

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023365**Date Inspected:** 14-May-2009**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:** Shen Fu Yoo**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:

BAY 14

Orthotropic Box Girder (OBG)

This QA Inspector observed ZPMC welding personnel performing Submerged Arc Welding (SAW) with ceramic backing for Deck Panel for Segment 7CW. The weld joint no. SEG037*-004 is in progress. The welder is identified as 045265. Welder was welding in 1G (Flat) position. In process SAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-223(1)2-T-1.

This QA Inspector observed ZPMC welding personnel performing Submerged Arc Welding (SAW) for Side Panel between SP 109A to SP136A for Segment 9EW. The weld joint no. SEG-057A-002 is in progress. The welder is identified as 250050. Welder was welding in 1G (Flat) position. In process SAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2231-B-L2C-S-2.

This QA Inspector observed ZPMC welding personnel performing Submerged Arc Welding (SAW) for Side Panel between SP 347A to SP320A for Segment 9CE. The weld joint no. SEG-054A-009 is in progress. The welder is

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identified as 044755. Welder was welding in 1G (Flat) position. In process SAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2231-B-L2C-S-2.

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Deck Panel Diaphragms for Segment 6AW. The weld joint no. SSD9-PP037-003 and 004 is in progress. The welder is identified as 006401. Welder was welding fillet in 2F (Horizontal) position. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2132.

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Deck Panel Diaphragms for Segment 6AW. The weld joint no. SSD11-PP039-003 and 004 is in progress. The welder is identified as 045240. Welder was welding fillet in 2F (Horizontal) position. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2132.

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Deck Panel Diaphragms for Segment 6AW. The weld joint no. SSD12-PP040 004 and 005 is in progress. The welder is identified as 201215. Welder was welding fillet in 2F (Horizontal) position. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2132.

BAY 19

Suspender Bracket

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Suspender Bracket. The weld joint no. SB003 024 and 025 is in progress. The welder is identified as 062756. Welder was welding fillet in 2G (Horizontal) and 2F (Horizontal) position. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2232-Tc-U5F and WPS-B-P-2132.

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Suspender Bracket. The weld joint no. SB3-SB-28W 001 and 019 is in progress. The welder is identified as 062763. Welder was welding fillet in 3G (Vertical) and 3F (Vertical) position. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2232-Tc-U5F and WPS-B-P-2133.

The designated ZPMC CWI for the West Line is Mr. Shen Fu Yoo and QC Mr. Li Ming Yang, Mr. Liu Wan Ning and Mr. Liu Rudan for Bay 14.

The designated ZPMC CWI for the West Line is Mr. Liu Fawen and QC Mr. Zhou Cheng and Mr. Shen Jian Guo for Bay 19.

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

Summary of Conversations:

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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 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Math,Manjunath	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
