

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-012441**Date Inspected:** 07-Mar-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 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 (Lower Chevron X3D)

This Quality Assurance (QA) Inspector witnessed final tension verification for Lower Chevron X3D Angle (North and South side) at Panel Point (PP) 45, PP 46 and PP 47 for Segment 6CW. Inspected 10% on a random basis and found the Rotation of Nut to be in general compliance. Inspection was performed against the Notification No. 00272 Dated March 07, 2010.

Bolt sizes used were M22 x 65 RC Set# DHGM220033 and final torque required was Rotation of Nut.

Segment 7AW to 7BW (U-Ribs)

This QA Inspector performed Survey Inspection for the U-Ribs to U-Ribs (Total 39 nos.) for Segment 7AW to 7BW (Shop Segment Splice) between Panel Point (PP) 49 and PP 50 from North towards South side i.e., from Counter Weight side to Cross Beam Side. Report forwarded to team leader for further action.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Added the information in the punch list to identify the locations where shims to be installed and where Reinforcing Splice Plate to be installed.

Segment 6AW

This QA inspector observed ZPMC qualified welding personnel identified as 058102 performing buttering by Shielded Metal Arc Welding (SMAW). PMCK identified as FL3 Stiffener welded at skin. ZPMC QC is identified as Mr. Feng Ya Jung. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-FCAW-2G (2F)-FCM-Repair-1. The Welding Repair Report (WRR) was B-WR10880 Rev.0. Please refer the pictures attached for more comprehensive detail taken at PP 38.

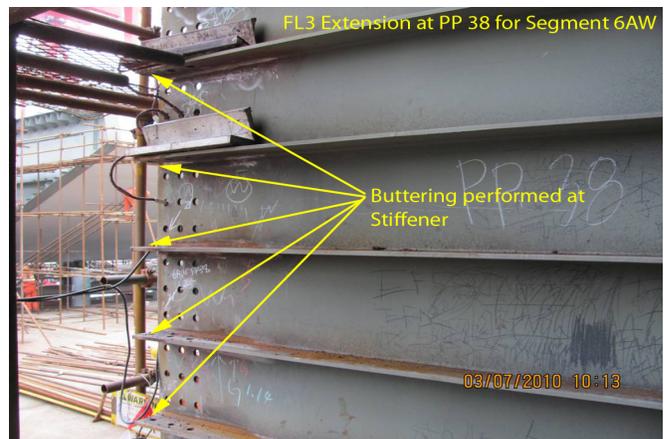
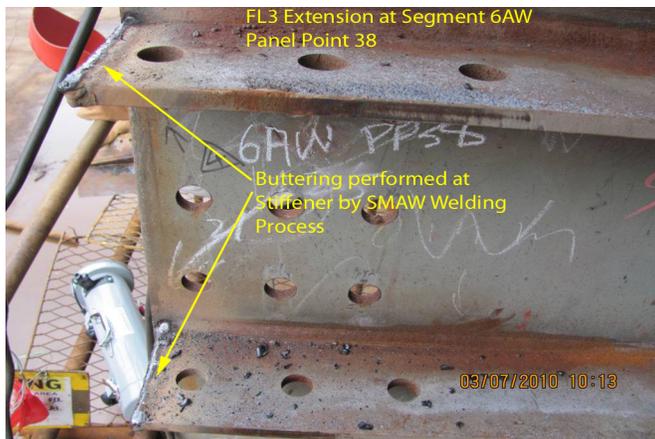
Segment 6CW

This QA inspector observed ZPMC qualified welding personnel identified as 058102 performing buttering by Shielded Metal Arc Welding (SMAW). PMCK identified as FL3 Stiffener welded at skin. ZPMC QC is identified as Mr. Feng Ya Jung. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-FCAW-2G (2F)-FCM-Repair-1. The Welding Repair Report (WRR) was B-WR10880 Rev.0.

Segment 6CE and 6CW

This QA inspector observed ZPMC qualified welding personnel identified as 053753 performing repair welding by Shielded Metal Arc Welding (SMAW). Weld joints are identified as FB027-001-128, FB028-001-128, FB031-001-128 and FB035-001-128. ZPMC QC is identified as Mr. Wang Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-FCAW-2G (2F)-FCM-Repair-1.

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



WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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
