

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-009681**Date Inspected:** 10-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** ZPMC and ABF**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 Mr. Wai Pau, was present during the times noted above for observations relative to the work being performed.

Bay #1

Counter weight box: - Caltrans QA inspector observed two ZPMC welding operators performed an electric arc stud weld process on the interior surface of base plate for counter weight box #CW50. The stud size is 19mm diameter x150mm length. A stud and ceramic ferrule are loaded into the gun, and the gun properly positioned against the base plate on the assigned location with down hand welding position. The stud welding has been completed approximately two hours on one side of base plate. The counter weight box need rotate to another side for stud welding. The stud welding process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA Inspector observations, no discrepancies were noted.

Bay #2

Floor beam type 1:- Caltrans QA inspector observed one ZPMC welding operator performed semi-automatic FCAW fillet weld process on flange and stiffeners for type-1 of floor beam #FB-3100-001. The fillet weld size is 6mm with single pass. The semi-automatic FCAW fillet welds process were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA Inspector observations, no discrepancies were noted.

Floor beam type 1:- Caltrans QA inspector observed one ZPMC welders performed FCAW fillet weld process on stiffeners for type-1 of floor beam #FB-3038-001. The fillet weld size is 6mm, 8mm and 10mm with single pass and multiple pass. The FCAW fillet welds process were monitored and recorded by ZPMC and ABF QC inspector.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Based on Caltrans QA Inspector observations, no discrepancies were noted.

Bay #3

Caltrans QA Inspector observed three ZPMC grinders in process of grinding on six longitudinal diaphragms. The longitudinal diaphragms ID are LD001-045-001, LD-001-056-003, LD001-043-004, LD002-047-004, LD001-044-004 and LD002-041-004. The grinding process were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA Inspector observations, no discrepancies were noted.

Bay #6

Tower strut: - Caltrans QA Inspector observed a welder performed two spots SMAW noncritical weld repair process on tower strut. The tower struts ID was WD1-A305-53M-1. All of FCAW noncritical repair weld located at web to flange of tower strut which have been rejected by ZPMC UT testing. The weld repair report number is T-CWR292 and the weld repair areas are 65mm length x 25mm wide x 30mm depth and 55mm length x 20mm wide x 35mm depth. The SMAW noncritical weld repair is monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

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

Summary of Conversations:

As notes within report above.



Stud weld process on base plate of counter weight box



SMAW noncritical weld repair process on tower strut

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 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Pau,Wai	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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