

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: 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-009951**Date Inspected:** 07-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) Trial Assembly Area

Lift 1 East

This Quality Assurance (QA) Inspector witnessed final tension verification for bolt connecting Bottom Plate to FL3 at PP 14, PP 15 and PP 16 for Segment Lift 2 East. Inspected 10% on a random basis and found the tension to be in general compliance.

Bolt sizes used are M24x60 RC Lot No. DHGM240014 and final Torque required was 567 N-m and

Bolt sizes used are M24x65 RC Lot No. DHGM240008 and final Torque required was 547 N-m.

Manual Torque wrench has been used with Serial No. XO2-599.

Lift 1 West

This Quality Assurance (QA) Inspector witnessed final tension verification for bolt connecting Bottom Plate to FL3 at PP 14, PP 15 and PP 16 for Segment Lift 2 West. Inspected 10% on a random basis and found the tension

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to be in general compliance.

Bolt sizes used are M24x60 RC Lot No. DHGM240014 and final Torque required was 567 N-m and

Bolt sizes used are M24x65 RC Lot No. DHGM240009 and final Torque required was 567 N-m.

Manual Torque wrench has been used with Serial No. XO2-599.

Segment 5BE and Segment 5CE

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) for Longitudinal Diaphragm. The weld joint was been performed against B-WR6986 Rev.0. The welder is identified as 062092. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-345-SMAW-4G (4F)-Repair.

Segment 5BW to Segment 5CW

This QA Inspector observed ZPMC welding personnel performing Heat Straightening for Longitudinal Diaphragm Cross Beam side. The Heat Straightening has been performed against HSR1 (B)-7674 Rev.0 for LD 5BW to 5CE.

Segment 5BW

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW). The weld joint was been identified as SSD16-170. The welder is identified as 068764. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-2212-Tc-U4b-F.

Segment 1AAW

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for transverse stiffener which is welded in between the I-Ribs of 1AAW. The weld joint has been identified as OBW1-99 and 100. The welder is identified as 220069. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2133 and WPS-BT-2134.

Segment 5BE

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) for 5BE Deck Panel extension plate connecting to FL3 at PP 34. The weld joint has been identified as OBE5-022 and 023. The welder is identified as 067571. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-2144-Tc-U4b-FCM-1 and WPS-B-P-2114-FCM-1.

Segment 1AAW

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for transverse stiffener which is welded in between the I-Ribs of 1AAW. The weld joint has been identified as

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OBW1-103 and 104. The welder is identified as 220067. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2133 and WPS-BT-2134.

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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