

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023384**Date Inspected:** 10-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 Flux Cored Arc Welding (FCAW) for Unequal Angle to Bottom Plate for Segment 6AW. The weld joint no. SSD-029-PP54.5 from 133 to 140 is in progress. The welder is identified as 066401. Welder was welding Fillet in 2F (Horizontal) and position 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-T-2133.

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Unequal Angle to Bottom Plate for Segment 7DW. The weld joint no. SSD-022-PP57.5 from 004 and 005 is in progress. The welder is identified as 037840. 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 Unequal

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Angle to Bottom Plate for Segment 7EW. The weld joint no. SSD-041A-PP59.5 from 007 and 008 is in progress. The welder is identified as 037840. 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 Submerged Arc Welding (SAW) with ceramic backing for Deck Panel for Segment 6AW. The weld joint no. SEG027*-034 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 Flux Cored Arc Welding (FCAW) with ceramic backing for Deck Panel for Segment 6BW. The weld joint no. SEG029*-028 is in progress. The welder is identified as 050316. 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-223(1)2-T-1.

This QA Inspector observed ZPMC welding personnel performing Submerged Arc Welding (SAW) for Side Plate between SP 346A to SP 373A for Segment 9BE. The weld joint no. SEG-052A-002 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-2221-B-L2c-S.

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) for Lifting Lugs for Segment 7DW. The weld joint no. SSD10-PP056-258 and 259 is in progress. The welder is identified as 066038. Welder was welding CJP in 4G (Overhead) position. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-4214-Tc-U4c-F.

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) for Lifting Lugs for Segment 7CW. The weld joint no. SSD14-PP055-252, 258, 242 and 248 is in progress. The welder is identified as 066326. Welder was welding CJP in 4G (Overhead) position. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-4214-Tc-U4c-F.

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) for Side Plate SP575-001 for Segment 9BW. The weld joint no. SP575-001 from 065 to 069 is in progress. The welder is identified as 037996; 067610 and 067764. Welder was welding in 4G (Overhead) position. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-2214-B-U2.

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) for Longitudinal Diaphragm for Segment 6CW. The weld joint no. SEG-031F-006 is in progress. The welder is identified as 201215. Welder was welding CJP in 4G (Overhead) position. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-2214-TC-U4b.

This QA Inspector observed ZPMC welding personnel performing Submerged Arc Welding (SAW) for Deck Plate between DP 220A to DP 247A for Segment 6BW. The weld joint no. SEG-029*-028 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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Side Plate between SP 107A to SP134A for Segment 9CW. The weld joint no. SEG-053A-002 is in progress. The welder is identified as 207465. 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.

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.

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.

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