

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-010240**Date Inspected:** 08-Nov-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 Yang 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 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) Assembly Area

Segment 5CE to 6AE

This QA Inspector measured and recorded the dimension along with Mr. Manikandhan for Offset and Mis-alignment for the Closed U-Ribs 39 Nos. for Segment 5CE to 6AE (Shop Weld) between PP 36 and PP 37.

Segment 6AE to 6BE

This QA Inspector measured and recorded the dimension root gap for Segment 6AE to 6BE between PP 40 to PP 41 for Side Panel Bike Path and Cross Beam side and observed readings ranging between 7mm to 9mm. Edge Panel for the Corner Assembly observed a root gap of 12 to 14mm for Bike Path and Cross Beam Side.

Segment 1AW to 1BW

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

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Bottom Panel Transverse Weld UT rejected areas for Segment 1AW to 1BW. The Weld No. is identified as OBW1A-008. Welders were identified as 066326. The welding was been performed against B-CWR875. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-345-SMAW-4G (4F)-FCM-Repair-1. The parameters noted down by QC found in compliance with WPS.

Segment 1AW to 1BW

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) for Bottom Panel Transverse Weld UT rejected areas for Segment 1AW to 1BW. The Weld No. is identified as OBW1A-008. Welders were identified as 037748. The welding was been performed against B-CWR875. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-345-SMAW-4G (4F)-FCM-Repair-1. The parameters noted down by QC found in compliance with WPS.

Segment 1AW to 1BW

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) for Bottom Panel Transverse Weld UT rejected areas for Segment 1AW to 1BW. The Weld No. is identified as OBW1A-008. Welders were identified as 037748. The welding was been performed against B-CWR875. The welding was been performed against B-CWR875. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-345-SMAW-4G (4F)-FCM-Repair-1. The parameters noted down by QC found in compliance with WPS.

Segment 1AW to 1BW

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) for Bottom Panel Transverse Weld UT rejected areas for Segment 1AW to 1BW. The Weld No. is identified as OBW1A-008. Welders were identified as 067589. The welding was been performed against B-CWR875. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-345-SMAW-4G(4F)-FCM-Repair-1. The parameters noted down by QC found in compliance with WPS.

Segment 5CE

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Side Panel to Bottom Panel connecting weld, which was flame cut due to misalignment in the Longitudinal Stiffener Bike Path side for Segment 5CE at PP 36. The Weld No. is identified as Seg026A-008. Welders were identified as 220063. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2231-T-1. The parameters noted down by QC found in compliance with WPS.

Segment 1AAE, 1AE and 1BE

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) for Corner Assembly for Segment 1AAE, 1AE and 1BE. The Weld No. are identified as CA107B-001. Welders were identified as 049769. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-345-SMAW-4G (4F)-FCM-Repair-1 and WPS-345-SMAW-4G

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(4F)-FCM-Repair-1. The parameters noted down by QC found in compliance with WPS.

Lift 2 West

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) for Transverse Segment to Segment Weld for Side Panel Counter Weight side for Segment 2AW to 2BW between PP 16 and PP 17. The Weld No. is identified as OBW2A-003. Welders were identified as 049769. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-345-SMAW-4G (4F)-FCM-Repair-1. The parameters noted down by QC found in compliance with WPS.

Segment 5AW

This QA Inspector observed ZPMC personnel performing Cope Hole radius grinding for the weld connecting the Bottom Panel to Floor Beam at Cross Beam and Counter Weight side for Segment 5BW at PP 31.

Segment 6AE

This QA Inspector observed at Segment 6AE at PP 40 and 6BE at PP 41 Side Panel Cross Beam side Hold back area welding has been performed and grinding has been performed.

Segment 5BW

This QA Inspector observed at Segment 5BW at PP 33 to 34 Cross Beam side for Side Panel to Side Panel Hold back area fillet weld MT test has been performed by ZPMC.

Segment 6BW

This QA Inspector observed at Segment 6BW at PP 41 Hold Back area Side Panel T-Rib Welding has been performed.

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
