

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-018917**Date Inspected:** 26-Dec-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 # Bay 14(14AE-14BE)

This QA Inspector along with QA Inspector Mr. Manjunath S Math performed dimensional joint survey inspection on the U-rib to verify the offset using 1 meter straight edge. 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 14AE to Segment 14BE – PP 127.3 to PP 127.5

OBG # TRIAL ASSEMBLY YARD (Lift 11E)

This QA Inspector along with QA Inspector Mr. Manjunath S Math performed dimensional survey inspection on the bike path cantilever to verify the length of cantilever, distance from end of cantilever to nearest anchor bolt and spacing between anchor bolts using measuring tape. The measurements were recorded on a separate sheet and forwarded to team leader for review and disposition. The segment, panel point and bike path cantilever designations are as follows:

11CE – PP 103 - BK001-010

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11DE – PP 105 - BK001-012

11EE – PP 107 - BK001-013

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (12AE-12BE)

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 042 in the (3G) vertical position on deck panel I stiffener piece mark no. DP3011-001. The location was the complete joint penetration groove weld joining the I stiffeners of segment 12AE and 12BE at bike path side. The welder ID was 044515. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-3213-B-U3b.

OBG # TRIAL ASSEMBLY YARD (12AE-12BE)

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 025 in the (3G) vertical position on deck panel I stiffener piece mark no. DP3001-001. The location was the complete joint penetration groove weld joining the I stiffeners of segment 12AE and 12BE at crossbeam side. The welder ID was 050289. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-3213-B-U3b.

OBG # TRIAL ASSEMBLY YARD (12AW)

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 051 in the (2G) horizontal position on longitudinal shear plate piece mark no. SEG3004V. The location was the complete joint penetration groove weld joining the longitudinal shear plate with the bottom panel of segment 12AW at work point W4. The welder ID was 046704. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212-Tc-U4b-FCM-1.

For additional information please reference the pictures below:

OBG # TRIAL ASSEMBLY YARD (12AW-12BW)

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 001 in the (4G) overhead position on deck panel piece mark no. OBW12. The location was the transverse splice weld joining segment 12AW and 12BW at work point W2 to W5. The welder ID was 044551. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 001 in the (4G) overhead position on deck panel piece mark no. OBW12. The location was the transverse splice weld joining segment 12AW and 12BW at work point W2 to W5. The welder ID was 046709. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 001 in the (4G) overhead position on corner assembly deck panel piece mark no. OBW12. The location was the transverse splice

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weld joining segment 12AW and 12BW at work point W2 to W5. The welder ID was 040656. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.



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