

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-010602**Date Inspected:** 27-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **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.

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Traveler rails: - Caltrans QA inspector observed fourteen ZPMC welders performed FCAW process on the flange to web plate of traveler rail #11TR1-023, 11TR1-018, 10TR2-003, 10TR1-006, 10TR1-013, 11TR3-016, 11TR2-013, 11TR3-005, 11TR2-014, 11TR1-013, 10TR1-001, 11TR3-015, 11TR1-010, 11TR1-011, 11TR3-026, 11TR2-017 and 11TR2-005. 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 fit up groups performed fit up and SMAW and FCAW tack weld process on the flange to web plate of six 10TR and 11TR type traveler rails. Each group has two workers and one tack weld welder. During observation, 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 and FCAW 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 welders performed carbon arc back gouging process on the flange to web plate of traveler rail. A back gouging is on one side of flange to web of four traveler rails.

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Approximately 8mm sound wall thick has been gouged out. The back gouging area has been re-bevel to request design joint by grinding and the beveled surface is entirely free of the scale, traces of oxide films and other contaminants prior welding. Base on Caltrans observation, no discrepancies were noted.

Traveler rails: - Caltrans QA inspector observed eight workers performed grinding process on CJP and PJP welds of ten traveler rails. The welds are located on the flange to web plate. The grinding purpose is removing the weld profile on the welds prior NDT and visual testing. Based on Caltrans QAI 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
