

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-007019**Date Inspected:** 23-Jan-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Wei / Sun Bo**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 Components**Summary of Items Observed:**

The Caltrans (CT) Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Tower and Orthotropic Box Girders (OBG).

OBG Sub-Assembly Bay 2:

The QA Inspector randomly observed ZPMC welder Gu Xue Ying ID 045218, utilizing the Shielded Metal Arc Welding (SMAW) Process to attach fit up adjustment turnbuckles to pads on Cross Beam Sub-Assembly SEG-1, piece mark 196p.

The QA Inspector randomly observed ZPMC Quality Control (QC) Personnel verifying fit up of webs to the base plate on Cross Beam Sub-Assembly SEG-2.

The QA Inspector randomly observed ZPMC helpers utilizing angle grinders to blend the bevels on 80.75M West and North Tower Diaphragms.

OBG Sub-Assembly Bay 3:

The QA Inspector randomly observed ZPMC welder Wang Chang Fa ID 058102, utilizing the SMAW Process in the 1G (Flat Groove) position with ZPMC WPS WPS-B-P-2211, to fit up and tack weld the butt splice between T=18+18 millimeter (mm) to T=14 mm sections of Floor Beam Sub-Assembly FB023-006 at WJ's 078 and 079.

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The QA Inspector randomly observed ZPMC QC verifying weld parameters. Weld parameters appeared to comply with contract requirements.

The QA Inspector randomly observed a ZPMC Carbon Air Arc Gouging Operator utilizing the Carbon Air Arc Gouging Process, to back gouge the vertical welds attaching cross stiffeners to Floor Beam Diaphragm Sub-Assemblies FB003-042 and FB003-094.

The QA Inspector randomly observed ZPMC welder Chen Chuan Zong ID 044824, utilizing the Flux Cored Arc Welding (FCAW) Process in the 1G (Flat Groove) position with ZPMC WPS WPS-B-T-2231, to weld the root pass in the butt splice between T=18+18 mm to T=14 mm sections of Floor Beam Sub-Assembly FB023-006 at WJ's 078 and 079. The QA Inspector randomly observed ZPMC QC verifying weld parameters. Weld parameters appeared to comply with contract requirements.

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 Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Franco,Charlie	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
