

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-007021**Date Inspected:** 27-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 12:

The QA Inspector randomly observed ZPMC welding personnel performing heat straightening operations to reduce weld induced distortion from welding the T=35 millimeter (mm) thick I-Ribs Deck Plate 1AE-DP605-001 (In Process Yellow Tag Number 001480) at Complete Joint Penetration (CJP) Weld Joint (WJ) Numbers 009, 011 and 013. DP605-001 is placed upside down with heat being applied to the underside of the Deck Plate with the ribs facing downward. The QA Inspector randomly observed that no counter weights, restraint or jacks were being used at this time. The work was being performed in accordance with ZPMC Heat Straightening Request (HSR) HSR(B)-250 Rev. 0.

The QA Inspector randomly observed a ZPMC Carbon Air Arc Gouging Operator utilizing the Carbon Air Arc Gouging Process to gouge out and remove rejects in WJ's 013 and 017 in Deck Plate 1AE-DP615-001. The rejects were detected during previous ZPMC QC Ultrasonic Testing (UT) Examination.

The QA Inspector randomly observed a ZPMC helper utilizing an angle grinder to clean up excavations after Carbon Air Arc Gouging in WJ's 013 and 017 in Deck Plate 1AE-DP615-001.

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The QA Inspector randomly observed ZPMC welding personnel performing heat straightening operations to reduce weld induced distortion from welding the T=35 mm thick I-Ribs to Deck Plate 1AE-DP605-001 (In Process Yellow Tag Number 001480) at Complete Joint Penetration (CJP) Weld Joint (WJ) Numbers 009, 011 and 013. DP605-001 is placed upside down with heat being applied directly to the welds attaching the I-Ribs to DP605-001. The QA Inspector randomly observed that both restraints and jacks (passive) were being used but no counter weights. The work was being performed in accordance with ZPMC Heat Straightening Request (HSR) HSR(B)-250 Rev. 0.

The QA Inspector randomly observed ZPMC QC verifying flatness of the underside of Deck Plate 1AE-DP605-001 with a 2 meter straight edge.

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
