

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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011257**Date Inspected:** 07-Jan-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, M. Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # TRIAL ASSEMBLY YARD (6AE-6BE)

During the Quality Assurance (QA) random in-process visual inspection of T-Ribs stiffeners in the OBG Trial Assembly area, this QA inspector discovered the following issue:

-Three (3) T-Rib web welds between the 6AE to 6BE (transverse splice) were misaligned across the weld joints.

-The Side Panel (SP) weld joints are identified as:

- 1) SP307-001-032 (3rd T-Rib on SP from top-BP side)
- 2) SP334-001-023 (12th T-Rib on SP from top-BP side)
- 3) SP526-002-070 (1st T-Rib on SP from top-CB side)

-These welds are complete joint penetration (CJP) butt weld.

-The SP material at the BP and CB side are designated as non Seismic Performance Critical Members (Non SPCM).

-The out of tolerance offset measurement across the welds were measured at 4mm.

-The maximum out of tolerance allowed per AWS D1.5 2002 is 3mm.

This QA Inspector randomly observed the following work in progress:

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

OBG # TRIAL ASSEMBLY YARD (6BW-6CW)

FCAW Process:

Welding of weld joint – 020 located on PCMK BP141-001, CJP joining T-Rib of 6BW and 6CW. Welder is identified as 053609. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2-F.

FCAW Process:

Welding of weld joint – 031 located on PCMK SP143-001, CJP joining T-Rib of 6BW and 6CW. Welder is identified as 067501. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2-F.

OBG # TRIAL ASSEMBLY YARD (6BW-6CW)

FCAW Process:

Welding of weld joint – 009 and 012 located on PCMK SP083-001, Hold back area of T-Rib 6BW and 6CW. Welder is identified as 200676. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

OBG # TRIAL ASSEMBLY YARD (6CE)

FCAW Process:

Welding of weld joint – 149 located on PCMK SSD27-PP45, FL3 of 6CE. Welder is identified as 051246. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversation.

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

Inspected By:	Manikandan,Murugan	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
