

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-007020**Date Inspected:** 24-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 fit up and tack weld Web Plates piece marks X196P and X196R to the base plate of Cross Beam Sub-Assembly SEG-1.

The QA Inspector randomly observed ZPMC welder Chen Chuan Zong ID 044824, utilizing the SMAW Process to fit up and tack weld Web Plates piece marks X195B and X195H to the base plate of Cross Beam Sub-Assembly SEG-2.

The QA Inspector randomly observed ZPMC welding personnel heat straightening various Cross Beam Web Plates to reduce mill induced distortion.

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

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T=18 millimeter (mm) to T=12+12 mm sections of Floor Beam Sub-Assembly FB039-003 at Weld Joint (WJ) Numbers 081 and 101 and between T=18+18 mm to T=14 mm sections at WJ's 078 and 079. 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 at WJ's 078/079 and 081/101 on Floor Beam Sub-Assembly FB024-006.

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 FB039-003 at WJ's 078 and 079. 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 helper utilizing an angle grinder to blend after Carbon Air Arc Back Gouging at WJ's 078/079 and 081/101 on Floor Beam Sub-Assembly FB024-006.

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
