

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016825**Date Inspected:** 21-Sep-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)**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

Segment 10AW (Plumbness and Flatness after Heat Straightening)

This QA Inspector performed Dimension Control Inspection along with ABF QA Inspector for measuring plumbness and flatness on the deck panel to deck panel diaphragm between U-Rib at 30th location (reference of numbering taken from counter weight side towards cross beam side) on Segment 10AW at Panel Point (PP) 86 after heat straightening.

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 10BW (Plumbness and Flatness after Heat Straightening)

This QA Inspector performed Dimension Control Inspection along with ABF QA Inspector for measuring plumbness and flatness on the deck panel to deck panel diaphragm between U-Rib at 29th, 30th, 31st, 32nd, 33rd,

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34th, 35th and 36th locations (reference of numbering taken from counter weight side towards cross beam side) on Segment 10AW at Panel Point (PP) 91 after heat straightening.

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 10BE (Plumbness and Flatness after Heat Straightening)

This QA Inspector performed Dimension Control Inspection along with ABF QA Inspector for measuring plumbness and flatness on the deck panel to deck panel diaphragm between U-Rib at following locations (reference of numbering taken from cross beam side towards bike path side) on Segment 10BE.

At 28th, 29th and 39th locations at Panel Point (PP) 91 after heat straightening.

At 26th location at Panel Point (PP) 90 after heat straightening.

At 13th, 14th and 27th locations at Panel Point (PP) 89 after heat straightening.

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 10CW

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 SEG063A-040. The welder identification was 040611 and observed welding in the 4G (Overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1. The piece mark was identified as Side Panel to Bottom Panel hold back weld at work point W3.

Segment 10CW

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 SEG063A-041. The welder identification was 046709 and observed welding in the 4G (Overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1. The piece mark was identified as Side Panel to Bottom Panel hold back weld at work point W4.

Segment 11AW

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 SEG065A-013. The welder identification was 040611 and observed welding in the 4G (Overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1. The piece mark was identified as Side Panel to Bottom Panel hold back weld at work point W3.

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Segment 11AW

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 SEG065A-014. The welder identification was 046709 and observed welding in the 4G (Overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1. The piece mark was identified as Side Panel to Bottom Panel hold back weld at work point W4.

Segment 10CW

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 SEG063-036. The welder identification was 044551 and observed welding in the 4G (Overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1. The piece mark was identified as Deck Panel to Edge Panel hold back weld at work point W5.

Segment 11AW

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 SEG065-001. The welder identification was 041713 and observed welding in the 4G (Overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1. The piece mark was identified as Longitudinal Diaphragm flange weld connecting floor beam at work point W3.

Segment 11AW

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 SEG065-024. The welder identification was 040609 and observed welding in the 3G (Vertical) position using approved Welding Procedure Specification WPS-B-T-2233-Tc-U4b-FCM-1. The piece mark was identified as Longitudinal Diaphragm web weld connecting floor beam at work point W4.

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 150000422372, who represents the Office of Structural Materials for your project.

Inspected By: Math,Manjunath

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer