

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016454**Date Inspected:** 24-Aug-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)**Location:** Shanghai, China**CWI Name:** Li Yang and Zhu Zhong Hai**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 Mr. 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) at Trial Assembly Areas

Segment 10AW to Segment 10BW

This QA Inspector observed the in-process welding by Shielded Metal Arc Welding (SMAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as DP688-001-037. The welder identification was 066268 and observed welding in the 3G (Vertical) position using approved Welding Procedure Specification WPS-B-T-3213. The piece mark was identified as Deck Panel I-Rib at transverse splice, Cross Beam side.

Segment 10AW to Segment 10BW

This QA Inspector observed the in-process welding by Shielded Metal Arc Welding (SMAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as DP688-001-035. The welder identification was 066268 and observed welding in the 3G (Vertical) position using approved Welding Procedure Specification WPS-B-T-3213. The piece mark was identified as Deck Panel I-Rib at transverse splice, Cross Beam

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side.

Segment 10AW to Segment 10BW

This QA Inspector observed the in-process welding by Shielded Metal Arc Welding (SMAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as DP688-001-036. The welder identification was 066268 and observed welding in the 3G (Vertical) position using approved Welding Procedure Specification WPS-B-T-3213. The piece mark was identified as Deck Panel I-Rib at transverse splice, Cross Beam side.

Segment 10AW to Segment 10BW

This QA Inspector observed the in-process welding by Shielded Metal Arc Welding (SMAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as DP675-001-037. The welder identification was 066459 and observed welding in the 3G (Vertical) position using approved Welding Procedure Specification WPS-B-T-3213. The piece mark was identified as Deck Panel I-Rib at transverse splice, Counter Weight side.

Segment 10AW to Segment 10BW

This QA Inspector observed the in-process welding by Shielded Metal Arc Welding (SMAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as OBW10-003. The welder identification was 067829 and 067589 and observed welding in the 4G (Overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1. The piece mark was identified as Deck Panel transverse splice.

Segment 10AW

This QA Inspector observed the in-process welding by Shielded Metal Arc Welding (SMAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as Seg059A-040. The welder identification was 067752 and was observed welding in the 4G (Overhead) position using approved Welding Procedure Specification WPS-B-P-2214-Tc-U4b-FCM-1. The piece mark was identified as the Bottom Panel to Side Panel hold back area at Work Point W3.

Segment 10BW

This QA Inspector observed the in-process welding by Shielded Metal Arc Welding (SMAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as Seg061A-013. The welder identification was 067752 and was observed welding in the 4G (Overhead) position using approved Welding Procedure Specification WPS-B-P-2214-Tc-U4b-FCM-1. The piece mark was identified as the Bottom Panel to Side Panel hold back area at Work Point W3.

Segment 9EW

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This QA Inspector observed the in-process welding by Flux Cored Arc Welding (FCAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as Seg055B-043. The welder identification was 202384 and was observed welding in the 3G (Vertical) position using approved Welding Procedure Specification WPS-345-SMAW-3G (3F)-FCM-Repair-1. The piece mark was identified as the Longitudinal Diaphragm web to Floor Beam connecting weld at work point W3

Segment 10AW

This QA Inspector observed the in process fillet weld welding by Flux Cored Arc Welding (FCAW) process. The Weld joint was designated as Seg059B-027. The welder identification was 040704 and was observed welding in the 2F (Horizontal) position using approved Welding Procedure Specification WPS-B-T-2132. The piece mark was identified as the Longitudinal Diaphragm web at Work Point W3.

Segment 10BW

This QA Inspector observed the in process fillet weld welding by Flux Cored Arc Welding (FCAW) process. The Weld joint was designated as Seg061B-007. The welder identification was 040704 and was observed welding in the 2F (Horizontal) position using approved Welding Procedure Specification WPS-B-T-2132. The piece mark was identified as the Longitudinal Diaphragm web at Work Point W3.

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 were reported on this date.

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 Tsang 150000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Math,Manjunath	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
