

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-018294**Date Inspected:** 21-Nov-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 (11BW)

This QA Inspector along with QA inspector Mr. Manjunath S Math performed dimensional joint survey inspection after heat straightening on the floor beam to verify the flatness using 1500mm straight edge. 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 11BW – PP 99 and PP 100

OBG # TRIAL ASSEMBLY YARD (11CW)

This QA Inspector along with QA inspector Mr. Manjunath S Math performed dimensional joint survey inspection after heat straightening on the floor beam to verify the flatness using 1500mm straight edge. 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 11CW – PP 102 and PP 103

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

This QA Inspector along with QA Inspector Mr.Manjunath S Math performed dimensional joint survey inspection on the longitudinal diaphragm to verify the offset using 1000mm straight edge. 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 11CW to Segment 11DW – PP 103 to PP 104

OBG # TRIAL ASSEMBLY YARD (11DE-11EE)

This QA Inspector along with QA Inspector Mr.Manjunath S Math performed dimensional joint survey inspection on the longitudinal diaphragm to verify the offset using 1000mm straight edge. 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 11DE to Segment 11EE – PP 106 to PP 107

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (11EW)

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 002 in the (4G) overhead position on corner assembly piece mark no. CA091. The location was the complete joint penetration groove weld joining edge panel and deck panel of segment 11EW at work point W2. The welder ID was 040611. The welding was performed against welding repair report B-WR17349. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

OBG # TRIAL ASSEMBLY YARD (11DW)

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 071 in the (3G) vertical position on partial height diaphragm piece mark no. SSD25-PP105. The location was the fillet weld between partial height diaphragm to skin plate of segment 11DW-FL3. The welder ID was 046704. The welding variables recorded by QC appeared to comply with the WPS-B-P-2113-FCM-1.

OBG # TRIAL ASSEMBLY YARD (11DE)

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 172 in the (4G) overhead position on partial height diaphragm piece mark no. SSD24-PP105.5. The location was the 'I' stiffener fillet weld of segment 11DE-FL3. The welder ID was 041713. The welding variables recorded by QC appeared to comply with the WPS-B-P-2114-FCM-1.

OBG # TRIAL ASSEMBLY YARD (11DW-11EW)

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The QA Inspector observed the welding operation per the SMAW process on base metal in the (4G) overhead position on side and bottom panel. The location was the transverse splice weld joining segment 11DW and 11EW at crossbeam side. The welder ID was 040724. The welding was performed against critical welding repair report B-CWR1842. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-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.



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
