

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-012073**Date Inspected:** 28-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**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.

Traveler rail: - Caltrans QA inspector observed two ZPMC welders performed FCAW repair weld process on the flange to web of traveler rail # 10TR3-037, 11TR3-027 and 10TR3-034. The repair areas are located at top and bottom flanges to web and total fifteen spots and length for 10mm to 180mm. All of repair areas have been pre heating prior FCAW repair welding. The FCAW repair process were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA Inspector observations, no discrepancies were noted.

Traveler rail: - Caltrans QA inspector observed two ZPMC welders performed SMAW build up weld metal (buttering) process on the flange of traveler rail #11TR2-005, 11TR2-003 and 11TR1-004, The buttering areas are located both ends of top and bottom flanges. The buttering size is along the both edge ends of flanges with 10mm width. All of buttering areas have been pre heating prior SMAW welding. The SMAW process were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA Inspector observations, no discrepancies were noted.

OBG deck panel: - Caltrans QA Inspector observed two ZPMC welders in process fit up and SMAW tack welding on two deck panels. The deck panels and weld ID are DP3051A, DP3052A and 12BW-SEG3005-008. A numerous temporary tack welds have been welded attach to the two deck panels after has been secured. All the tack weld areas have been pre heat with heating torches. Base on Caltrans observation, no discrepancies were noted.

OBG 12AE segment: - Caltrans QA Inspector observed ZPMC three workers and two welders in process fit up and SMAW tack welding on floor beams of OBG segment 12AE. One floor beam FR-1 attached to one FR-E located at the PP111 tube section. A numerous temporary tack welds have been welded attach to the floor beams

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

after has been secured. All the tack weld areas have been pre heat with heating torches. Base on Caltrans observation, no discrepancies were noted.

OBG 12BE segment: - Caltrans QA Inspector observed ZPMC three workers and one welder in process fit up and SMAW tack welding on floor beams of OBG segment 12BE. The floor beam #FB3015-003 attached to bottom plate and located at the PP115 tube section. A numerous temporary tack welds have been welded attach to the floor beams after has been secured. All the tack weld areas have been pre heat with heating torches. Base on Caltrans observation, no discrepancies were noted.

CLOSING STATEMENT

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
---------------------	-------------------	-------------