

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017645**Date Inspected:** 29-Oct-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)**Location:** Shanghai, China**CWI Name:** Li Yang and 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) at Trial Assembly Areas

Bike Path at Bay # 11

This QA Inspector performed Dimension Control Inspection on the Bike Path bottom panel for flatness check and bike path identified as BK004A-017 and BK004A-021.

The QA Inspector measured the flatness using 1500mm long straight edge and observed flatness dimensions within the allowable tolerances.

The results of the inspection were informed to Caltrans Lead Inspector Mr. Hiranch Patel.

Bike Path at Bay # 19

This QA Inspector performed Dimension Control Inspection on the Bike Path bottom panel for flatness check and bike path identified as BK004A-001.

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The QA Inspector measured the flatness using 1500mm long straight edge and observed flatness dimensions out of tolerance.

The results of the inspection were informed to Caltrans Lead Inspector Mr. Hiranch Patel and ABF Mr. Peter Shaw.

Lift 10 East (X37B Brackets)

This QA Inspector performed Dimension Control Inspection on October 23, 2010 for the Segment 10AE, Segment 10BE and Segment 10CE. Measured the distance between road barrier bolt hole drilled at X37B from deck panel to the cope hole at X37B bracket installed at Corner Assembly at east and west side of the X37B brackets. Identified the locations where dimension is out of tolerance and needs retro-fits.

Visual inspection was performed as on date i.e., October 29, 2010 to verify the installation of retro-fits at following locations.

At Panel Points(PP) 85.25, Bike Path side.

At Panel Points(PP) 86.25, Cross Beam side.

At Panel Points(PP) 88.75, Cross Beam side.

At Panel Points(PP) 89.75, Cross Beam side.

At Panel Points(PP) 90.25 and PP 90.75, Cross Beam side.

At Panel Points(PP) 90.75, Bike Path side.

At Panel Points(PP) 91.25 and PP 91.75, Cross Beam side.

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.

Please reference the pictures attached for more comprehensive details.

Segment 11CW

This QA Inspector observed the in-process welding by Flux Cored Arc Welding (FCAW) process on a fillet weld. The Weld joint was designated as EP121-001-005/006. The welder identification was 062935 and observed welding in the 4F (Overhead) position using approved Welding Procedure Specification WPS-B-T-2134. The piece mark was identified as the Edge Panel, I-Rib hold back weld Counter Weight side.

Segment 11CW

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This QA Inspector observed the in-process welding by Flux Cored Arc Welding (FCAW) process on a Complete Joint Penetration (CJP) groove weld. The weld joint was designated as Seg069C-006. The welder identification was 040609 and observed welding in the 2G (Horizontal) position using approved Welding Procedure Specification WPS-B-T-2232-B-U2-F. The piece mark was identified as Longitudinal Diaphragm flange weld connecting floor beam at work point W4.

Segment 11BW

This QA Inspector observed the in process fillet weld repair welding by Flux Cored Arc Welding (FCAW) process. The Weld joint was designated as DP692-001-017/018. The welder identification was 040611 and observed welding in the 4F(Overhead) position using approved Welding Procedure Specification WPS-B-T-4114. The piece mark was identified as Deck Panel I-Rib hold back weld, Cross Beam side.

Segment 11CW

This QA Inspector observed the in-process welding by Flux Cored Arc Welding (FCAW) process on a Complete Joint Penetration (CJP) groove weld. The weld joint was designated as Seg069C-022. The welder identification was 040609 and observed welding in the 2G (Horizontal) position using approved Welding Procedure Specification WPS-B-T-2232-B-U2-F. The piece mark was identified as Floor Beam stiffener to longitudinal diaphragm flange at work point W4.

Please reference the pictures attached for more comprehensive details.

Segment 11CW

This QA Inspector observed the in process fillet weld repair welding by Flux Cored Arc Welding (FCAW) process. The Weld joint was designated as DP693-001-011/012. The welder identification was 040611 and observed welding in the 4F(Overhead) position using approved Welding Procedure Specification WPS-B-T-4114. The piece mark was identified as Deck Panel I-Rib hold back weld, Cross Beam side.

Segment 11CW

This QA Inspector observed the in-process welding by Flux Cored Arc Welding (FCAW) process on a Complete Joint Penetration (CJP) groove weld. The weld joint was designated as Seg069B-001. The welder identification was 040609 and observed welding in the 2G (Horizontal) position using approved Welding Procedure Specification WPS-B-T-2232-B-U2-F. The piece mark was identified as Longitudinal Diaphragm flange weld connecting floor beam at work point W3.

Segment 11CW

This QA Inspector observed the in-process welding by Flux Cored Arc Welding (FCAW) process on a Complete Joint Penetration (CJP) groove weld. The weld joint was designated as Seg069B-007. The welder identification was 040609 and observed welding in the 2G (Horizontal) position using approved Welding Procedure Specification WPS-B-T-2232-B-U2-F. The piece mark was identified as Floor Beam stiffener to longitudinal

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diaphragm flange at work point W3.

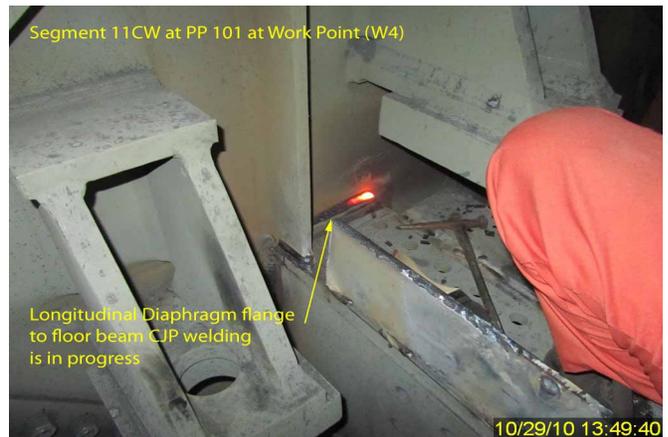
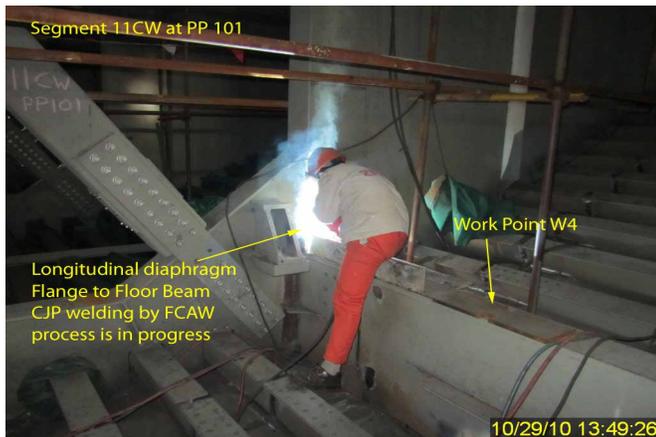
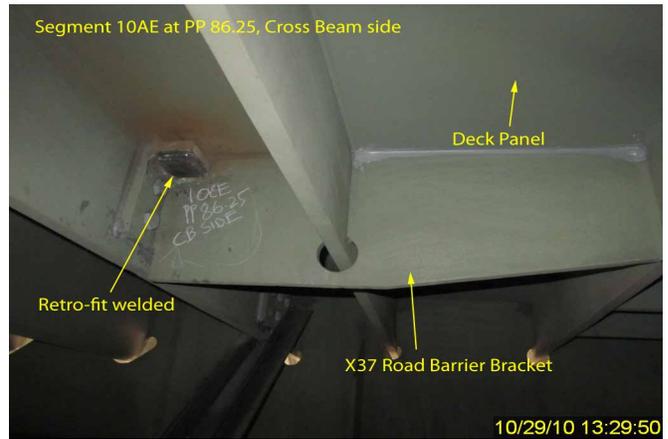
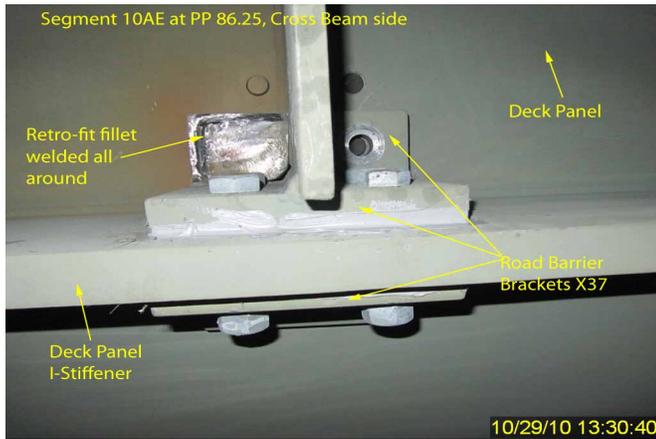
Segment 11BW

This QA Inspector observed the in-process welding by Flux Cored Arc Welding (FCAW) process on a fillet weld. The Weld joint was designated as EP120-001-010/011. The welder identification was 062935 and observed welding in the 4F (Overhead) position using approved Welding Procedure Specification WPS-B-T-2134. The piece mark was identified as the Edge Panel, I-Rib hold back weld Counter Weight side.

Segment 11BW to Segment 11CW

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 SP742-001-047. The welder identification was 046704 and observed welding in the 3G (Vertical) position using approved Welding Procedure Specification WPS-B-P-2213-B-U2-FCM-1. The piece mark was identified as the Side Panel, T-Rib splice weld.

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



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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:	Dsouza,Christopher	QA Reviewer
