

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017594**Date Inspected:** 22-Oct-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 Mr. M. Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # TRIAL ASSEMBLY YARD

This QA inspector along with QA inspector Mr. Manjunath S Math performed dimensional joint survey inspection to verify the root gap and offset on the transverse splice weld of segment 11BE and segment 11CE. The measurements were recorded on a separate sheet and forwarded to team leader for review and disposition. The segment and panel point designations were as follows:

Segment 11BE to Segment 11CE – PP 100 to PP 101

OBG # TRIAL ASSEMBLY YARD (10E)

This QA inspector witnessed the final bolt tension verification on the U-Rib splice between 10BE and 10CE. The torque wrench S/N was X02-666. The QA inspector witnessed 10% of the bolts on a random basis and found the tensioning of the bolts appeared to be in general compliance. The panel point and bolt size designations were as follows:

PP 91 to PP 92:

M22 X 70 – DHGM 220022 – 487 NM

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M22 X 80 – DHGM 220094 – 470 NM

M22 X 85 – DHGM 220109 – 350 NM

OBG # TRIAL ASSEMBLY YARD (CB14)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as I stiffeners hold back welds. The weld designations reviewed are as follows:

FB201-014-025, 026, 033 & 034

FB203-014-003 & 004

FB202-014-007 & 008

SP203-014-044~047

SP201-014-015~018

SP202-014-018 & 019

SP206-014-044 & 045

SP204-014-013~016

SP205-014-018 & 019

BP202-014-009 & 010

BP203-014-009 & 010

DP205-014-005 & 006

DP204-014-007 & 008

DP203-014-021~024

DP202-014-021 & 022

DP201-014-009 & 010

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (11BW-11CW)

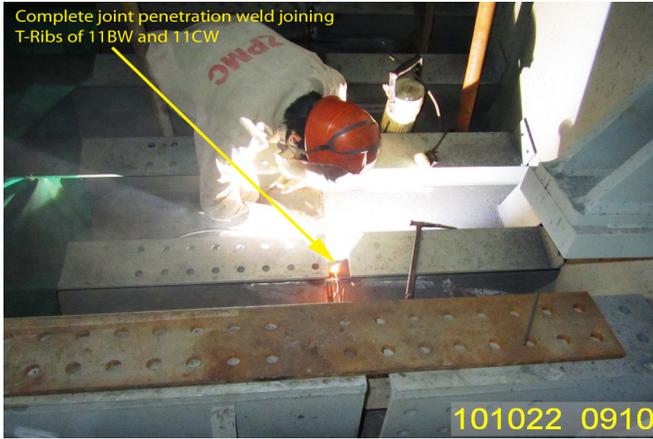
The QA inspector observed the welding operation per the SMAW process on weld joint no. 044 in the (3G) vertical position on side panel T-Rib piece mark no. SP168-001. The location was the complete joint penetration weld joining T-Rib of 11BW and 11CW. The welder ID was 040656. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2213-B-U2-FCM-1.

For additional information please reference the pictures below:

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:	Manikandan, Murugan	Quality Assurance Inspector
Reviewed By:	Peterson, Art	QA Reviewer
