate transverse splice. The welder is identified as #040320 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1.

Segment 10CE

This QA Inspector observed Base Metal Repair using the Shielded Metal Arc Welding (SMAW) process at locations of removed fit up plates along the exterior of the Deck Plate at cross beam location. The welder is identified as #251194 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-345-SMAW-1G (1F)-FCM-repair-1 for CWR1799.

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

Segment 10CE

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This QA Inspector observed ZPMC personnel performing Ultrasonic Testing on the FL3 web to flange hold back CJP weld at panel point 92.

Segment 11CW

This QA Inspector observed the fit up of the bottom Counter Weight Connection Plate at panel points 102 – 104.

Segment 11CE/11DE

This QA Inspector observed the fit up of the Side Plates and Bottom Plate of the segment transverse CJP splice.

Segment 10AW

This QA Inspector observed the installation of sea bracing in the interior of the segment.

Segment 11EE

This QA Inspector observed segment 11EE was placed in the trial assembly east line up.

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:	Dsouza,Christopher	QA Reviewer
