

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-015797**Date Inspected:** 06-Jul-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:** 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 13 section**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 #14

Caltrans QA inspector observed a fit up groups performed fit up and SMAW tack weld process on T-joint stiffeners fillet weld. The fillet weld is attached to two angle plates with 45mm wall thick. The angle plate is section #14 mock up. The angle plates have been fit up are SA3348D, SA3349E/F and SA3354E. A numerous temporary tack welds have been welded attach between angle plate and stiffeners after adjusted and secured by hand jack. The fit up SMAW tack welding process were monitored and recorded by ZPMC and ABF QC inspector. Base on Caltrans QAI observation, no discrepancies were noted.

Caltrans QA inspector observed two fit up groups performed fit up and SMAW tack weld process on T-joint fillet weld. The T-joint is attached to stiffeners and side plate (SP) with plate 18mm and 25mm wall thick. The side plate and plate ID are # SP3102A/PL3394A and SP3575A/PL3255A, SP3071A/PL3251A of 13AE and 13CE section. A numerous temporary tack welds have been welded attach between plate and stiffeners after adjusted and secured by hand jack. The fit up SMAW tack welding process were monitored and recorded by ZPMC and ABF QC inspector. Base on Caltrans QAI observation, no discrepancies were noted.

Caltrans QA Inspector observed two welding operator in process of semi-automatic SAW on CJP weld. The CJP weld is butt joint and attached plate to plate with 25mm wall thick of longitudinal diaphragms (LD) section of east line. The weld number is LD3036-001-002 and LD3035-001-001. The semi-automatic SAW process was

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

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

Bay#16

Caltrans QA Inspector observed a welding operator in process of semi-automatic SAW on CJP butt joint weld. The CJP weld is attached to 60mm wall thick base plate of 13AW section of west line. This section is a SPM member. The weld number and plate number are BP3073-001-002/PL3364B and PL3365B (side A). The minimum preheat for SPM member CJP weld is 160C degree. The semi-automatic SAW process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI 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 James Devey 15000026784 , who represents the Office of Structural Materials for your project.

Inspected By:	Pau, Wai	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
