

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-015799**Date Inspected:** 11-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 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 # SP3103A/PL3295A, SP3071A/PL3251A and SP2099A/PL3391B of 13AE and 13AW 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 ABF survey group performed survey on the bolt hole lines of 100mm welded bottom plate. The bottom plates ID are PL3366C, PL3365C, PL3364C, PL3363C, PL3362C and PL3361C. All the survey check can't complete today and continue tomorrow. 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 LD3033-001-001 and LD3031-001-004. The semi-automatic SAW process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

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Caltrans QAI observed two ZPMC heat straightening operators performed heat straightening on the section 14 angle plate mock up with ZPMC Heat Straightening Report. The angle plate mock up ID are SA3348C, SA3350A/B/D, SA3355B/C. The heating temperature is maximum 650 C (1200 F) and cool in still air. The steel plate flatness offset from 0.1mm to 0.4mm. All the plates for heat straightening have been inspected and recorded by ZPMC QC. Based on Caltrans QAI observation, no discrepancies were noted.

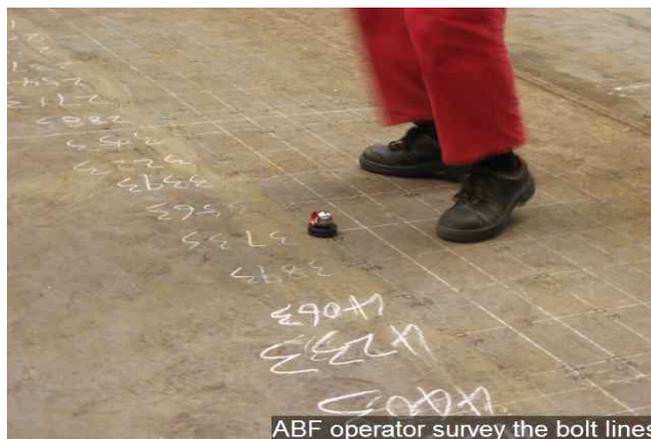
Bay #15

Caltrans QA Inspector observed a ZPMC operator performed machining process on the surface of base plate. The machining surface is designed to attach to bearing component. Total 5mm metal has been removed from the surface. ZPMC operator informed Caltrans QA that surface has 1mm left for machining. The machining was 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 100mm wall thick base plate (BP) of 13AW section of west line. This section is a SPM member. The weld number and plate number are BP3074-001-004/PL3365C and PL3364C (side B). 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.

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