

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-018221**Date Inspected:** 17-Nov-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 11AE

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Partial Joint Penetration (PJP) weld joint. The Weld joint is designated LB4-002-058, Light Bracket to Deck Plate. The welder is identified as #040367 and was observed welding in the 2G (horizontal) position using approved Welding Procedure Specification WPS-B-T-2232-ESAB.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Partial Joint Penetration (PJP) weld joint. The Weld joint is designated LB4-002-044, Light Bracket to Deck Plate. The welder is identified as #047353 and was observed welding in the 2G (horizontal) position using approved Welding Procedure Specification WPS-B-T-2232-ESAB.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Partial Joint Penetration (PJP) weld joint. The Weld joint is designated LB4-002-075, Light Bracket to Edge Plate. The welder is identified as

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#052910 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2314-TC-P4.

Segment 11CW/11DW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated OBW11A-003, Deck Plate transverse CJP splice. The welder is identified as #046709 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-345-SMAW-4G (4F)-FCM-repair-1 for WR2220, UT repair.

Segment 11DW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated SEG071C-057, Longitudinal Diaphragm horizontal stiffener to Floor Beam. The welder is identified as #046709 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-345-SMAW-4G (4F)-FCM-repair-1 for WR17160, UT repair.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated FB027-011-128, FL3 Web to Bottom Flange hold back weld. The welder is identified as #053486 and was observed welding in the 2G (horizontal) position using approved Welding Procedure Specification WPS-B-T-2232-TC-U4b-F.

Cross Beam 16

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated CB202A-016-004, Side Panel to Bottom Panel hold back weld. The welder is identified as #053486 and was observed welding in the 2G (horizontal) position using approved Welding Procedure Specification WPS-B-T-2232-TC-U4b-F.

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

Segment 11AE

This QA Inspector observed ABF personnel performing Magnetic Particle Testing on the Light Bracket FCAW PJP root pass at the Deck Plate and Edge.

Segment 11BE/11CE

This QA Inspector observed ABF personnel performing Magnetic Particle Testing along the Edge Plate transverse CJP splice at locations of removed fit up plates, cross beam side.

This QA Inspector observed ABF personnel performing Ultrasonic Testing on the Edge Plate to Side Plate CJP hold back weld, bike path side.

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Segment 11CE/11DE

This QA Inspector observed ABF personnel performing Ultrasonic Testing on the Edge Plate transverse CJP splice and the Side Plate transverse CJP splice, bike path side.

Segment 11EE

This QA Inspector observed fit up of the Bike Path Cantilever at panel point 107.

This QA Inspector observed ABF personnel performing Magnetic Particle Testing on the Light Bracket FCAW PJP root pass at the Deck Plate and Edge.

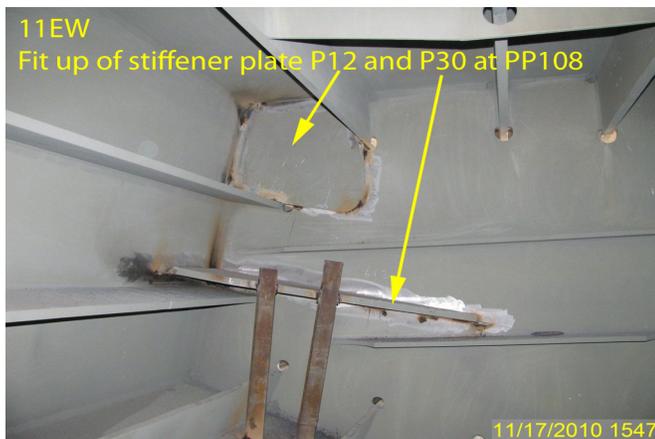
Segment 11EW

This QA Inspector observed fit up of Stiffener plates P12 and P30 in the corner assembly, west side of panel point 108, counter weight side.

Segment 11EW

This QA Inspector observed fit up of the Suspender Bracket at panel point 106.

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:	Dsouza, Christopher	QA Reviewer
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