

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-008751**Date Inspected:** 27-Jul-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:** Xu Yumin**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**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) Trial Assembly Areas

3AE

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) at Deck Panel Diaphragm to Floor Beam Flange at PP 22. The weld joint no. SSD18A-PP022-005/004 is in progress. The welder is identified as 050242 and 051356. Welder was welding in 2G position. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-345-FCAW-2G-Repair-2.

3AE

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) at Deck Panel Diaphragm to Floor Beam Flange at PP 21. The weld joint no. SSD18A-PP022-005/004 is in progress. The welder is identified as 051356, 050242, 044801 and 055791. Welder was welding in 2G position. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e.,

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WPS-345-FCAW-2G-Repair-2.

Segment 2AW and 2BW

This Quality Assurance (QA) Inspector signed off the Green Tag for the Bolting Tension Verification. The following are details of reports.

1. U-Rib to U-Rib (Big splice location no. 21(L), 34(R) from North for 2AW and 2BW for PP 16 to 17 Green Tag No.174 (for bolt size M22x85 and M22x65)
2. U-Rib to U-Rib (Big splice location no. 21(L), 34(R) from North for 2AW and 2BW for PP 16 to 17 Green Tag No.175 (for bolt size M22x80 and M22x65)
3. U-Rib to U-Rib (Except big splice location no. 2,4,17 and 21 from North for 2AW and 2BW for PP 13.5 and 14 Green Tag No.176 (for bolt size M22x65)

5AE

This Quality Assurance (QA) Inspector observed BK003-001-36K and BK002-001-36K Cantilevers for Bike Path repair welding for renewed steel is in progress, the Cantilever got distorted to heat applied during heat straightening both the cantilever repairing is in progress next to segment 5AE.

2AE

This Quality Assurance (QA) Inspector observed rotation of nut is in progress for U-Rib to U-Rib connection for segment 2AE between PP 13.5 to PP 14.

2AW

This Quality Assurance (QA) Inspector observed 3 nos. angle assembly connecting Bottom Panel to Floor Beam bolt installation carried out and snug tightening is in progress and 2nos. angle assembly connecting to Side Panel to Floor Beam North and South side snug tightening is in progress bolt size used are M22x55 and M22x60.

1BW and 2AW

This Quality Assurance (QA) Inspector observed at PP 10.5; PP 11.5; PP12.5 and PP 13.5 Floor Beam to Side Panel connecting angle assembly bolt snug tightening is in progress bolt size used are M22x55 and M22x65 and for Bottom Panel to Floor Beam connecting angle assembly bolts used M22x75 snug tightening is in progress.

1AW and 1BW

This Quality Assurance (QA) Inspector observed at PP 10 and 10.5 shop welds for Segment to Segment hold back areas to Bottom Panel to Bottom Panel plate stiffener buffing is in progress for ZPMC Magnetic Particle Testing.

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1AW and 1BW

This Quality Assurance (QA) Inspector observed at Counter Weight Side (shop welded Segment to Segment completed) and for Longitudinal Stiffener heat straightening is in progress.

1AE

This Quality Assurance (QA) Inspector observed at PP 8.5 North and South side magnetic particle testing by ABF QA is in progress for lifting lug assembly weld.

2BW

This Quality Assurance (QA) Inspector observed at PP 18 T-Rib at Bottom Panel and Side Panel (North and South) web area rounding off weld being performed.

2BE

This Quality Assurance (QA) Inspector observed at PP 18 corner assembly North Side Magnetic Particle Testing by ZPMC personnel in progress for all stiffeners hold back welded areas.

1BE

This Quality Assurance (QA) Inspector observed at PP 14.5 Floor Beam Flange to deck panel diaphragm connecting weld UT being performed by ZPMC personnel.

4AE

This Quality Assurance (QA) Inspector observed at PP 24 and 25 Deck Panel Diaphragm to Floor Beam Flange connecting weld welding CJP being completed and visual inspection for PP 25 being completed by ZPMC CWI and visual inspection found discontinuity areas grinding in progress at PP 24 CWI visual inspection is been carried out.

3AE

This Quality Assurance (QA) Inspector observed at PP 21 West Side welding finished East Side Back Gouging completed from other side for the same grinding in progress to facilitate ZPMC and ABF to perform Magnetic Particle Test to weld connecting Deck Panel Diaphragm to Floor Beam Flange.

3AE

This Quality Assurance (QA) Inspector observed at PP 22 East Side welding finished and West Side carbon arc gouging being performed to weld connecting Deck Panel Diaphragm to Floor Beam Flange.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract

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documents.

Summary of Conversations:

No Relevant Conversation

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 , who represents the Office of Structural Materials for your project.

Inspected By:	Math,Manjunath	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
