

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-019201**Date Inspected:** 30-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:** Shi Lei**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 12AW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated DP3045-001-334, Longitudinal Diaphragm to Deck Plate hold back weld. The welder is identified as #040611 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 Shielded Metal Arc Welding (SMAW) in progress of a fillet joint. The Weld joint is designated LD3020-001-049, Longitudinal Diaphragm horizontal stiffener hold back weld. The welder is identified as #041713 and was observed welding in the 4F (overhead) position using approved Welding Procedure Specification WPS-B-T-2114-FCM-1.

Segment 12BW

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated DP3056-001-009, Longitudinal Diaphragm to Deck Plate hold back weld. The welder is identified as #040611 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-TC-U4b-FCM-1.

Segment 12AE

This QA Inspector observed Base Metal Repair using the Shielded Metal Arc Welding (SMAW) process at locations of removed fit up plates on the FL3 Bottom Panel. The welder is identified as #040270 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-345-SMAW-1G (1F)-FCM-repair-1.

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

Segment 12AW

This QA Inspector observed ABF personnel performing Magnetic Particle Testing on the Side Plate transverse CJP splice at locations of removed fit up plates after base metal repair, counter weight side at the west end of the segment.

Segment 12AE

This QA Inspector observed ABF personnel performing Magnetic Particle Testing on the Side Plate transverse CJP splice at locations of removed fit up plates after base metal repair, bike path side at the west end of the segment.

Segment 11AE

This QA Inspector observed grit blasting on the west end of the segment.

Segment 12AE/12BE

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

Segment 12AW/12BW

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

Segment 11EE

This QA Inspector observed the removal of stiffener plate PL30 at panel point 108 connected at the floor beam and

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

edge plate bike path side.

Segment 12CE

This QA Inspector observed beveling of the Deck Plate and Side Plates with the use of a mechanical guided torch at the west end of the segment.

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
