

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-023381**Date Inspected:** 11-May-2009**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:** Shen Fu Yoo**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 Trial Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

BAY 14

Orthotropic Box Girder (OBG)

This QA Inspector observed ZPMC welding personnel performing Submerged Arc Welding (SAW) for Side Panel for Segment 9DE. The weld joint no. SEG056A-002 is in progress. The welder is identified as 207288. Welder was welding in 1G (Flat) position. In process SAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2221-B-L2C-S-2.

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Unequal Angle to Bottom Plate for Segment 6AW. The weld joint no. SSD-021-PP37.5 009 and 010 is in progress. The welder is identified as 045218. Welder was welding Fillet in 2F (Horizontal) and position and 3F (Vertical) position. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2132 and WPS-B-T-2133.

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Unequal

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Angle to Bottom Plate for Segment 6BW. The weld joint no. SSD-030-PP40.5 009 and 010 is in progress. The welder is identified as 045218. Welder was welding Fillet in 2F (Horizontal) and position and 3F (Vertical) position. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2132 and WPS-B-T-2133.

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) for Lifting Lugs for Segment 6AW. The weld joint no. SSD10A-PP040-224 is in progress. The welder is identified as 047856. Welder was welding CJP in 3G (Vertical) position. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-2213-Tc-U5b.

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) for Lifting Lugs for Segment 6AW. The weld joint no. SSD012A-PP40-222 and 223 is in progress. The welder is identified as 045240. Welder was welding CJP in 3G (Vertical) position. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-2213-Tc-U5b.

This QA Inspector observed ZPMC welding personnel performing Submerged Arc Welding (SAW) with ceramic backing for Deck Panel for Segment 6AW. The weld joint no. SEG031*-034 is in progress. The welder is identified as 045265. Welder was welding in 1G (Flat) position. In process SAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-223(1)2-T-1.

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Side Panel for Segment 9CW. The weld joint no. SEG053A-008 is in progress. The welder is identified as 207540. Welder was welding in 1G (Flat) position. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2231-B-U2-F.

This QA Inspector observed ZPMC welding personnel performing Submerged Arc Welding (SAW) for Side Panel for Segment 10BW. The weld joint no. SEG061A-002 is in progress. The welder is identified as 250050. Welder was welding in 1G (Flat) position. In process SAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2221-B-L2C-S-2.

This QA Inspector observed ZPMC welding personnel performing Submerged Arc Welding (SAW) for Deck Panel for Segment 6BW. The Deck Panel DP139A to DP166A is being welded the weld joint no. SEG029*-027. The welder is identified as 045265. Welder was welding in 1G (Flat) position. In process SAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2221-B-L2C-S-2.

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (SAW) for Deck Panel for Segment 6CW. The Deck Panel DP140A to DP167A is being welded the weld joint no. SEG031*-033. The welder is identified as 050316. Welder was welding in 1G (Flat) position. In process SAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2221-B-L2C-S-2.

This QA Inspector observed ZPMC welding personnel performing Stud Welding for Corner Panel CA35A. Welder was welding in Vertical position. In process Stud Welding appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2143.

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The designated ZPMC CWI for the West Line is Mr. Shen Fu Yoo and QC Mr. Li Ming Yang, Mr. Liu Wan Ning and Mr. Liu Rudan.

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

Summary of Conversations:

No relevant conversations were reported on this date.

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 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Math,Manjunath	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
