

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-011138**Date Inspected:** 04-Dec-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**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 #6

Floor Beam: - Caltrans QA inspector performed final dry MT inspection on fillet welds of floor Beam plates. The floor Beam plate welds ID are BP3001-001-117~118/103~114/091~102, BP-3016-017-001/002 and BP3012-017-001-002. The welds for dry MT inspection have been accepted by ZPMC prior Caltrans QA inspection. Base on Caltrans MT inspection, the welds appeared to be in compliance with requirements of AWS D1.5 2002 and Caltrans contract documents.

Bay #3

Longitudinal diaphragm: - Caltrans QA Inspector observed two welding operators performed SAW process on CJP weld on the longitudinal diaphragm plate. The CJP weld number is LD3021-001-025 and LD3032-001-010. The SAW welding was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

Bay #2

Longitudinal diaphragm: - Caltrans QA Inspector observed a welder performed SMAW weld repair process on fillet welds of two longitudinal diaphragm plates. The longitudinal diaphragms ID are LD3014A, and LD3008A. The SMAW 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

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and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

Floor beam type 1:- Caltrans QA inspector observed one ZPMC welders performed FCAW repair fillet weld process on stiffeners for type-1 of floor beams #FB-3006-001 and FB-3004-001. 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 fillet welds process were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA Inspector observations, no discrepancies were noted.

Bay#5

Traveler rail: - Caltrans QA inspector observed seven ZPMC welders performed FCAW process on the flange to web plate of traveler rail #11TR3-005, 11TR3-016, 11TR2-007, 11TR2-006, 10TR3-006, 10TR3-003, 11TR1-016 and 11TR1-017. 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.

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
