

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-020542**Date Inspected:** 13-Feb-2011**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:	Shao Jian Yuan and Li Yan Hua			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 Bay # 14.

Bay # 14: Segment 13CE

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 Seg3011-001. The welder identification was 067572 and observed welding in the 1G (Flat) position using approved Welding Procedure Specification WPS-B-P-2211-B-U2a-FCM-1. The piece mark was identified as the weld connecting the Deck Panel (DP3099A) to Corner Assembly (CA3014A).

Please reference the pictures attached for more comprehensive details.

Bay # 14: Segment 13BE

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 Seg3009M-001. The welder

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identification was 067571 and observed welding in the 4G (Overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2a-FCM-1. The piece mark was identified as the weld connecting the Side Panel to Corner Assembly.

Please reference the pictures attached for more comprehensive details.

Bay # 14: Segment 14 East

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 Seg3019U-002. The welder identification was 067079 and observed welding in the 3G (Vertical) position using approved Welding Procedure Specification WPS-B-T-2233-ESAB. The piece mark was identified as the weld connecting the Anchorage Plate AP3031A to the Longitudinal Diaphragm at work point E3.

Please reference the pictures attached for more comprehensive details.

Bay # 14: Segment 14 East

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 Seg3019AP-004. The welder identification was 066763 and observed welding in the 1G (Flat) position using approved Welding Procedure Specification WPS-B-T-2231-ESAB. The piece mark was identified as the weld connecting the Anchorage Plate (AP3004) to Anchorage Plate (AP3005).

Please reference the pictures attached for more comprehensive details.

Bay # 14: Segment 14 East

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 Seg3019U-003. The welder identification was 066236 and observed welding in the 2G (Horizontal) position using approved Welding Procedure Specification WPS-B-T-2232-ESAB. The piece mark was identified as the weld connecting the Anchorage Plate to Bottom Panel.

Please reference the pictures attached for more comprehensive details.

Bay # 14: Segment 14 West

This QA Inspector observed the in-process welding by Shielded Metal Arc Welding (SMAW) process on a Fillet weld. The Weld joint was designated as Seg3020BE-054. The welder identification was 067764 and observed welding in the 4F (Overhead) position using approved Welding Procedure Specification WPS-B-P-2114-FCM-1. The piece mark was identified as the weld connecting the Vertical Shear Plate Sub Assembly (SA3451A) to Longitudinal Diaphragm (LD3049A) between Panel Point (PP) 125 to PP 126.

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Bay # 14: Segment 14 West

This QA Inspector observed the repair welding by Shielded Metal Arc Welding (SMAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as Seg3020BB-001. The welder identification was 066038 and observed welding in the 2G (Horizontal) position using approved Welding Procedure Specification WPS-345-SMAW-2G(2F)-Repair-FCM-1. The piece mark was identified as the weld connecting the Vertical Shear Plate Sub Assembly (SA3442A) to Longitudinal Diaphragm (LD3090A) between Panel Point (PP) 125 to PP 126. ZPMC performed repair welding in accordance with Critical Welding Report B-CWR2793.

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: Math,Manjunath

Quality Assurance Inspector

Reviewed By: Dsouza,Christopher

QA Reviewer