

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-017668**Date Inspected:** 28-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 DP679-001-020, Deck Plate I-rib web splice. The welder is identified as #046704 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-3213-B-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 DP693-001-020, Deck Plate I-rib web splice. The welder is identified as #040611 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-3213-B-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 OBW11-008, Deck Plate transverse splice. The welder is identified

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as #046704 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 OBW11B-008, Side Plate transverse splice. The welder is identified as #057333 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 OBW11-010, Edge Plate transverse splice. 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 11BW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated SEG067A-044, Side Plate to Bottom Plate hold back. The welder is identified as #049502 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1.

Segment 11CW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet weld joint. The Weld joint is designated SEG069B-011, Longitudinal Diaphragm web to Bottom Plate. The welder is identified as #040609 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-T-2132.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated SEG069A-003, Side Plate to Bottom Plate hold back. The welder is identified as #049502 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-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 OBE11B-007, Side 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.

Segment 11CE/11DE

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated OBE11A-002, Deck Plate transverse splice root pass. The welder is identified as #040367 and was observed welding in the 1G (flat) position using approved Welding Procedure

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Specification WPS-B-T-2231T.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated OBE11A-004, Deck Plate transverse splice root pass. The welder is identified as #044473 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-T-2231T.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated OBE11A-003, Deck Plate transverse splice root pass. The welder is identified as #047353 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-T-223(2)1T-1.

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

Segment 11BE

This QA Inspector observed the fit up of the Suspender Bracket at panel point 100.

Lift 10 East

This QA Inspector observed the installation of sea bracing in the interior of the segments was in progress.

Segment 11AW

This QA Inspector observed ABF personnel performing Magnetic Particle Testing on the along the Bottom Plate splice at locations of removed fit up plates.

Cross Beam 16

This QA Inspector observed CB 16 was placed in the Trial Assembly Line up at 11DE and 11DW.

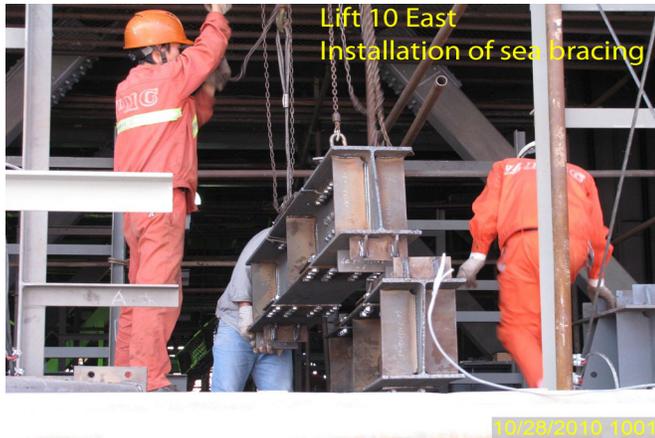
BK001-012

This QA Inspector observed Heat Straightening of the Bike Path Cantilever bottom Panel at weld BK001-012-006 following HSR1(B)-9502.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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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
