

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-018594**Date Inspected:** 14-Dec-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 12AE/12BE

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated OBE12D-002, Side Plate transverse splice weld. The welders are identified as #047353, #040367, #052763 and were observed welding in the 3G (vertical) position using Welding Procedure Specification WPS-B-T-2233T-ESAB using ceramic backing.

Segment 12AE

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated BP3001-001-062, 063, Bottom Plate WT stiffener hold back weld. The welder is identified as #050289 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-T-2132-ESAB.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated BP3002-001-055, 056, Bottom Plate WT stiffener hold back weld. The welder is identified as #053871 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-T-2132-ESAB.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated BP3003-001-059, 060, Bottom Plate WT stiffener hold back weld. The welder is identified as #053871 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-T-2132-ESAB.

Segment 12BE

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated BP3004-001-019, 020, Bottom Plate WT stiffener hold back weld. The welder is identified as #050289 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-T-2132-ESAB.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated BP3005-001-013, 014, Bottom Plate WT stiffener hold back weld. The welder is identified as #053871 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-T-2132-ESAB.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated BP3006-001-017, 018, Bottom Plate WT stiffener hold back weld. The welder is identified as #053871 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-T-2132-ESAB.

For the above mentioned welding activities ZPMC Quality Control (QC) Inspectors are identified as An Qing Xiang and Liu Hua Ji. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Segment 12CE

This QA Inspector observed the following issue:

-The slope at the Bottom Plate Complete Joint Penetration (CJP) butt splice does not meet the 1:2.5 transition criteria for the change in plate thickness.

-Bottom Plates are identified as:

BP3007, BP3008, BP3009

-Weld joints are identified as:

-BP3007-001-001, joining plate PL3046A (28mm) to PL3046B (35mm).

-BP3008-001-001, joining plate PL3047A (28mm) to PL3047B (35mm).

-BP3009-001-001, joining plate PL3048A (28mm) to PL3048B (35mm).

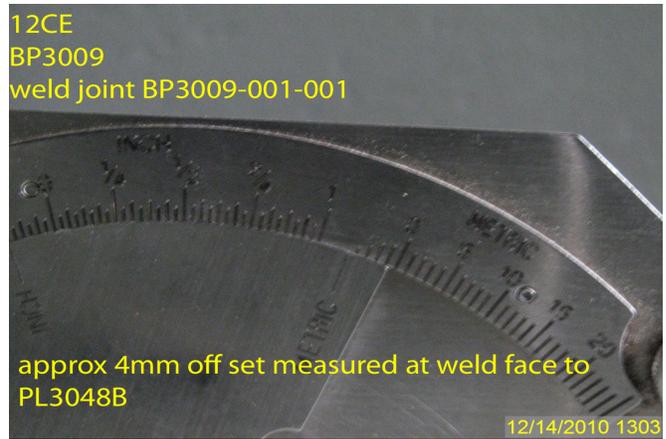
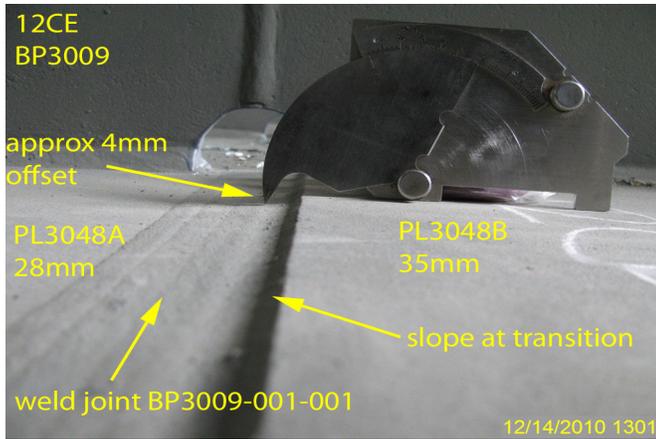
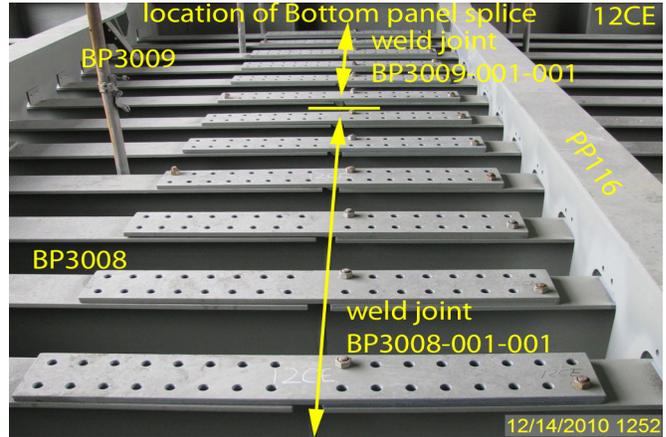
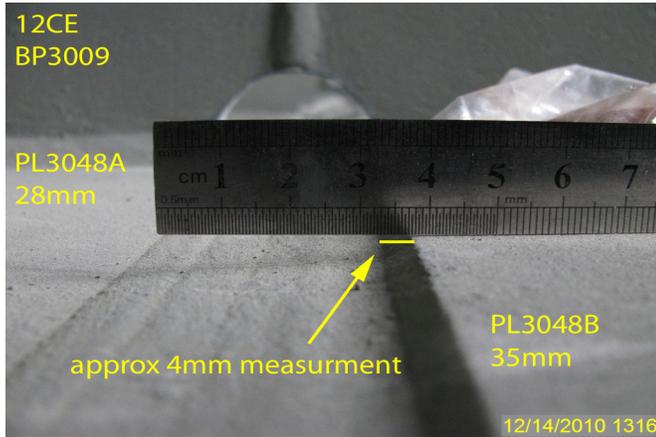
An Incident Report was written for this issue.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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