DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-010551
Date Inspected: 06-Dec-2009

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name: Li Yang

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ 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) Trial Assembly Areas

Segment 5CW to 6AW

This Quality Assurance (QA) along with Ct QA Mr. Manikandan has been called for Joint Inspection along with ABF Inspectors for the U-Ribs to U-Ribs for segment 5CW to 6AW between the Panel Point (PP) 36 and PP 37 for all the 39 nos. of U-Rib.

The misalignment for all the U-Rib to U-Rib Left and Right side measured and recorded and the ABF took the details to prepare the formal report and forward to Caltrans via Transmittal.
Segment 6AW to 6BW

This Quality Assurance (QA) along with Ct QA Mr. Manikandan performed Individual Survey for Root Gap and Offset for the following locations.

Deck Panel

Bottom Panel
Side Panel for Cross Beam side
Side Panel for Counter Weight side
Edge Panel for Cross Beam side and
Edge Panel for Counter Weight side

The report was been generated and submitted to Team Leader and Engineer for there review.

Segment 6BE to 6CE

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) and Submerged Arc Welding (SAW) for Deck Panel for Segment to Segment Transverse Splice Weld between PP 43 and PP 44 for Segment 6BE to 6CE. The welder was identified as 220063 and 053742. The Weld joint is identified as OBE6A-002-003-004. In process FCAW and SAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B –T-2232(1)-T-2.

Segment 6BE to 6CE

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Edge Panel Segment to Segment Transverse Splice Weld between PP 43 and PP 44 for Segment 6BE to 6CE. The welder was identified as 0534742 and 067947. The Weld joint is identified as OBE6A-001 and OBE6A-005. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B –T-2233T.

Segment 6BE to 6CE

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Segment to Segment Transverse Splice Weld between PP 43 and PP 44. The welder was identified as 220067 and 220069. The Weld joint is identified as OBE6C-003 for Side Panel to Side Panel Cross Beam Side. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2233T.

Segment 6AW to 6BW

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Bottom Panel to Bottom Panel Transverse Segment Weld between PP 40 and PP 41. The welder was identified as 220063 and 067876. The Weld joint is identified as OBW6A-003. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2231-B-U2a-F.

Segment 5CW to 6AW

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for T-Rib Hold Back areas between PP 36 and PP 37. The welder was identified as 067876 and 067947. The Weld joint is identified as SP-750-001-036/037/038 and 040 and SP-512-001-030/031 and 032 for Side Panel to Side Panel

Cross Beam Side. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2132.

Segment 5CW to 6AW

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for T-Rib Hold Back areas between PP 36 and PP 37. The welder was identified as 066746 and 066674. The Weld joint is identified as SP-147-001-031/032/033 and 034 and SP-120-001-033/034 and 035 for Side Panel to Side Panel Cross Beam Side Counter Weight Side. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2132.

Segment 5CW to 6AW

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) for Deck Panel Corner Assembly I-Rib to I-Rib Counter Weight Side for Transverse Splice Segment between PP 36 and PP 37. The welder was identified as 0667764. The Weld joint is identified as DP622-001-013/014 (for 5CW segment) and DP623-001-007/008 (for 6AW Segment). In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2114-FCM-1.

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:	Miller,Mark	QA Reviewer