

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-021115**Date Inspected:** 26-Feb-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:** Zhou Zhong Hai**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 12BW/12CW

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 OBW12C-001, Bottom Plate transverse 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 CWR2821.

Segment 12BE/12CE

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 OBE12-002, Side Plate transverse splice. The welder is identified as #067752 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-345-SMAW-4G (4F)-FCM-repair-1 for CWR2805-R1.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Cross Beam 17

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated CB3001-017-006, Side Panel to Bottom Panel hold back weld. The welder is identified as #067752 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 Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated SP3032-017-014, Side Panel stiffener hold back weld. The welder is identified as #047353 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-T-2132-ESAB.

Segment 12AE

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated SEG3001AG-174, Partial Height Diaphragm flange splice at panel point 112. The welder is identified as #044504 and was observed welding in the 2G (horizontal) position using approved Welding Procedure Specification WPS-B-P-2212-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 SEG3001AG-100, Partial Height Diaphragm flange splice at panel point 111. The welder is identified as #044504 and was observed welding in the 2G (horizontal) position using approved Welding Procedure Specification WPS-B-P-2212-B-U2-FCM-1.

Segment 12BW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated DP3054-001-020, Longitudinal Diaphragm to Deck Plate Diaphragm. The welder is identified as #067993 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-345-SMAW-3G (3F)-FCM-repair-1.

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

Segment 12BW/12CW

This QA Inspector observed ABF personnel performing Ultrasonic Testing on the Side Plate transverse CJP splice, counter weight side.

Segment 12BW

This QA Inspector observed match drilling of the Bottom Plate WT stiffener flange at 12AW/12BW splice.

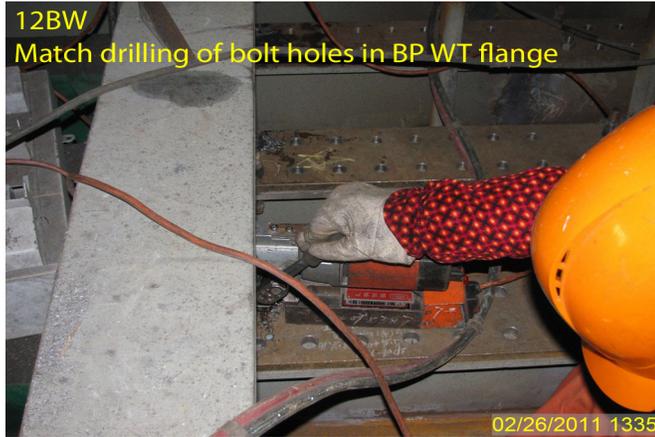
Segment 12CW

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

This QA Inspector observed cutting of the Side Plate to Bottom Plate hold back weld for correction of misalignment following WR19264, cross beam side.

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: Miller,Mark

QA Reviewer