

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-012014**Date Inspected:** 14-Feb-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**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 Trial 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

Lift 6 East

This QA Inspector observed ZPMC welding personnel performing welding by Shielded Metal Arc Welding (SMAW) for weld connecting Deck Panel to Edge Panel Bike Path side. The weld joints are identified as CA 026-002. The welder is identified as 058087. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-345-SMAW-2G (2F)-FCM-Repair-1. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS. The welding was been performed against the Critical Welding Repair report B-CWR 1092 Rev 1.

Lift 6 East

This QA Inspector observed ZPMC welding personnel performing welding by Shielded Metal Arc Welding (SMAW) for weld connecting Deck Panel to Edge Panel Bike Path side. The weld joints are identified as CA 026-004. The welders are identified as 049339 and 048047. In process SMAW appears to be progressing in

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compliance with Caltrans Engineer Approved welding procedure i.e., WPS-345-SMAW-2G (2F)-FCM-Repair-1. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS. The welding was performed against the Critical Welding Repair report B-CWR 1092 Rev 1.

7BW to 7CW

This QA Inspector observed ZPMC welding personnel performing welding by Shielded Metal Arc Welding (SMAW) for weld connecting Edge Panel Counter Weight side for Transverse Splice Weld. The weld joints are identified as OBW7A -006. The welder is identified as 069683. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-2214-B-U2-FCM-1. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

7BW to 7CW

This QA Inspector observed ZPMC welding personnel performing welding by Shielded Metal Arc Welding (SMAW) for weld connecting Edge Panel Cross Beam side for Transverse Splice Weld. The weld joints are identified as OBW7A -010. The welder is identified as 068917. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-2214-B-U2-FCM-1. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

6CE

This QA Inspector observed ZPMC welding personnel performing repair welding by Flux Cored Arc Welding (FCAW) for weld connecting Longitudinal Diaphragm to Floor Beam excavated weld due to Ultrasonic rejected areas. The weld joint was identified as Seg032F-013. The welder is identified as 220066. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-345-FCAW-3G (3F)-FCM-Repair-1. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

6AW

This QA Inspector observed ZPMC welding personnel performing repair welding by Flux Cored Arc Welding (FCAW) for weld connecting Edge Panel vertical T-Stiffeners which were removed from location due to misaligned drilling during fabrication between Edge Panel T-Rib to Deck Panel I-Rib Cross Beam side. The welding was in progress against the B-WR9848 Rev.0. The welder is identified as 066673. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-345-FCAW-3G (3F)-FCM-Repair-1. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

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

Summary of Conversations:

No relevant conversations.

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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 T Sang 1500-0042-2372, 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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