

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-021210**Date Inspected:** 02-Mar-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:** 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 12BE

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 DP3018-001-022, Longitudinal Diaphragm to Deck Plate. The welder is identified as #044504 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-345-SMAW-4G (4F)-FCM-repair-1 for WR20290.

Segment 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 SEG3003A-012, Side Plate to Bottom Plate hold back weld. The welder is identified as #044504 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-345-SMAW-1G (1F)-FCM-repair-1 for CWR2814-R2.

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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 OBE12E-002, Side Plate transverse splice. The welder is identified as #044504 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-345-SMAW-3G (3F)-FCM-repair-1 for CWR2805-R2.

Segment 12BW

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 SEG3005A-003, Side Plate to Bottom Plate hold back weld. The welder is identified as #046709 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-345-SMAW-1G (1F)-FCM-repair-1 for WR20317.

Segment 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 SEG3006A-012, Side Plate to Bottom Plate hold back weld. The welder is identified as #046709 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-345-SMAW-1G (1F)-FCM-repair-1 for WR20317.

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-R1.

For the above mentioned welding activities ZPMC Quality Control (QC) Inspectors are identified as Wang Li Yang 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 to Bottom Plate CJP hold back weld, cross beam side.

QA Verification

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ABF MT personnel. The following items were tested:

12BE/12CE

Side Plate WT stiffener hold back welds

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SP3006-001-029
SP3006-001-030
SP3006-001-041
SP3006-001-042
SP3007-001-025
SP3007-001-026
SP3007-001-035
SP3007-001-036
SP3008-001-025
SP3008-001-026
SP3008-001-027
SP3008-001-028
SP3012-001-021
SP3012-001-022
SP3012-001-023
SP3012-001-024
SP3010-001-009
SP3010-001-010
SP3010-001-021
SP3010-001-022
SP3011-001-008
SP3011-001-009
SP3011-001-018
SP3011-001-019

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



Summary of Conversations:

No relevant conversations.

Comments

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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
