

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022169**Date Inspected:** 27-Mar-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), Changxing Island **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

Non Destructive Examination (Magnetic Particle Testing)

This QA Inspector performed Magnetic Particle Testing (MPT) Inspection against the Inspection Notification # 08644 dated Mar 27, 2011 for the punch list generated against the visual discontinuities observed after sweep blasting (prior to painting). All the areas was previously tested and accepted by ZPMC Quality Control personnel.

This QA Inspector generated an MPT report (TL-6028) on this date. The members are identified as Orthotropic Box Girder (OBG) components. The items which were inspected are listed in the punch list as generated by Caltrans Engineer and which are depicted as below.

Segment 12AW: Punch List item # 314 till item # 339

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Segment 12AW: Punch List item # 314 till item # 339

Traveler Rails at Bay # 11

This QA Inspector performed Dimension Control Inspection on the Traveler Rails 20TR2-035 for the following measurements and observed recorded dimensions within the tolerances. The inspection was performed against the Inspection Notification # 08641 dated Mar 27, 2011 after heat straightening.

Traveler Rails Thickness at typical section,

Traveler Rails Flange width at typical section,

Traveler Rails Depth at typical section,

Traveler Rails Flange curl at typical section,

Traveler Rails Traveler Rail length.

Traveler Rails Sweep.

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.

Segment 12CW (Cantilever Bracket)

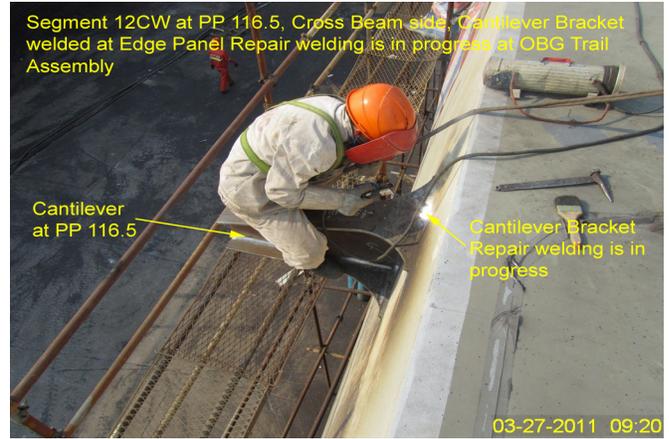
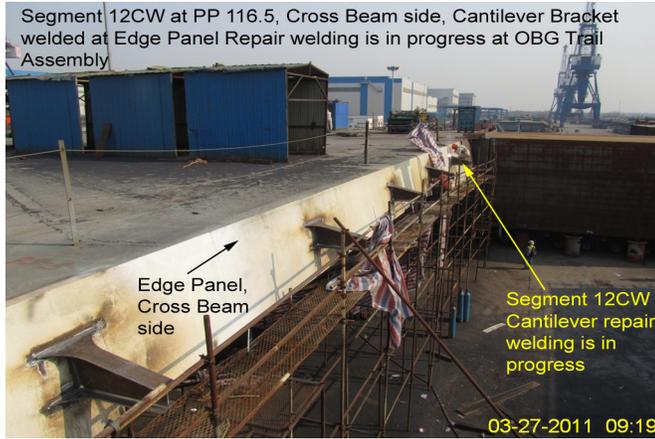
This QA Inspector observed the repair welding by Shielded Metal Arc Welding (SMAW) process on a Complete Joint Penetration (CJP) weld. The weld joint was designated as OBW12C-026. The welder identification was 046709 and was observed welding in the 1G (Flat) position using approved Welding Procedure Specification WPS-345-SMAW-1G(1F)-FCM-Repair-1. The piece mark was identified as Cantilever Brackets welded at Edge Panel at PP 116.5, Cross Beam side.

Please reference the pictures attached for more comprehensive details.

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: Miller,Mark

QA Reviewer