

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-012440**Date Inspected:** 06-Mar-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**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:

Orthotropic Box Girder (OBG) Trial Assembly Areas

Segment 6AE

This Quality Assurance (QA) Inspector measured and recorded the Dimension for Floor Beam Stiffener to Longitudinal Diaphragm Flange for the Radius and Distance from the Edge to Weld and Weld Length from Cope Hole at Panel Point (PP) 48 and PP 49 (East and West Side of the Floor Beam). Report forwarded to team leader for further action.

Segment 6BE

This Quality Assurance (QA) Inspector measured and recorded the Dimension for Floor Beam Stiffener to Longitudinal Diaphragm Flange for the Radius and Distance from the Edge to Weld and Weld Length from Cope Hole at Panel Point (PP) 50, PP 51 and PP 52 (East and West Side of the Floor Beam). At PP 52 East side the measurements were not recorded as Floor Beam stiffener not welded to Longitudinal Diaphragm Flange. The measurements were not recorded at PP Report forwarded to team leader for further action.

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Segment 6CE

This Quality Assurance (QA) Inspector measured and recorded the Dimension for Floor Beam Stiffener to Longitudinal Diaphragm Flange for the Radius and Distance from the Edge to Weld and Weld Length from Cope Hole at Panel Point (PP) 53, PP 54 and PP 55(East and West Side of the Floor Beam). At PP 55 East side the measurements were not recorded as Floor Beam stiffener not welded to Longitudinal Diaphragm Flange. Report forwarded to team leader for further action. Please refer the pictures attached below for more comprehensive details.

Segment 6CW

This QA inspector observed ZPMC qualified welding personnel identified as 054467 perform repair welding Shielded Metal Arc Welding (SMAW), weld joint identified as CA027-005. ZPMC QC is identified as Mr. Feng Ya Jung. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-FCAW-2G (2F)-FCM-Repair-1. The Welding Repair Report (WRR) was B-WR10754 Rev.0.

Segment 6CW

This QA inspector observed, ZPMC qualified welding personnel identified as 054467 perform repair welding Shielded Metal Arc Welding (SMAW), weld joint identified as CA029-005. ZPMC QC is identified as Mr. Feng Ya Jung. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-FCAW-4G (4F)-FCM-Repair-1. The Welding Repair Report (WRR) was B-WR10753 Rev. 0.

Segment 5CW

The QA inspector performed inspection for the Incident Report # Dated 01/28/2010 for Longitudinal Diaphragm (LD) Stiffener at PP 36 for Segment 5CW as 16mm max deflection was measured with a straight edge in contact with the bottom of X77V and top of X77T stiffener. As on date after ZPMC had offered for inspection measured and recorded the deflection as 6mm. Report forwarded to team leader for further action.

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

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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

Reviewed By: Miller, Mark

QA Reviewer