

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-020798**Date Inspected:** 30-Jan-2011**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:** Qui Wen**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.

Bay 14

Segment 13AW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SEG3013P-197. The welder is identified as #066631 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-P-2213-TC-U4b-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 as SEG3013P-149. The welder is identified as #067876 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-2233-ESAB.

Segment 14BW

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP)

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weld joint. The Weld joint is designated as SEG3020J-078-149. The welder is identified as #201215 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-T-2231-ESAB.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a UT repair on a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SEG3020X-008. The welder is identified as #045246 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-345-SMAW-3G (3F)-FCM-1 for CWR2792.

14 WEST

Deck Plate Diaphragm to Deck Plate

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as DP3171-001-299. The welder is identified as #067572 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 Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as DP3170-001-114. The welder is identified as #067520 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 Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as DP3169-001-158. The welder is identified as #037779 and was observed welding in the 2G (horizontal) position using approved Welding Procedure Specification WPS-B-P-2212-TC-U4b-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 as DP3170-001-216. The welder is identified as #069493 and was observed welding in the 2G (horizontal) position using approved Welding Procedure Specification WPS-B-P-2212-TC-U4b-FCM-1.

For the above mentioned welding activities ZPMC Quality Control (QC) Inspector is identified as Wang Xiang Pin and Zhong Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS.

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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