

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-010245**Date Inspected:** 07-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

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 6AE

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Partial Height Floor Beam in way of FL3 for Segment 6AE at PP 37, PP 38 and PP 39. The Weld No. are identified as SSD27-PP39 127/128, 131/132 and 141/142. Welders were identified as 222396. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2133. The

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parameters noted down by QC found in compliance with WPS.

Segment 6AE

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Partial Height Floor Beam in way of FL3 for Segment 6AE at PP 37, PP 38 and PP 39. The Weld No. is identified as SSD27-PP39 104. Welders were identified as 062447. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2132. 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 5CE to 6AE

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) for Deck Panel Corner Assembly I Ribs to I Ribs Stiffeners for the Hold Back Area between the Segments 5CE to 6AE between PP 36 to 37. The Weld No. is identified as DP631-001-008. Welders were identified as 066330. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-4114-1. 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 progress.

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 st Side Panel T-Rib grinding has been

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performed to facilitate the welding.

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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