

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-023004**Date Inspected:** 26-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

Segment 12AE

This QA Inspector observed Plug welding using the Shielded Metal Arc Welding (SMAW) process on four (4) mis-drilled bolt holes in the Bottom Plate at panel point 111.5. 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)-repair-misdrilled hole for CWR2770 and CWR2771.

Cross Beam 18

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as FB4103-018-015, Floor Beam I-rib hold back weld. The welder is identified as #220066 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-P-2132-ESAB.

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This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as SP3085-018-036, Side Panel I-rib hold back weld. The welder is identified as #220063 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-P-2132-ESAB.

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

QA Verification

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

12 East

Floor Beam to Bottom Plate

SEG3001D-060

SEG3002E-150

SEG3002F-056

SEG3003M-056

SEG3003N-056

12 West

SA6022B-012-022

SA6022B-012-064

SA6022B-012-068

SA6022B-012-061

SA6022A-012-010

SA6022A-012-050

SA6022A-012-054

SA6022A-012-047

SA6021C-012-009

SA6021C-012-047

SA6021C-012-054

SA6021C-012-050

SA6021B-012-007

SA6021B-012-029

SA6021B-012-036

SA6021B-012-032

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

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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
