

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-007097**Date Inspected:** 27-Feb-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 6 magnetic drill operators and 6 helpers, utilizing magnetic drills with hole saw bits, to cut bolt holes in connection plates piece marks OBE1C and OBE2C-X38 (A709 GR 345 T2-X T=8), A480 (A709 GR 485 T=40) and A158 (A709 GR 485 T=40).

The QA Inspector randomly observed ZPMC welders Xu Guo Yin ID 059443 and Xiang Huan Feng ID 059416, utilizing the Flux Cored Arc Welding (FCAW) Process in the 2G/2F (Horizontal Groove/Horizontal Fillet) Positions with ZPMC WPS WPS-345-FCAW-2G (2F)-Repair-1 to weld repairs in WJ 001, 002, 003, 004, 005 (059443); and 006, 007, 008, 009 and 010 (059416) respectively, attaching U-Ribs to Deck Plate 7BW-DP223-001.

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

The QA Inspector randomly observed ZPMC welders Liu Xie ID 066236, Xia Jun ID 068253 and Jiang Jin Yong ID 060361, utilizing the Shielded Metal Arc Welding (SMAW) Process in the 2G (Horizontal Groove) Position with ZPMC Weld Procedure Specification (WPS) WPS-345-SMAW-2G (2F) Repair-1 to weld repairs to WJ's 011 (B-WR2536) 015 (B-WR2538) and 017 (B-WR2539) respectively, attaching T=35 mm I-Ribs to the base

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plate on Deck Plate 1AW-DP575-001. The QA Inspector randomly observed ZPMC QC monitoring weld parameters. Weld parameters appeared to comply with contract requirements.

The QA Inspector randomly observed 2 ZPMC helpers utilizing angle grinders to blend the U-Rib welds after R1 repairs on Deck Plate 7BW-DP115-002.

The QA Inspector randomly observed 2 ZPMC helpers utilizing angle grinders to excavate areas in the U-Rib welds at WJ's 008 and 010, for R3 repairs in Deck Plate 7BW-DP169-001. These areas had been previously marked up after previous UT Examination.

The QA Inspector randomly observed 4 ZPMC helpers utilizing angle grinders to blend the U-Rib welds after R1 repairs on Deck Plate 7BW-DP223-001.

The QA Inspector randomly observed 3 ZPMC helpers utilizing angle grinders to excavate areas in the U-Rib welds at WJ's 001 through 010, for repairs in Deck Plate 7BW-DP250-001. These areas had been previously marked up after previous UT Examination.

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
