

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-001958**Date Inspected:** 15-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 930**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Bay 2 New OBG Bldg

CWI Name:	Chen Chie Ming 03110711	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:	Side & Bottom Panels	

Summary of Items Observed:

Caltrans Quality Assurance Inspector Mr. David Kelsey (QA Inspector) arrived at Shanghai Zhenhua Port Machinery Co (ZPMC) to observe Quality Control Inspector Mr. Chen Chie Ming (QC Inspector) of ZPMC perform the duties and responsibilities as outlined in the Welding Quality Control Plan (WQCP) and the Contract Special Provisions and to randomly inspect the in-process welding fabrication of the Orthotropic Box Girder (OBG) SP12A, SP21A, BP005 and BP004.

The Caltrans QA Inspector performed in-process visual inspection on the submerged arc welding (SAW) multiple cover pass welds joining the side plates SP12A to the SP21A.

The Caltrans QA Inspector performed in-process visual inspection on the submerged arc welding (SAW) multiple cover pass welds joining the bottom plates BP004 to the BP005.

Bay 2 New OBG Building:

The Caltrans QA Inspector observed heat straightening of side plate SP64 to a maximum temperature not to exceed 650°C per heat straightening procedure HSR1 B-496.

The Caltrans QA Inspector observed cutting plate edge to a 22.5° bevel on side plate SP 60 with the automated machine oxygen/acetylene process.

The Caltrans QA Inspector verified the fit-up of bottom plates BP002 to BP003 in preparation for welding. QA Inspector measured bevel angle at 45° and a root gap opening of 5 to 7 millimeters.

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The Caltrans QA Inspector observed in-process welding of the previously mentioned bottom and side plates within the parameters set forth in the WPS-B-T-224-B-L26-S-1. QA Inspector observed the ZPMC QC Inspector and two CAWI monitoring welding voltage, pre-heat & interpass temperatures, weld pass width, profile/size and travel speed. The Caltrans QA Inspector checked the CWI qualifications and randomly verified the pre-heat & interpass temperatures, welding position, welding voltage, weld profile, size and interpass cleaning on the previously mentioned plates.

The in-process welding, heat straightening, and fit-up preparation observed appears to comply with WPS-B-T-224-B-L26-S-1, HSR1 B-496, the approved drawings, the WQCP, Contract Special Provisions and AWS welding code D1.5.

Summary of Conversations:

No significant conversations at the time of this 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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Kelsey,David	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
