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 #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-016055
Date Inspected: 04-Aug-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name:	Zhu Zhong Hai			**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 Mr. 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 9CW to Segment 9DW

This QA Inspector performed Dimension Control Inspection for measuring Offset along with ABF QA personnel on the U-Rib to U-Rib from Counter Weight side to Cross Beam side at a total of 39 locations on Segment 9CW to Segment 9DW between Panel Point (PP) 79 to PP 80 at the following locations:

The offset was measured within 50mm from the Deck Panel on U-Rib on the South and North side. The QA Inspector measured the Offset using 1(One) Meter Straight Edge.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

Segment 9AW

This QA Inspector performed Green Tag Dimension Control Inspection along with ABF QA personnel for the Segment 9AW from Panel Point (PP) 72 to PP 73 at the following locations:

The Floor Beam (FB) flatness was verified and measured from East and West side of the FB at Panel Points (PP) 72 and PP 73. The QA Inspector measured the flatness using 1500mm Straight Edge.

The Deck Panel to the Deck Panel Diaphragm plate plumbness and flatness was verified and measured from east and west side of the Deck Panel Diaphragm at Panel Points (PP) 72 and PP 73. The QA Inspector measured the plumbness using carpenter square and performed a flatness check using 710mm Straight Edge.

Segment 9DW to Segment 9EW

This QA Inspector observed the in process fillet welding operation by the Flux Cored Arc Welding (FCAW) process. The Weld joint was designated as BP154-001-020, BP154-001-022 and BP154-001-024. The welder identification was 040609 and was observed welding in the 3F (Vertical) position using approved Welding Procedure Specification WPS-B-T-2233-B-U2-F. The piece mark was identified as the Bottom Panel T-Ribs, hold back area.

Segment 9DW to Segment 9EW

This QA Inspector observed the in process fillet welding operation by the Flux Cored Arc Welding (FCAW) process. The Weld joint was designated as BP100-001-020, BP154-001-026 and BP154-001-030. The welder identification was 202384 and was observed welding in the 3F (Vertical) position using approved Welding Procedure Specification WPS-B-T-2233-B-U2-F. The piece mark was identified as the Bottom Panel T-Ribs, hold back area.

Segment 9DW to Segment 9EW

This QA Inspector observed the in-process welding by Shielded Metal Arc Welding (SMAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as SP108-001-051, SP108-001-053, SP108-001-055, SP108-001-57, SP108-001-59 and SP108-001-61. The welder identification was 066038 and was observed welding in the 4G (Overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1. The piece mark was identified as the Side Panel T-Ribs web to web, Counter Weight side. Please reference the pictures attached for more comprehensive details.

Segment 9CW

This QA Inspector observed the in process fillet welding operation by the Flux Cored Arc Welding (FCAW) process. The Weld joint was designated as SP493-001-029/30, SP493-001-030/031 and SP493-001-032/033. The welder identification was 046706 and was observed welding in the 2F (Horizontal) position using approved Welding Procedure Specification WPS-B-T-2132. The piece mark was identified as the Side Panel T-Ribs hold back area, Cross Beam side.

Segment 9DW

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

This QA Inspector observed the in process fillet welding operation by the Flux Cored Arc Welding (FCAW) process. The Weld joint was designated as SP494-001-036/037 and SP494-001-038/039. The welder identification was 046706 and was observed welding in the 2F (Horizontal) position using approved Welding Procedure Specification WPS-B-T-2132. The piece mark was identified as the Side Panel T-Ribs hold back area, Cross Beam side.

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

Summary of Conversations:

No relevant conversations were reported on this date.

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 150000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Math,Manjunath	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer