

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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008802**Date Inspected:** 06-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Yumin**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 Trail Assembly**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) S. Manjunath. Math was present during the times noted above for observations relative to the work being performed.

Orthotropic Box Girder (OBG) Trial Assembly Areas**Lift 4 (West)**

This Quality Assurance (QA) Inspector witnessed final tension verification for Cable Tray between PP 24 to 25, PP 25 to 26, PP 27 to 28 and PP 28 to 28.5 North and South Side for Lift 4 West bolts partly installed. Inspected 10% on a random basis for the partly installed bolts and found the tension to be in general compliance. Cable Tray not been installed between PP 26 to 27 due to scaffolding obstructions. Bolt sizes used were M3/4 x 2 1/4 RC Set# DHG60580 and final Torque required was 340 N-m. Manual Torque wrench is been used with Sr. No. XQ2-584.

Lift 3 (West)

This Quality Assurance (QA) Inspector carried out Magnetic Particle Test along with Mr. Manikandhan for the Deck Panel Diaphragm to Floor Beam Flange at PP 19 (East Side) and at PP 20 (East Side) and rest of the Panel Points i.e., PP 21, PP 22 and PP 23 MPT test not carried out due to ongoing Painting activity.

Segment 5BE to 5CE

WELDING INSPECTION REPORT

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This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) welding for Bottom Panel to Side Panel Cross Beam Side. The weld joint no. SP604A to SP603B and BP166A to BP165A. The welding was being performed against B-WR6986. The welder is identified as 053609 and 220069. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-345-FCAW-1G (1F)-Repair-1.

Segment 1AW to 1AAW

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) welding for “I” –Rib Cope Holes at hold back welded areas. The welding was being performed against B-CWR7248. The welder is identified as 220066 and 220067. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2233-B-U2-F.

Segment 1AE

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Deck Panel Diaphragm to Floor Beam Flange (FL1). The weld joint no. SSD 34A –PP8.5-153 welding was being performed. The welder is identified as 050316 and 058245. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2232-Tc-U4b-FCM.

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

Inspected By:	Math,Manjunath	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
