

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017653**Date Inspected:** 28-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:**

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (11AE-11BE)

The QA inspector observed the heat straightening operation on weld joint no. 035 on side panel piece mark no. SP699-001. The location was the complete joint penetration groove weld joining the WT stiffeners of segment 11AE and 11BE. The heat straightening was performed against heat straightening report HSR (B)-431 Rev.0 dated 27th Oct. 2010. The heat straightening operation appeared to be in general compliance with the contract specifications.

The QA inspector observed the heat straightening operation on weld joint no. 031 on side panel piece mark no. SP714-001. The location was the complete joint penetration groove weld joining the WT stiffeners of segment 11AE and 11BE. The heat straightening was performed against heat straightening report HSR (B)-431 Rev.0 dated 27th Oct. 2010. The heat straightening operation appeared to be in general compliance with the contract specifications.

For additional information please reference the pictures below:

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

The QA inspector observed the welding operation per the SMAW process on weld joint no. 006 in the (3G) vertical position on edge panel piece mark no. OBW11. The location was the transverse splice weld joining

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segment 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.

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

The QA inspector observed the welding operation per the SMAW process on weld joint no. 007 in the (4G) overhead position on deck panel piece mark no. OBW11. The location was the transverse splice weld joining segment 11BW and 11CW. The welder ID was 041713. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

The QA inspector observed the welding operation per the SMAW process on weld joint no. 008 in the (4G) overhead position on deck panel piece mark no. OBW11. The location was the transverse splice weld joining segment 11BW and 11CW. The welder ID was 044551. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

The QA inspector observed the welding operation per the SMAW process on weld joint no. 020 in the (3G) vertical position on deck panel I stiffener piece mark no. DP693-001. The location was the complete joint penetration groove weld joining the I stiffeners of segment 11BW and 11CW. The welder ID was 040611. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-3213-B-U3b.

The QA inspector observed the welding operation per the SMAW process on weld joint no. 020 in the (3G) vertical position on deck panel I stiffener piece mark no. DP679-001. The location was the complete joint penetration groove weld joining the I stiffeners of segment 11BW and 11CW. The welder ID was 046704. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-3213-B-U3b

OBG # TRIAL ASSEMBLY YARD (11CW)

The QA inspector observed the welding operation per the SMAW process on weld joint no. 013 in the (4G) overhead position on side and bottom panel piece mark no. SEG069A. The location was the hold back area of longitudinal weld joining the side to bottom panel of segment 11CW. The welder ID was 049502. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

OBG # TRIAL ASSEMBLY YARD (11BW)

The QA inspector observed the welding operation per the SMAW process on weld joint no. 044 in the (4G) overhead position on side and bottom panel piece mark no. SEG067A. The location was the hold back area of longitudinal weld joining the side to bottom panel of segment 11BW. The welder ID was 049502. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

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

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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 15000422372, who represents the Office of Structural Materials for your project.

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