

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-014382**Date Inspected:** 16-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

Cross Beam (CB) #7

This QA Inspector along with Caltrans QA Mr. Manikandan performed Inspection for the Cross Beam which is connected at FL3 areas of 7BE and 7BW between Panel Point (PP) 50, PP 51 and PP 52 for the following.

Measured Gap between FL3 of 7BW to Cross Beam #7 Vertical Skin faying surface and 13 numbers horizontal Stiffener Offset at PP 50 (West Side)

Measured Gap between FL3 of 7BE to Cross Beam #7 Vertical faying surface and 13 numbers horizontal Stiffener Offset at PP 50 (East Side)

Measured Gap between FL3 of 7BW to Cross Beam #7 Vertical faying surface and 13 numbers horizontal Stiffener Offset at PP 51 (West Side)

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Measured Gap between FL3 of 7BE to Cross Beam #7 Vertical faying surface and 13 numbers horizontal Stiffener Offset at PP 51 (East Side)

Measured Gap between FL3 of 7BW to Cross Beam #7 Vertical faying surface and 13 numbers horizontal Stiffener Offset at PP 52 (West Side)

Measured Gap between FL3 of 7BE to Cross Beam #7 Vertical faying surface and 13 numbers horizontal Stiffener Offset at PP 52 (East Side)

Measured Gap between FL3 Bottom Plate of 7BW to Cross Beam #7 Bottom Plate faying surface and 5 numbers horizontal Stiffener Offset between PP 50 and PP 51(West Side)

Measured Gap between FL3 Bottom Plate of 7BE to Cross Beam #7 Bottom Plate faying surface and 5 numbers horizontal Stiffener Offset between PP 50 and PP 51 (East Side)

Measured Gap between FL3 Bottom Plate of 7BW to Cross Beam #7 Bottom Plate faying surface and 5 numbers horizontal Stiffener Offset between PP 51 and PP 52(West Side)

Measured Gap between FL3 Bottom Plate of 7BE to Cross Beam #7 Bottom Plate faying surface and 5 numbers horizontal Stiffener Offset between PP 51 and PP 52 (East Side)

Measured Gap between Deck Panel Extension at FL3 location of 7BW to Cross Beam #7 Deck Plate faying surface and 11 numbers horizontal Stiffener Offset between PP 50 and PP 51(West Side)

Measured Gap between FL3 Deck Panel Extension at FL3 location of 7BE to Cross Beam #7 Deck Plate faying surface and 11 numbers horizontal Stiffener Offset between PP 50 and PP 51 (East Side)

Measured Gap between FL3 Deck Panel Extension at FL3 location of 7BW to Cross Beam #7 Deck Plate faying surface and 11 numbers horizontal Stiffener Offset between PP 51 and PP 52(West Side)

Measured Gap between FL3 Deck Panel Extension at FL3 location of 7BE to Cross Beam #7 Deck Plate faying surface and 11 numbers horizontal Stiffener Offset between PP 51 and PP 52 (East Side)

Segment 8AW to 8BW

This QA Inspector observed ZPMC welding personnel performing welding by Shielded Metal Arc Welding (SMAW) for Bottom Panel Transverse Splice. The weld joints are identified as OBW8C-003. The welder is identified as 068097, 067942 and 037840. 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.

Segment 8AW to 8BW

This QA Inspector observed ZPMC welding personnel performing welding by Shielded Metal Arc Welding

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(SMAW) for Side Panel Transverse Splice Cross Beam side. The weld joints are identified as OBW8C-004. The welder is identified as 067764. 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.

Segment 8AW to 8BW

This QA Inspector observed ZPMC welding personnel performing welding by Shielded Metal Arc Welding (SMAW) for Side Panel Corner Assembly Transverse Splice Cross Beam side. The weld joints are identified as OBW8C-005. The welder is identified as 066261. 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.

Segment 8AW to 8BW

This QA Inspector observed ZPMC welding personnel performing welding by Shielded Metal Arc Welding (SMAW) for Side Panel Corner Assembly Transverse Splice Counter Weight side. The weld joints are identified as OBW8C-001. The welder is identified as 068097. 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.

Segment 8AW to 8BW

This QA Inspector observed ZPMC welding personnel performing welding by Shielded Metal Arc Welding (SMAW) for Side Panel Transverse Splice Counter Weight side. The weld joints are identified as OBW8C-002. The welder is identified as 037840 and 067942. 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.

Segment 8AW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder performing Flux Core Arc Welding (FCAW) welding was performed on weld joint SSD25-PP063-089/090 for Partial Height Diaphragm at FL3 areas. Welder is identified as 045227. ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2232.

Segment 8AW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder performing Shielded Metal Arc Welding (SMAW) welding was performed on weld joint EP062-001-012~015 for Counter Weight side Edge Panel Stiffeners. Welder is identified as 066038. ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2212-FMC-1.

Segment 8AW

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This Quality Assurance (QA) Inspector observed ZPMC qualified welder performing Flux Cored Arc Welding (FCAW) welding was performed on weld joint Seg043A-021 at work point location W4 Longitudinal Diaphragm Web to Bottom Plate. Welder is identified as 048696. ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2231-B-U2-F.

Segment 8AW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder performing Flux Cored Arc Welding (FCAW) welding was performed on weld joint Seg043A-043 at work point location W3 Longitudinal Diaphragm Web to Bottom Plate. Welder is identified as 045175. ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2231-B-U2-F.

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
