

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-018424**Date Inspected:** 27-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 (Lift 11E)

This QA Inspector along with QA inspector Mr. Manjunath S Math performed dimensional joint survey inspection on the cope hole located at the floor beam to bottom panel, floor beam to side panel and at longitudinal diaphragms to verify the radius and smoothness using 150mm rule. 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:

Lift 11E - PP 95, PP 98, PP 101, PP 104, PP 107

OBG # TRIAL ASSEMBLY YARD (Lift 11E)

This QA Inspector along with QA inspector Mr. Manjunath S Math performed dimensional joint survey inspection on the reentrant corners located at the floor beam vertical flange welded on the flange of longitudinal diaphragm to verify the radius using pre-cut 25mm and 50mm template. 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:

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Lift 11E - PP 95, PP 98, PP 101, PP 104

This QA Inspector randomly observed the following work in progress:

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

The QA Inspector observed the heat straightening operation on WT stiffeners. The location was the hold back of WT stiffener fillet weld of segment 11DW and 11EW. The heat straightening was performed against heat straightening report HSR1 (B)-9889 Rev.0 dated 17th Nov. 2010. The heat straightening operation appeared to be in general compliance with the contract specifications. The weld designations reviewed are as follows:

SP785-001-011 to 012

SP745-001-043 to 048

SP507-001-051 to 052

BP785-001-033 to 036

BP745-001-049 to 060

BP507-001-057 to 060

OBG # TRIAL ASSEMBLY YARD (11DE)

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. 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 050289. The welding was performed against welding repair report B-WR17823 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1.

For additional information please reference the pictures below:

OBG # TRIAL ASSEMBLY YARD (11EE)

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 014 in the (1G) flat position on side and bottom panel piece mark no. SEG074A. The location was the complete joint penetration groove weld joining side and bottom panel of segment 11EW at work point E3. The welder ID was 050289. The welding was performed against welding repair report B-WR17823 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. 002 in the (4G) overhead position on edge and deck panel piece mark no. CA093. The location was the complete joint penetration groove weld joining edge and deck panel of segment 11DE at work point E4. The welder ID was 040320. The welding was performed against welding repair report B-WR17822 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 (11EE)

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 049 in the (4G) overhead position on edge and deck panel piece mark no. SEG072. The location was the complete joint penetration groove weld joining edge and deck panel of segment 11EE at work point E4. The welder ID was 040320. The welding was performed against welding repair report B-WR17822 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

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:	Manikandan,Murugan	Quality Assurance Inspector
----------------------	--------------------	-----------------------------

Reviewed By:	Peterson,Art	QA Reviewer
---------------------	--------------	-------------