

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-009048**Date Inspected:** 05-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:** Li Jha and 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 3 (West)**

This Quality Assurance (QA) Inspector witnessed final tension verification for Cable Tray between PP 19 to 20, PP 21 to 22, PP 22 to 23 and PP 23 to 23.5 North and South Side for Lift 3 West bolts partly installed. Inspected 10% on a random basis the partly installed bolts and found the tension to be in general compliance. Cable Tray not been installed between PP 20 to 21 due to scaffolding obstructions. Bolt sizes used were M3/4 x 2 1/4 RC Set# DHG60571 and DHG60581 and final Torque required was 393 N-m and 340 N-m. Manual Torque wrench is been used with Sr. No. XQ2-584.

Lift 2 (West)

This Quality Assurance (QA) Inspector witnessed final tension verification for Suspender Bracket Counter Weight Side at PP 16 for Segment 2AW. Inspected 10% on a random basis and found the tension to be in general compliance. Bolt sizes used were M24 x 75 RC Set# DHGM240020 and final Torque required is 600 N-m, M24 x 85 RC Set# DHGM240015 and final torque required is 517 N-m and M27 x 85 RC Set# DHGM270001 and final torque required is 853 N-m. Manual Torque wrench is been used with Sr. No. XQ2-584.

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Segment 5BE to 5CE

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 Shielded Metal Arc Welding (SMAW) for hold back area for "I" Rib to "I" Rib. The weld joint no. SP 404-001-040 and 039 welding was being performed. The welder is identified as 037743. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-2211-B-U2-FCM-1.

Lift 2 East

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for FL3 Stiffener at PP 14 as Linear Indications were found during MT test by Caltrans QA, The welding is being carried out against B-CWR 701 Rev.0. The weld joints were identified as SSD54-PP014-174 and SSD54-PP014-183. The welder is identified as 048801. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-345-FCAW-1G (1F)-FCM-Repair-1.

Lift 2 East

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for FL3 Stiffener at PP 15 as Linear Indications were found during MT test by Caltrans QA, The welding is being carried out against B-CWR 701 Rev.0. The weld joints were identified as SSD17-PP015-163 and SSD17-PP015-176. The welder is identified as 048801. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-345-FCAW-1G (1F)-FCM-Repair-1.

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

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Reviewed By: Carreon,Albert

QA Reviewer