

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027195**Date Inspected:** 25-Oct-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**CWI Name:** Wai Tao**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**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector R. Hernandez was present during the time noted above and conducted observations relative to the work being performed.

The QA Inspector randomly observed the following work in progress:

Bay Number 1

Performed verification VT for the component(s) and corresponding welds for component on OBG Barrier Rail assembly listed as E5-SB1-039 for the following designated weld number(s): 001~179. This QA inspector signed green tag #15141.

Performed verification VT for the component(s) and corresponding welds for component on OBG Barrier Rail assembly listed as E5-SB1-034 for the following designated weld number(s): 001~179. This QA inspector signed green tag #15141.

Performed verification VT for the component(s) and corresponding welds for component on OBG Barrier Rail assembly listed as E5-SB1-037 for the following designated weld number(s): 001~179. This QA inspector signed green tag #15141.

Performed verification VT for the component(s) and corresponding welds for component on OBG Barrier Rail assembly listed as E5-SB1-022 for the following designated weld number(s): 001~179. This QA inspector signed

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green tag #15141.

Performed verification VT for the component(s) and corresponding welds for component on OBG Barrier Rail assembly listed as E5-SB1-001 for the following designated weld number(s): 001~179. This QA inspector signed green tag #15141.

Performed verification VT for the component(s) and corresponding welds for component on OBG Barrier Rail assembly listed as E5-SB1-047 for the following designated weld number(s): 001~179. This QA inspector signed green tag #15141.

Performed verification VT for the component(s) and corresponding welds for component on OBG Barrier Rail assembly listed as E5-SB1-009 for the following designated weld number(s): 001~179. This QA inspector signed green tag #15141.

Performed verification VT for the component(s) and corresponding welds for component on OBG Barrier Rail assembly listed as E5-SB1B-005 for the following designated weld number(s): 001~179. This QA inspector signed green tag #15141.

Bay Number 2

Performed verification VT for the component(s) and corresponding welds for component on OBG Barrier Rail assembly listed as E5-SB5-006 for the following designated weld number(s): 001~179. This QA inspector signed green tag #15110.

Performed verification VT for the component(s) and corresponding welds for component on OBG Barrier Rail assembly listed as E5-SB5-007 for the following designated weld number(s): 001~179. This QA inspector signed green tag #15110.

Performed verification VT for the component(s) and corresponding welds for component on OBG Barrier Rail assembly listed as E5-SB5-008 for the following designated weld number(s): 001~179. This QA inspector signed green tag #15110.

Performed verification VT for the component(s) and corresponding welds for component on OBG Barrier Rail assembly listed as E5-SB5-012 for the following designated weld number(s): 001~179. This QA inspector signed green tag #15110.

Performed verification VT for the component(s) and corresponding welds for component on OBG Barrier Rail assembly listed as E5-SB5-014 for the following designated weld number(s): 001~179. This QA inspector signed green tag #15110.

Performed verification VT for the component(s) and corresponding welds for component on OBG Barrier Rail assembly listed as E5-SB1-011 for the following designated weld number(s): 001~179. This QA inspector signed green tag #15110.

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Performed verification VT for the component(s) and corresponding welds for component on OBG Barrier Rail assembly listed as E5-SB1-014 for the following designated weld number(s): 001~179. This QA inspector signed green tag #15110.

Performed verification VT for the component(s) and corresponding welds for component on OBG Barrier Rail assembly listed as E5-SB1-017 for the following designated weld number(s): 001~179. This QA inspector signed green tag #15110.

Performed verification VT for the component(s) and corresponding welds for component on OBG Barrier Rail assembly listed as E5-SB1D-013 for the following designated weld number(s): 001~179. This QA inspector signed green tag #15110.

ZPMC personnel heat straightening Orthotropic Box Girder (OBG) sub assembly member identified as VP3014-001 for weld(s) 002~009, 011~019, 022~030, 033~041, 044~052. Distortion appeared to be caused by welding. ZPMC Quality Control (QC) inspector identified as Mr. Wai Tao was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report (HSR) no. HSR(B)-419.

Bay Number 3

Performed verification VT for the component(s) and corresponding welds for component on OBG Floor Beam component listed as FB3265-001 for the following designated weld number(s): 001~047, 050~052, 055~057, 060~062, 065~067, 070~072, 075~077, 080~082, 083~094, 099~105, & 110~135. This QA inspector signed green tag #15139.

Performed verification VT for the component(s) and corresponding welds for component on OBG Edge Beam assembly listed as EB3053-001 for the following designated weld number(s): 001~012. This QA inspector signed green tag #15156.

Performed verification VT for the component(s) and corresponding welds for component on OBG Edge Beam assembly listed as EB3052B-001 for the following designated weld number(s): 005~008. This QA inspector signed green tag #15155.

Performed verification VT for the component(s) and corresponding welds for component on OBG Edge Beam assembly listed as EB3052A-001 for the following designated weld number(s): 001~004. This QA inspector signed green tag #15154.

Performed verification VT for the component(s) and corresponding welds for component on OBG Edge Beam assembly listed as EB3051B-001 for the following designated weld number(s): 005~016. This QA inspector signed green tag #15153.

Performed verification VT for the component(s) and corresponding welds for component on OBG Edge Beam assembly listed as EB3051A-001 for the following designated weld number(s): 001~004. This QA inspector signed green tag #15152.

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Performed verification VT for the component(s) and corresponding welds for component on OBG Edge Beam assembly listed as EB3050B-001 for the following designated weld number(s): 005~008. This QA inspector signed green tag #15150.

Performed verification VT for the component(s) and corresponding welds for component on OBG Edge Beam assembly listed as EB3050A-001 for the following designated weld number(s): 001~004. This QA inspector signed green tag #15150.

FCAW welding of fillet weld joint(s) located on lift 14 OBG longitudinal diaphragm identified as LD3041-001 weld number(s) 278. Welder is identified as welder no. 052686. The welding variables recorded by ZPMC QC identified as Wai Tao, appeared to comply with applicable WPS(s) WPS-B-T-2132-3.

FCAW welding of fillet weld joint(s) located on lift 14 OBG longitudinal diaphragm identified as LD3041-001 weld number(s) 368. Welder is identified as welder no. 217805. The welding variables recorded by ZPMC QC identified as Wai Tao, appeared to comply with applicable WPS(s) WPS-B-T-2132-3.

Bay Number 4

FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG sub assembly component identified as SA3326-001 weld number(s) 001~004. Welder is identified as welder no. 208035. The welding variables recorded by ZPMC QC identified as Wai Tao appeared to comply with applicable WPS(s) WPS-B-T-2231-TC-P4-F.

FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG sub assembly component identified as SA3327-001 weld number(s) 001~004. Welder is identified as welder no. 208035. The welding variables recorded by ZPMC QC identified as Wai Tao appeared to comply with applicable WPS(s) WPS-B-T-2231-TC-P4-F.

FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG sub assembly component identified as SA3328-001 weld number(s) 001~004. Welder is identified as welder no. 208035. The welding variables recorded by ZPMC QC identified as Wai Tao appeared to comply with applicable WPS(s) WPS-B-T-2231-TC-P4-F.

FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG sub assembly component identified as SA3329-001 weld number(s) 001~003. Welder is identified as welder no. 208035. The welding variables recorded by ZPMC QC identified as Wai Tao appeared to comply with applicable WPS(s) WPS-B-T-2231-TC-P4-F.

FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG sub assembly component identified as SA3330-001 weld number(s) 001 & 002. Welder is identified as welder no. 208035. The welding variables recorded by ZPMC QC identified as Wai Tao appeared to comply with applicable WPS(s) WPS-B-T-2231-TC-P4-F.

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FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG sub assembly component identified as SA3331-001 weld number(s) 001 & 002. Welder is identified as welder no. 208035. The welding variables recorded by ZPMC QC identified as Wai Tao appeared to comply with applicable WPS(s) WPS-B-T-2231-TC-P4-F.

FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG sub assembly component identified as SA3332-001 weld number(s) 001. Welder is identified as welder no. 208035. The welding variables recorded by ZPMC QC identified as Wai Tao appeared to comply with applicable WPS(s) WPS-B-T-2231-TC-P4-F.

Unless otherwise noted above all items observed on this day appeared to be in general compliance with the applicable contract documents

Summary of Conversations:

Pertinent conversations are included in the body of the report.

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 1500-0042-02372, who represents the Office of Structural Materials for your project.

Inspected By:	Hernandez,Rene	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
