

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-023369**Date Inspected:** 20-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) for Deck Panel to Corner Assembly DP 85A to CA 27A for Segment 6BW. The weld joint no. SEG029-007 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-2231-B-L2C-S-2.

This QA Inspector observed ZPMC welding personnel performing Submerged Arc Welding (SAW) for Side Panel between SP 349A to SP 322A for Segment 9EE. The weld joint no. SEG058A-009 is in progress. The welder is 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 Side Panel between SP 108A to SP 135A for Segment 9DW. The weld joint no. SEG 055-001 is in progress. The

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welder is identified as 045203. Welder was welding in 1G (Flat) position. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2231-B-U2-F.

This QA Inspector observed ZPMC welding personnel performing Submerged Arc Welding (SAW) for Bottom Panel between BP 102A to BP 048A for Segment 10AW. The weld joint no. SEG 059A-005 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 Shielded Metal Arc Welding (SMAW) for Deck Panel to Corner Assembly DP 84A to CA 25A for Segment 6AW. The weld joint no. SEG 027*-031 is in progress. The welder is identified as 037723. Welder was welding in 1G (Flat) position. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-2214-B-U2-FCM.

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Deck Plate Diaphragm Floor Beam for Segment 6AW. The weld joint no. SSD11-PP39-001 and 008 is in progress. Welder is identified as 045240. Welder was welding CJP in 3G (Vertical) position. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2233-B-U2.

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Deck Plate Diaphragm Floor Beam for Segment 6CW. The weld joint no. SSD10-PP44-003 is in progress. Welder is identified as 066401 and 066751. Welder was welding CJP in 2G (Horizontal) position. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2132-Tc-U4b-F.

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Corner Assembly Edge Plate for Segment 6CW. The weld joint no. SSD21-PP46.5-147 and 140 is in progress. Welder is identified as 204730. Welder was welding Fillet in 2F (Horizontal) and 3F (Vertical) position. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2132 and WPS-B-T02133.

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.

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

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