

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-012208**Date Inspected:** 20-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

Segment 6CW to 7AW (Longitudinal Diaphragm) Joint Survey

This QA Inspector performed Joint Inspection with ZPMC Survey Team and ABF Survey Team for the Longitudinal Diaphragm between Segment 6CW to 7AW (Field Segment Splice) between Panel Point (PP) 47 and PP 48 North (Counter Weight Side) and South (Cross Beam Side) for Offset and Sweep. The offset was measured at 5 (five) different locations in which 2 (Two) locations were at Flange area and 3 (Three) locations were at Web area and Sweep was measured at 100 mm from both side from the Floor Beam and 800mm from both side of floor Beam and at Centre (Total 5 Locations). The measured readings were recorded on spread sheet, generated the report and submitted to the Task Leader and Engineer for review.

Segment 7AW to 7BW (T-Ribs) Caltrans QA Survey Inspection

This QA Inspector performed along with Caltrans QA Mr. Vikram Singh performed Individual Inspection for the T-Ribs to T-Ribs between Segment 7AW to 7BW (Shop Segment Splice) between Panel Point (PP) 49 and PP 50

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North(Counter Weight Side total 19 Nos. T-Ribs) and South (Cross Beam side Total 19 Nos. T-Ribs) and at Bottom Panel (Total 18 Nos. T-Ribs) for Horizontal and Vertical Offset. The measured readings were recorded on spread sheet, generated the report and submitted to the Task Leader and Engineer for review, for more comprehensive details please refer the pictures attached below.

7AW to 7BW

This QA Inspector observed ZPMC welding personnel performing repair welding by Shielded Metal Arc Welding (SMAW) for I-Ribs to I-Ribs Side Panel Corner Assembly Cross Beam side. The weld joint was identified as SP429-001-035 and SP429-001-035. 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.

7AW to 7BW

This QA Inspector observed ZPMC welding personnel performing repair welding by Shielded Metal Arc Welding (SMAW) for I-Ribs to I-Ribs Side Panel Corner Assembly Counter Weight side. The weld joint was identified as SP437-001-031 and SP437-001-032. 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.

6CW

This QA Inspector observed ZPMC welding personnel performing repair welding by Shielded Metal Arc Welding (SMAW) for Counter Weight Connection Plate. The weld joint was identified as OBW6F-009. The welder is identified as 062092. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-2214-Tc-U4b-FCM-1. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

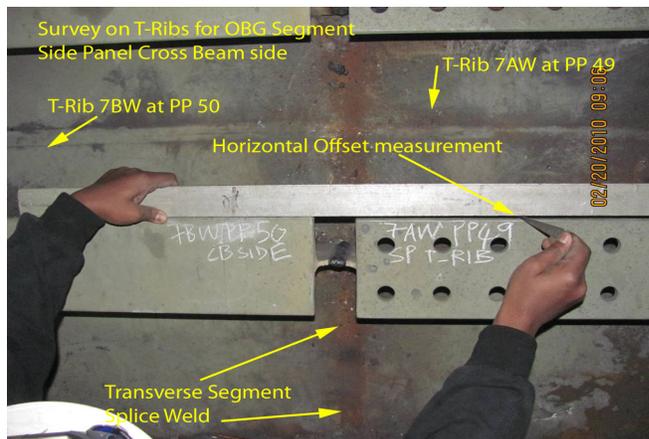
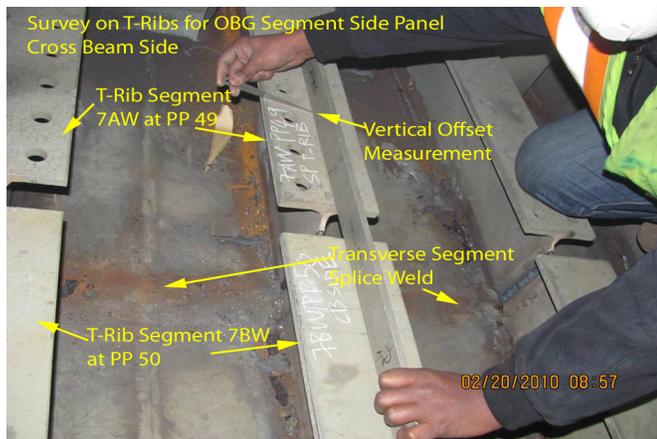
6BW

This QA Inspector observed ZPMC welding personnel performing repair welding by Shielded Metal Arc Welding (SMAW) for Counter Weight Connection Plate. The weld joint was identified as OBW6F-007. The welder is identified as 066261. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-2214-Tc-U4b-FCM-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.

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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 Eric T Sang 1500-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Math,Manjunath

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer