

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-008754**Date Inspected:** 31-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:** Wu Zhi Chen**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 Trail Assembly**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

3AW

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) at Bottom Panel to Side Panel connecting weld. It was noticed that during heat straightening of the Longitudinal Stiffener distortion occurred at Bottom Panel and at Longitudinal Stiffener web area between PP 19 and 20 at CB side. The welder is identified as 066571. Welder was welding in 4G position. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-345-SMAW-4G (4F)-Repair.

3AW

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) at holes of I-Rib Floor Beam FL3 to CB connecting plate in segment 4BE, 4AE, 3AE and 3BE have insufficient size after cutting the allowance of the connection plate. All together have 96 Connecting Plates which needs surface welding.

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The critical weld report no. B- WR6550. The welder is identified as 220064. Welder was welding in 1G position. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i. e., WPS-345-FCAW-1G (1F)-Repair-Mis-drilled hole.

3AW

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) for the Deck Panel Diaphragm to Floor Beam Flange for the repaired area for segment 3AW at PP 20. The Critical Weld report no. B- CWR617. The welder is identified as 054467. Welder was welding in 2G position. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-SMAW-2G(2F)-Repair.

3AW

This Quality Assurance (QA) Inspector observed at PP 20 for FL3 stiffeners mis drilled holes repair work completed and flush grinding is in progress.

Cantilever

This Quality Assurance (QA) Inspector observed Cantilever no. BK-003-001-36K and BK-002-001-36K repair in progress due to the steel replacement, distortion in cantilever caused by heat straightening the work is been performed next to the 5AE.

3BE

This Quality Assurance (QA) Inspector observed at PP 23 field segment U-Rib being installed with retro plate splice with few bolts so that at site those can be removed at installed at U-Rib to U-Rib.

3AE

This Quality Assurance (QA) Inspector observed at PP 19 and 20 cross beam side Longitudinal Diaphragm and Bottom Panel to Side Panel cut loose as it was distorted during heat straightening and as on date welding is in progress by welder 066571 in 4G position from external from internal side welding is completed.

2BE

This Quality Assurance (QA) Inspector observed at PP 18 Deck Panel Diaphragm to Floor Beam Flange Magnetic Particle Testing (MPT) is in progress by ZPMC QC at east side of diaphragm.

2BE

This Quality Assurance (QA) Inspector observed at PP 18 Deck Panel Diaphragm to Floor Beam Flange Magnetic Particle Testing (MPT) is in progress by ABF QA at west side of diaphragm.

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1AE to 1AAE

This Quality Assurance (QA) Inspector observed segment 1AE to 1AAE (segment to segment) fit-up is in progress.

1AW to 1AAW

This Quality Assurance (QA) Inspector observed segment 1AW to 1AAW (segment to segment) fit-up is in progress.

Structure (Electric Stanchions)

This Quality Assurance (QA) Inspector observed A325 bolt installation for electric stanchions is in progress at Bottom Panel structure bolt installation is in progress T-Rib to the structure from PP 16 and 17 for segment 2AW to 2BW for segment 1AE to 1AAE (segment to segment) fit-up is in progress.

1BW to 2AW

This Quality Assurance (QA) Inspector observed at PP 12.5 to 13 Longitudinal Shear Plate (LD) segment to segment bolt connecting plate's heat straightening completed and splice plate installation is in progress.

3AW

This Quality Assurance (QA) Inspector observed at PP 20 and PP23 Deck Panel Diaphragm to Floor Beam Flange repair welding is in progress.

5AW

This Quality Assurance (QA) Inspector observed at PP 29 Magnetic Particle Testing being performed at weld connecting Deck Panel Diaphragm to Floor Beam Flange by ZPMC QC.

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

Inspected By: Math,Manjunath

Quality Assurance Inspector

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Reviewed By: Carreon,Albert

QA Reviewer