

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-012282**Date Inspected:** 26-Feb-2010**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:** Chen Xi, Li Jia.**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:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Subassembly, Bay 02, Traveler rail.

FCAW Repair welding (build up about 15-27mm) of weld joint 11TR1-004 (CWR # B-CWR1096); located on Subassembly, Bay 02. Welders are identified as 045203; ZPMC Quality Control Inspector (QC) is identified as Chen Xi. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-FCAW-1G(1F)-REPAIR-1. The attached photographs provide additional detail.

Subassembly, Bay 01, Traveler rail.

FCAW welding of weld joint 20TR1-026-007 & 20TR1-033-001; located on Subassembly, Bay 01. Welder is identified as 219188, 215397; ZPMC Quality Control Inspector (QC) is identified as Chen Xi. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-F. The attached photographs provide additional detail.

Subassembly, Bay 01, Support Brackets.

FCAW welding of weld joint 13TB1-201-002 & 13TB1-192-002 & 13TB1-203-002 & 13TB1-189-002 & 13TB1-199-002 & 13TB1-166-002; located on Subassembly, Bay 01. Welder is identified as 251246; ZPMC Quality Control Inspector (QC) is identified as Chen Xi. The welding variables recorded by Quality Control

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U4B-F. The attached photographs provide additional detail.

Subassembly, Bay 06, "U" Rib outer splice plate.

FCAW welding of weld joint USPL1-325-001, 002 & USPL1-326-001, 002 & USPL1-327-001, 002; located on Subassembly, Bay 03. Welder is identified as 053609; ZPMC Quality Control Inspector (QC) is identified as Chen Xi. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U4B-F. The attached photographs provide additional detail.

Bay 11, Bolt Tension Test.

This QA inspector witnessed the lot testing of the A325 High Strength Bolts to determine the torque values for the minimum tension required. Below is a list of the lots tested and the average torque values determined.

- DHGM270028(M27*110)- 680 Nm.
- DHGM270010(M27*150)- 827 Nm.
- DHGM27008(M27*130)- 887 Nm.
- DHGM270029(M27*120)- 647 Nm.
- DHGM270005(M27*150)- 820 Nm.
- DHGM270013(M27*85)- 920 Nm.
- DHGM270012(M27*85)- 880 Nm.
- DHGM270024(M27*100)- 827 Nm.

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



WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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 Serge Sinevod, 13482570045, who represents the Office of Structural Materials for your project.

Inspected By:	Juvekar,Amit	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
