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-010599
Date Inspected: 01-Nov-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

CWI Name:	ZPMC and ABF			**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

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. Wai Pau, was present during the times noted above for observations relative to the work being performed.

Bay#2

Floor beam: - Caltrans QA Inspector observed a welder performed FCAW weld repair process on 6mm fillet welds of two floor beams. The floor beams ID are FB3841-001, FB3012-001 and FB6502-001. The FCAW repair fillet welds that attached the stiffeners to base plate which has been rejected by QC VT inspection due to weld profile exceeding AWS code limitations. The FCAW repair fillet weld process is monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

Floor beam: - Caltrans QA Inspector observed ten ZPMC grinders in process of grinding on fillet welds and base plates of ten floor beams. The floor beams are type I and type II. The purpose of grinding is removing the weld profiles prior VT and MT inspection. The grinding process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

Bay#5

Traveler rails: - Caltrans QA inspector observed two ZP MC welders performed FCAW process on the flange to web plate of traveler rail #10TK2-021, 10TR2-022, 11TR3-012 and 11TR3-018. This type component designed has CJP and PJP weld along on one side of full weld length and other side has CJP only. All the welding areas have been pre heating prior FCAW welding. The FCAW process were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA Inspector observations, no discrepancies were noted.

Traveler rails: - Caltrans QA inspector observed two ZPMC workers and one tack weld welder performed fit up and SMAW tack weld process on the flange to web plate of ten traveler rails 10TR3 type and the traveler rails have not been identified by ZPMC at this time. A numerous temporary tack welds have been welded attach to the web after adjusted and secured by template. The fit up and SMAW tack welding process were monitored and recorded by ZPMC and ABF QC inspector. Base on Caltrans QAI observation, no discrepancies were noted.

Traveler rails: - Caltrans QA inspector observed two ZPMC welders performed SMAW repair weld process on twenty- five web plates of traveler rails type 10TR2 and 11TR3. The repair areas are rejected by VT inspection with oxide films and notches which caused by oxyacetylene cutting. The repair areas have been pre-heat prior welding. The SMAW repair process was monitored and recorded by ZPMC and ABF QC inspector. Base on Caltrans QAI observation, no discrepancies were noted.

Bike path: - Caltrans QA inspector observed two ZPMC workers and one welder performed fit up and SMAW tack weld process on the base plate of bike path # BK-001-048, BK-001-049 and BK-001-050. A numerous temporary tack welds have been welded attach to the base plates after adjusted and secured by hand jack. The fit up and SMAW tack welding process were monitored and recorded by ZPMC and ABF QC inspector. Base on Caltrans QAI observation, no discrepancies were noted.

Bay#6

Tower strut: - Caltrans QA Inspector observed two welders performed SMAW critical and noncritical weld repair process on two tower struts. The tower strut welds ID are WD1-A305-65M-3-2A/B and WD1-A305-53M-3-9A/B. The SMAW critical and noncritical repair weld located at web to flange which has been rejected by ZPMC UT testing. The weld repair report number for critical is T-CWR-405 and noncritical is TWR-2586. The SMAW critical and noncritical weld repair is monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As notes within report above.

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 Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Pau,Wai	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer