

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-009860**Date Inspected:** 02-Oct-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 Jha and 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 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) Trail Assembly Area

Lift 5 West (Segment 5BE to 5CE)

This QA Inspector along with Mr. Manikandhan measured and recorded the dimension for Longitudinal Diaphragm for Offset and Sweep and noticed Offset of +4mm and Sweep as 7mm. This inspection was a joint inspection in which ABF and ZPMC were also involved.

1AE to 1AAE

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) for Stiffener welded between I-Rib Stiffener for Deck Panel. The weld joint is identified as OBE1-087. The welder is identified as 050433. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-2114-FCM-1.

Segment 5AE to 5BE

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) for

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Transverse Splice weld the back gouged areas. The weld joint is identified as OBE5A-008. The welder is identified as 066179. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-2214-B-U2-FCM-1.

1AE to 1AAE

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) for Stiffener welded between I-Rib Stiffener for Deck Panel. The weld joint is identified as OBE1-079. The welder is identified as 045268. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-2114-FCM-1.

1AW to 1AAW

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) for Stiffener welded between I-Rib Stiffener for Deck Panel. The weld joint is identified as OBW1-011 and 023. The welders were identified as 220066. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2233-Tc-U5-F and WPS-B-T-2234-C-U2-F.

1AW to 1AAW

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) for Stiffener welded between I-Rib stiffener for Deck Panel. The weld joint is identified as OBW1-239 and 063. The welders were identified as 220067. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2233-Tc-U5-F and WPS-B-T-2234-C-U2-F.

Segment 1AE

This Quality Assurance (QA) Inspector observed at 1AE for Deck Pane I Stiffener to Transverse welded stiffener between I stiffener welding was in progress.

Segment 5BW

This Quality Assurance (QA) Inspector observed at 5BW Bolt snug tightening and final rotation of nut was been performed.

Segment 2AE to 2BE

This Quality Assurance (QA) Inspector observed at 2AE to 2BE between PP 14, PP 15 and PP16 FL3 Bottom Panel to Bolt installation is finished and snug tightening and final rotation of nut was in progress.

Segment 5CE

This Quality Assurance (QA) Inspector observed at 5CE at PP 35 Bike Path side Angle connecting to Floor Beam flange to spice plate bolt sung tightening was in progress.

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Segment 5CE

This Quality Assurance (QA) Inspector observed at 5CE at PP 35 Bike Path side Angle connecting to Floor Beam flange to splice plate bolt snug tightening 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
Reviewed By:	Carreon,Albert	QA Reviewer
