

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-012018**Date Inspected:** 08-Feb-2010**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:	Li Yang and Wu Zhi Cheng	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 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:

Orthotropic Box Girder (OBG) Trial Assembly Areas

6AW to 6BW

This QA Inspector observed ZPMC personnel's at Segment 6AW to 6BW at PP 40 and PP 41 Longitudinal Diaphragm North and South side Heat Straightening was in progress against Heat Straightening Report (HSR) Report HSR1(B)-7992 Rev. 0 Dated Dec 11, 2009 for the following welds.

Seg 029B-007~008

Seg 029C-038~039

Seg 027D-035~038

Seg 027F-035~038

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LD 009A-001~010

LD010A-001~010

7BW to 7CW

This QA Inspector observed ZPMC welding personnel performing welding by Shielded Metal Arc Welding (SMAW) for weld connecting Edge Panel Counter Weight side for Transverse Splice Weld. The weld joints are identified as OBW7A -006. The welder is identified as 069683. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-2214-B-U2-FCM-1. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

7BW to 7CW

This QA Inspector observed ZPMC welding personnel performing welding by Shielded Metal Arc Welding (SMAW) for weld connecting Edge Panel Cross Beam side for Transverse Splice Weld. The weld joints are identified as OBW7A -010. The welder is identified as 068917. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-2214-B-U2-FCM-1. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

7BW to 7CW

This QA Inspector observed ZPMC welding personnel performing welding by Flux Cored Arc Welding (FCAW) for weld connecting Side Panel Corner Assembly Counter Weight side for Transverse Splice Weld. The weld joints are identified as OBW7C -006. The welder is identified as 068917. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2233T. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

7BW to 7CW

This QA Inspector observed ZPMC welding personnel performing welding by Flux Cored Arc Welding (FCAW) for weld connecting Side Panel Corner Assembly Cross Beam Side for Transverse Splice Weld. The weld joints are identified as OBW7C -010. The welder is identified as 069683. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2233T. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

7BW to 7CW

This QA Inspector observed ZPMC welding personnel performing welding by Flux Cored Arc Welding (FCAW) for weld connecting Side Panel Counter Weight side for Transverse Splice Weld. The weld joints are identified as OBW7C -007. The welder is identified as 068917. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2233T. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

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7BW to 7CW

This QA Inspector observed ZPMC welding personnel performing welding by Flux Cored Arc Welding (FCAW) for weld connecting Side Panel Cross Beam Side for Transverse Splice Weld. The weld joints are identified as OBW7C -009. The welder is identified as 069683. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2233T. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

7BW to 7CW

This QA Inspector observed ZPMC welding personnel performing welding by Flux Cored Arc Welding (FCAW) for weld connecting Bottom Panel for Transverse Splice Weld. The weld joints are identified as OBW7C -008. The welder is identified as 069683. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2231T. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

7BW to 7CW

This QA Inspector observed ZPMC personnel's at Segment 7BW to 7CW between Panel Point (PP) 52 and PP 53 Bottom Panel; Side Panel (Cross Beam and Counter Weight side) welding is in progress for Transverse Splice.

6BW

This QA Inspector observed ZPMC personnel's counter weight side Suspender Bracket installation is in progress.

7AW to 7BW

This QA Inspector observed ZPMC personnel's 7AW to 7BW between PP 49 and PP 50 Side Panel T-Rib cross beam side hold back welded area grinding was in progress.

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 Eric T Sang 1500-0042-2372, who represents the Office of Structural Materials for your project.

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