

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-022865**Date Inspected:** 19-Apr-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:** Zhu 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

Bike Path Cantilever 17

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 BK017B-001-015 cover pass, connection plate. The welder is identified as #040367 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-2233-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 BK017-001-015 cover pass, connection plate. The welder is identified as #052763 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-2233-ESAB.

Segment 13AW

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

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 SEG3013A-008, Bottom Plate to Side Plate hold back weld. The welder is identified as #067942 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1.

Segment 12CE

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet weld joint. The Weld joint is designated as BP3007-001-038, 039, Bottom Plate WT stiffener hold back weld. The welder is identified as #044504 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-P-2112-FCM-1.

Segment 13AE

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet weld joint. The Weld joint is designated as SA3012-009, 010, Bottom Plate WT stiffener hold back weld. The welder is identified as #040270 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-P-2112-FCM-1.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet weld joint. The Weld joint is designated as SA3059-007, 008, Bottom Plate WT stiffener hold back weld. The welder is identified as #044504 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-P-2112-FCM-1.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet weld joint. The Weld joint is designated as SEG3059-001-001, 002, Side Plate WT stiffener hold back weld. The welder is identified as #057258 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-P-2112-FCM-1.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet weld joint. The Weld joint is designated as SEG3060-001-025, 026, Side Plate WT stiffener hold back weld. The welder is identified as #052493 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-P-2112-FCM-1.

Cross Beam 17

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of Edge build up on Floor Beam FB3050 at panel point 111 south end at locations that bolt hole edge distance is below minimum requirements. The welder is identified as #040378 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-345-SMAW-3G (4F)-FCM-1 for WR 20669.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

Segment 13AE

This QA Inspector observed ZPMC personnel performing Magnetic Particle Testing on the Architectural Housing stiffeners.

This QA Inspector observed ABF personnel performing Magnetic Particle Testing on the Edge Plate to Deck Plate hold back weld, cross beam side.

Bike Path Cantilever BK16

This QA Inspector observed ABF personnel performing Ultrasonic Testing on the Cantilever to connection plate.

Bike Path Cantilever BK17

This QA Inspector observed ABF personnel performing Ultrasonic Testing on the Cantilever to connection plate.

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



Summary of Conversations:

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

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
