

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-016875**Date Inspected:** 24-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 10AE (Lower Chevron Flatness Survey)

This QA Inspector performed Dimension Control Inspection along with ZPMC QC Mr. Zhang Hai Jung on the Splice plate installed at Lower Chevron from East and West side to ensure flatness is within the allowable tolerance of 2mm before snug tightening the bolts for Segment 10AE at Panel Points (PP) 86, PP 87 and 88 at Cross Beam side, work point E4 and Bike Path side, work point E3.

The QA Inspector measured the Flatness using 1(One) Meter Straight Edge and the results appeared to be in general compliance with contract requirements.

Segment 10CW

This QA Inspector observed the repair welding by Shielded Metal Arc Welding (SMAW). The weld joint was designated as SP139-001-025/026. The welder identification was 202316 and observed welding in the 2F

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(Horizontal) position using approved Welding Procedure Specification WPS-345-SMAW-2G(2F)-FCM-R-1. The piece mark was identified as Side Panel T-Rib hold back weld.

Segment 10CW

This QA Inspector observed the repair welding by Shielded Metal Arc Welding (SMAW). The weld joint was designated as SP166-001-029/030. The welder identification was 202316 and observed welding in the 2F (Horizontal) position using approved Welding Procedure Specification WPS-345-SMAW-2G(2F)-FCM-R-1. The piece mark was identified as Side Panel T-Rib hold back weld.

Segment 10CE

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 SEG064C-011. The welder identification was 044504 and observed welding in the 3G (Vertical) position using approved Welding Procedure Specification WPS-B-T-2213-Tc-U4b-FCM-1. The piece mark was identified as Longitudinal Diaphragm web weld connecting floor beam at work point E3.

Segment 10CE

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 SEG064B-001. The welder identification was 047353 and observed welding in the 1G (Flat) position using approved Welding Procedure Specification WPS-B-T-2231-Tc-U4b-F. The piece mark was identified as Longitudinal Diaphragm flange weld connecting floor beam at work point E4.

Segment 10BE

This QA Inspector observed the in process fillet welding by Shielded Metal Arc Welding (SMAW) process. The Weld joint was designated as DP702-001-015/016. The welder identification was 040581 and observed welding in the 4F (Overhead) position using approved Welding Procedure Specification WPS-B-T-4114-1. The piece mark was identified as Deck Panel, I-Rib hold back weld.

Segment 10CE

This QA Inspector observed the in process fillet welding by Shielded Metal Arc Welding (SMAW) process. The Weld joint was designated as DP703-001-009/010. The welder identification was 040581 and observed welding in the 4F (Overhead) position using approved Welding Procedure Specification WPS-B-T-4114-1. The piece mark was identified as Deck Panel, I-Rib hold back weld.

Segment 10BE to Segment 10CE

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 DP702-001-039 and

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DP702-001-040. The welder identification was 044515 and observed welding in the 3G (Vertical) position using approved Welding Procedure Specification WPS-B-T-3213-B-U3b. The piece mark was identified as Deck Panel, I-Rib web splice, on Cross Beam side.

Segment 10BE to Segment 10CE

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 DP702-001-041. The welder identification was 044515 and observed welding in the 3G (Vertical) position using approved Welding Procedure Specification WPS-B-T-3213-B-U3b. The piece mark was identified as Deck Panel, I-Rib web splice, on Cross Beam side.

Segment 10BE to Segment 10CE

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 DP715-001-019 and DP715-001-020. The welder identification was 057266 and observed welding in the 3G (Vertical) position using approved Welding Procedure Specification WPS-B-T-3213-B-U3b. The piece mark was identified as Deck Panel, I-Rib web splice, on Bike Path side.

Segment 10BE to Segment 10CE

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 DP715-001-021. The welder identification was 057266 and observed welding in the 3G (Vertical) position using approved Welding Procedure Specification WPS-B-T-3213-B-U3b. The piece mark was identified as Deck Panel, I-Rib web splice, on Cross Beam side.

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

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
