

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-018297**Date Inspected:** 25-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 (11DW-11EW)

This QA inspector performed a random visual survey inspection for flatness of transverse splice segment weld at side panel crossbeam on Segment 11DW to Segment 11EW with the following observations. The maximum out of flatness verified and measured was 13mm - 18mm for approximately 4000mm length using a 600 mm Straight Edge across the Complete Joint Penetration (CJP) groove weld with single point contact. The surface flatness survey data was taken on the exterior side (flat side of the weld) of the side panel. The allowable tolerance is 10mm.

The measurements were forwarded to team leader for review and disposition. The segment and panel point designations were as follows:

Segment 11DW to 11EW – PP 106 to PP 107

Transverse Splice Weld identified as OBW11C-009.

For additional information please reference the pictures below:

This QA Inspector randomly observed the following work in progress:

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

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 045 in the (1G) flat position on side and bottom panel piece mark no. SEG071A. The location was the complete joint penetration groove weld joining side and bottom panel of segment 11DW at work point W4. The welder ID was 046709. The welding was performed against welding repair report B-WR17734 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1.

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 014 in the (1G) flat position on side and bottom panel piece mark no. SEG073A. The location was the complete joint penetration groove weld joining side and bottom panel of segment 11EW at work point W4. The welder ID was 046709. The welding was performed against welding repair report B-WR17734 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1.

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

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 044 in the (1G) flat position on side and bottom panel piece mark no. SEG071A. The location was the complete joint penetration groove weld joining side and bottom panel of segment 11DW at work point W3. The welder ID was 046709. The welding was performed against welding repair report B-WR17735 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1.

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 013 in the (1G) flat position on side and bottom panel piece mark no. SEG073A. The location was the complete joint penetration groove weld joining side and bottom panel of segment 11EW at work point W3. The welder ID was 046709. The welding was performed against welding repair report B-WR17735 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1.

OBG # TRIAL ASSEMBLY YARD (CB16)

The QA Inspector observed the welding operation per the FCAW process on weld joint no. 006 in the (4G) overhead position on floor beam 'I' stiffener piece mark no. FB203-016. The location was the 'I' stiffener fillet weld of crossbeam 16. The welder ID was 041713. The welding was performed against welding repair report B-CWR2183 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F)-FCM-Repair-1.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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