

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-016925**Date Inspected:** 27-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 10CW to 11AW (Root Gap and Offset)

This QA Inspector along with Caltrans QA Inspector Mr. Manoj Prabhune performed Dimension Control Inspection for measuring root gap and offset at the Transverse Splice for the Segment 10CW to Segment 11AW between Panel Point (PP) 94 to PP 95 at the following locations:

Work Point W5 towards Work Point W6 (Edge Panel Cross Beam Side).

Work Point W6 towards Work Point W4 (Side Panel Cross Beam Side).

Work Point W4 towards Work Point W3 (Bottom Panel).

Work Point W3 towards Work Point W1 (Side Panel Counter Weight Side).

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Work Point W1 towards Work Point W2 (Edge Panel Counter Weight Side).

Work Point W2 towards Work Point W5 (Deck Panel).

The QA Inspector measured the root gap using 1(One) taper gauge and measured the offset using a bridge cam gauge.

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 11AW to 11BW (Root Gap and Offset)

This QA Inspector performed Dimension Control Inspection for measuring root gap and offset at the Transverse Splice for the Segment 11AW to Segment 11BW between Panel Point (PP) 97 to PP 98 at the following locations:

Work Point W6 towards Work Point W4 (Side Panel Cross Beam Side).

Work Point W4 towards Work Point W3 (Bottom Panel).

Work Point W3 towards Work Point W1 (Side Panel Counter Weight Side).

Work Point W2 towards Work Point W5 (Deck Panel).

The QA Inspector measured the root gap using 1(One) taper gauge and measured the offset using a bridge cam gauge.

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 to Segment 11AW (Transverse Splice T-Ribs)

This QA Inspector performed Dimension Control Inspection along with ABF QA personnel on the Transverse Splice T-Ribs to T-Ribs for the Segment 10CW to Segment 11AW between Panel Point (PP) 94 to PP 95 at the following locations:

Work Point W6 towards Work Point W4 (Side Panel Cross Beam Side) total 19 T-Ribs.

Work Point W4 towards Work Point W3 (Bottom Panel) total 18 T-Ribs.

Work Point W3 towards Work Point W1 (Side Panel Counter Weight Side) total 19 T-Ribs.

The QA Inspector measured the Vertical Offset using 1(One) Meter Straight Edge and measured the Horizontal Offset on the web using a Bridge Cam gauge.

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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 11AW to Segment 11BW

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 OBW11B-003. The welder identification was 040609 and was observed welding in the 1G (Flat) position using approved Welding Procedure Specification WPS-B-T-2231T. The piece mark was identified as the Bottom Panel, transverse splice weld.

Segment 10CE

This QA Inspector observed the in-process fillet welding by Flux Cored Arc Welding (FCAW) process. The weld joint was designated as SP633-001-043/044, SP633-001-045/046 and SP633-001-047/048. The welder identification was 040458 and observed welding in the 2F (Horizontal) position using approved Welding Procedure Specification WPS-B-T-2132. The piece mark was identified as Side Panel T-Rib hold back weld, Cross Beam side. Please reference the pictures attached for more comprehensive details.

Segment 11AE

This QA Inspector observed the in-process fillet welding by Flux Cored Arc Welding (FCAW) process. The weld joint was designated as SP634-001-001/002, SP634-001-003/004 and SP634-001-005/006. The welder identification was 040458 and observed welding in the 2F (Horizontal) position using approved Welding Procedure Specification WPS-B-T-2132. The piece mark was identified as Side Panel T-Rib hold back weld, 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.



Summary of Conversations:

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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
