

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT**Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008800**Date Inspected:** 31-Aug-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:	Li Jia	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 day CALTRANS OSM Quality Assurance Inspector (QA) S. Manjunath. Math was present during the times noted above for observations relative to the work being performed.

Orthotropic Box Girder (OBG) Trial Assembly Areas

Segment 5CE

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) and Flux Cored Arc Welding (FCAW) for Un-equal Angle to the Corner Assembly CA X37K it was over the requirement and gap noticed 17mm in length. The welding being carried out against the Welding Report B-WR6249 Rev. 0. The welder is identified as 216086. In process SMAW and FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-345-SMAW-1G (1F)-Repair and WPS-345-SMAW-FCAW-3G (3F)-Repair.

Segment 5BE to 5CE

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Side Panel to Side Panel Transverse Segment Weld Bike Path and Counter Weight Side. The weld joint no. OBE 9A-009 and OBE 9A-010 Welding was in progress. The welder is identified as 220067 and 053609. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2233T.

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Segment 1AE

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Deck Panel Diaphragm to the Floor Beam Flange. The weld joint no. SSD34A-PP8.5-153 and SSD34-PP8.5-153 welding was in progress. The welder is identified as 050316 and 658245. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2232-Tc-U4b-FCM.

Segment 1BE

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) for Weld connecting Deck Panel Diaphragm to the Floor Beam Flange Cracks were being found during MPT Test (2 Nos. of Longitudinal Crack and 2 Nos. of Transverse Crack) for Segment 1BE at PP 12. The weld joint no. SSD49-PP12-003 welding was in progress. The welder is identified as 045133. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-SMAW-345-2G (2F)-Repair. Welding being carried out against Critical Weld Repair B-CWR627 Rev. 1.

Segment 1AW

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Weld connecting Deck Panel Diaphragm to the Floor Beam Flange for Segment 1AW at PP 8.5. The weld joint no. SSD34A-PP 8.5-003 welding was in progress. The welder is identified as 048801. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2232-Tc-U5-F.

Segment 1AE to 1AAE

This QA Inspector along ABF Survey Team Measured and Recorded the flatness of weld connecting Area Bottom Panel to Side Panel by means of Straight Edge 630 mm and 600 mm and reading were being taken at locations B1, B2, B3 and B4.

Segment 5CE

This Quality Assurance (QA) Inspector observed at 5CE and PP35 North and South side Lower Chevrons bolts installation ASTM A 325 finished and Snug Tightening is in progress.

Segment 1BE

This Quality Assurance (QA) Inspector observed at 1BE at PP 12 Deck Panel Diaphragm to Floor Beam Flange weld excavated areas welding was in progress.

Segment 1AE

This Quality Assurance (QA) Inspector observed at 1AE at PP 8.5 Deck Panel Diaphragm to Floor Beam Flange

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weld excavated areas welding was in progress.

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
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