

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-014374**Date Inspected:** 08-May-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 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 12BW

This QA Inspector performed dimension inspection along with Caltrans QA Mr. Manikandan for the Floor beam flange at Panel Point (PP) 113 and at PP 114 and the observations was as following.

At PP 113 in 5000mm long string line deformation recorded as 1mm and at 3450mm long string line deformation recorded as 2mm.

At PP 114 in 5000mm long string line deformation recorded as 5mm and at 2500mm long string line deformation recorded as 3mm.

The measured and recorded readings were submitted to the Lead and Engineer for review.

Segment 8AW to 8BW

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This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) welding was performed on weld joint OBW8B-004 cross beam side of segment. Welder is number identified as 037748. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

Segment 8AW to 8BW

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) welding was performed on weld joint OBW8B-003 located at bottom plate of segment. Welder is number identified as 069683. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

Segment 8AW to 8BW

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) welding was performed on weld joint OBW8B-004 cross beam side of segment. Welder number identified as 068097. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

Segment 8AW to 8BW

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) welding was performed on weld joint OBW8B-002 counter weight side of segment. Welder number is identified as 045196. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

Segment 8AW to 8BW

This QA Inspector observed ZPMC welding personnel performing Submerged Arc Welding (SAW) welding was performed on weld joint OBW8-003 deck plate of segment. Welder number is identified as 045270. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-PT-223(2)1T-2. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

Segment 8AW to 8BW

This QA Inspector observed ZPMC welding personnel performing Submerged Arc Welding (SAW) welding was performed on weld joint OBW8-003 deck plate of segment. Welder number is identified as 045265. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-PT-223(2)1T-2. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

Segment 8AW

WELDING INSPECTION REPORT

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This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) welding was performed on weld joint BP094-001-055~066 bottom plate of segment. Welder number is identified as 068924. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2112-FCM-1. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

Segment 8BW

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) welding was performed on weld joint BP095-001-031~042 bottom plate of segment. Welder number is identified as 068924. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2112-FCM-1. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

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
Reviewed By:	Carreon,Albert	QA Reviewer
