

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: 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-011069**Date Inspected:** 03-Jan-2010**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, China

CWI Name:	Li Yang and Wu Zhi Cheng	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) Trial Assembly Areas

Segment 6BW to 6CW

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Transverse Splice Weld for Side Panel Corner Assembly Counter Weight Side for Segment 6BW to 6CW. Weld identified as OBW6C-001. The welders are identified as 053609. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2231T-1. It was observed that the root gap was exceeding the requirement of WPS thus ZPMC QC was having Welding Repair Report B-WR9652 Rev.0.

Segment 6CW

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Floor Beam Extension at PP 45 for Segment 6CW. Weld identified as SSD25-PP45-071/072 and 075/076. The welders are identified as 053742. In process FCAW appears to be progressing in compliance with Caltrans Engineer

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Approved welding procedure i.e., WPS-B-T-2231. The parameters recorded by ZPMC QC were in compliance with WPS.

Segment 6BW to 6CW

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Transverse Splice Weld for Side Panel Cross Beam Side for Segment 6BW to 6CW. Weld identified as OBW6C-005. The welders are identified as 200676. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2231T-1. It was observed that the root gap was exceeding the requirement of WPS thus ZPMC QC was having Welding Repair Report B-WR9652 Rev.0.

Segment 6CW

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Floor Beam Extension at PP 45 for Segment 6CW. Weld identified as SSD27-PP45-071/072 and 075/076. The welders are identified as 051246. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2231. The parameters recorded by ZPMC QC were in compliance with WPS.

Segment 6AE to 6BE

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Transverse Splice Weld Side Panel, Cross Beam side for Segment 6AE to 6BE. Weld identified as OBW6C-005. The welders are identified as 220063. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2231T. The parameters recorded by ZPMC QC were in compliance with WPS.

Segment 6BW to 6CW

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Transverse Splice Weld for Bottom Panel for Segment 6BW to 6CW. Weld identified as OBW6C-003. The welders are identified as 220066 and 053609. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2231T-1. It was observed that the root gap was exceeding the requirement of WPS thus ZPMC QC was having Welding Repair Report B-WR9652 Rev.0.

Segment 6AE to 6BE

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Transverse Splice Weld Side Panel Corner Assembly Cross Beam side for Segment 6AE to 6BE. Weld identified as OBW6C-006. The welders are identified as 220063. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2231T. The parameters recorded by ZPMC QC were in compliance with WPS.

Segment 6AW

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This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) for Counter Weight connecting plate for the Segment 6AW. Weld identified as OBW6F-004. The welder was identified as 220066. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2232-Tc-U5-F.

Segment 6BW to 6CW

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Transverse Splice Weld for Deck Panel side for Segment 6BW to 6CW. Weld identified as OBW6A-003. The welders are identified as 220069. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2231T-1. It was observed that the root gap was exceeding the requirement of WPS thus ZPMC QC was having Welding Repair Report B-WR9652 Rev.0.

Segment 5CE

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) at Weld connecting Bottom Panel to Side Panel Bike Path side for Segment 5CE at E3 location. The welder was identified as 054467. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-345-SMAW-4G (4F)-Repair. The repair work was been performed against the ABF RFI no. ABF-RFI-001938 Rev.1.

Segment 6AE to 6BE

This QA Inspector observed ZPMC personnel performing flame cut for the Side Panel Bike path side as distortion was observed at T-Ribs and the work was been performed against Welding Repair Report no. B-WR 9154 Rev. 0.

Segment 6BW to 6CW

This QA Inspector observed ZPMC personnel at Segment 6BW to 6CW misalignment of T-Ribs on Cross Beam side reached 5 ~ 16mm and Butt assembly gap was 8mm to 14mm I-Ribs hold back areas weld been removed and the work is performed against B-WR9666.

Segment CB5

This QA Inspector observed ZPMC personnel at CB5 connecting 6AW to 6AE deck panel FL3 extension to CB5 connection drilled splice plate placed all around the Cross Beam and match drilling is in progress at all the locations.

Segment 6AW

This QA Inspector observed ZPMC personnel at Segment 6AW Upper Chevron on PP 40 Turn of Nut is progress.

Segment 5BW to 5CW

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This QA Inspector observed ZPMC personnel at Segment 5BW to 5CW at PP 34 to PP 35 grinding was in progress on Longitudinal Diaphragm to Bottom Panel weld.

Segment 7AE to 6CE

This QA Inspector observed ZPMC personnel at 7AE to 6CE between PP 48 and PP 49 fit-up is in progress and segment to segment flame cutting for bevel preparation for Side Panel Cross Beam side.

CB6

This QA Inspector observed ZPMC personnel at CB6 fit-up with Segment 6CW to 6CE was in progress between PP 44, PP 45 and PP 46.

Segment 6BE to 6CE

This QA Inspector observed ZPMC personnel at 6BE to 6CE between PP 43 and PP 44 U-Ribs to U-Ribs internal side splice plate installation was in progress for match drilling.

Segment 6AE

This QA Inspector observed ZPMC personnel at 6BE to 6CE between PP 43 and PP 44 U-Ribs to U-Ribs internal side splice plate installation was in progress for match drilling.

Segment 5BE to 5CE

This QA Inspector observed ZPMC personnel at 5BE to 5CE between PP 31 and PP 32 for Transverse Splice weld for Deck Panel Magnetic Particle Test (MT) is been performed by ZPMC.

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:	Miller,Mark	QA Reviewer
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