

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-018299**Date Inspected:** 26-Nov-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), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**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 Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. M. Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # TRIAL ASSEMBLY YARD (11CW-11DW)

This QA Inspector along with QA Inspector Mr. Manjunath S Math performed dimensional joint survey inspection after adjustment on the WT stiffeners to verify the offset using 1000mm straight edge and bridge cam gauge. The measurements were recorded on a separate sheet and forwarded to team leader for review and disposition. The segment and panel point designations were as follows:

Segment 11CW to Segment 11DW – PP 103 to PP 104

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (11DW)

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 044 in the (1G) flat position on side and bottom panel piece mark no. SEG071A. The location was the complete joint penetration groove weld joining side and bottom panel of segment 11DW at work point W3. The welder ID was 046709. The welding was performed against welding repair report B-WR17735 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1.

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For additional information please reference the pictures below:

OBG # TRIAL ASSEMBLY YARD (11EW)

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 013 in the (4G) overhead position on side and bottom panel piece mark no. SEG073A. The location was the complete joint penetration groove weld joining side and bottom panel of segment 11EW at work point W3. The welder ID was 040611. The welding was performed against welding repair report B-WR17735 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

OBG # TRIAL ASSEMBLY YARD (11DE-11EE)

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 009 in the (3G) vertical position on side panel piece mark no. OBE11C. The location was the transverse splice weld joining segment 11DE and 11EE at bike path side. The welder ID was 044515. The welding was performed against critical welding repair report B-CWR2286 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F)-FCM-Repair-1.

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 008 in the (4G) overhead position on bottom panel piece mark no. OBE11C. The location was the transverse splice weld joining segment 11DE and 11EE at bike path side. The welder ID was 050289. The welding was performed against critical welding repair report B-CWR2285 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

OBG # TRIAL ASSEMBLY YARD (11CE)

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 012 in the (1G) flat position on side and bottom panel piece mark no. SEG070A. The location was the complete joint penetration groove weld joining side and bottom panel of segment 11CE at work point E3. The welder ID was 044515. The welding was performed against welding repair report B-CWR2268 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1.

OBG # TRIAL ASSEMBLY YARD (11DE)

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 043 in the (1G) flat position on side and bottom panel piece mark no. SEG072A. The location was the complete joint penetration groove weld joining side and bottom panel of segment 11DE at work point E3. The welder ID was 040611. The welding was performed against welding repair report B-CWR2268 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1.

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

Inspected By:	Manikandan,Murugan	Quality Assurance Inspector
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Reviewed By:	Peterson,Art	QA Reviewer
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