

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-018449**Date Inspected:** 02-Dec-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

Cross Beam (CB) # 16

This QA Inspector performed Dimension Control Inspection along with Caltrans QA Inspector for measuring offset between the stiffeners at floor beam (FL3) extension at Segment 11DW to Cross Beam # 16 stiffeners at bottom panel, vertical web plate and deck plate at following locations:

At Panel Point (PP) 104, Segment 11DW offset measurement performed between floor beam stiffeners to west side Vertical Web Plate stiffeners of cross beam # 16 total 13 stiffeners.

At Panel Point (PP) 105, Segment 11DW offset measurement performed between floor beam stiffeners to centre Vertical Web Plate stiffeners of cross beam # 16, total 13 stiffeners.

At Panel Point (PP) 106, Segment 11DW offset measurement performed between floor beam stiffeners to east side Vertical Web Plate stiffeners of cross beam # 16, total 13 stiffeners.

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

Between Panel Points (PP) 104 to PP 105, Segment 11DW offset measurement performed between deck panel stiffeners to deck panel stiffeners of cross beam # 16, total 11 stiffeners.

Between Panel Points (PP) 105 to PP 106, Segment 11DW offset measurement performed between deck panel stiffeners to deck panel stiffener of cross beam # 16, total 11 stiffeners.

Between Panel Points (PP) 104 to PP 105, Segment 11DW offset measurement performed between bottom panel stiffeners to bottom panel stiffeners of cross beam # 16, total 5 stiffeners.

Between Panel Points (PP) 105 to PP 106, Segment 11DW offset measurement performed between bottom panel stiffeners to bottom panel stiffener of cross beam # 16, total 5 stiffeners.

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.

Bike Path at Bay # 19

This QA Inspector performed Dimension Control Inspection on the Bike Path bottom panel for flatness check across the longitudinal butt weld. Flatness check was performed on following mentioned Bike Paths and Bike Path are identified as:

BK004A-004

The QA Inspector measured the flatness using 600mm long straight edge and observed flatness dimensions out of allowable tolerance.

The results of the inspection were informed to Caltrans Lead Inspector Mr. Mark Miller and Mr. Hiranch Patel.

Segment 11EW

This QA Inspector observed the in process fillet welding operation by the Flux Cored Arc Welding (FCAW) process. The weld joint was designated as BP055-001~025/026. The welder identification was 049220 and was observed welding in the 2F (Horizontal) position using approved Welding Procedure Specification WPS-B-T-2132-ESAB. The piece mark was identified as the Bottom Panel, T-Ribs hold back weld.

Segment 12AW

This QA Inspector observed the in process fillet welding operation by the Flux Cored Arc Welding (FCAW) process. The weld joint was designated as BP3020-001~047/048. The welder identification was 053486 and was observed welding in the 2F (Horizontal) position using approved Welding Procedure Specification WPS-B-T-2132-ESAB. The piece mark was identified as the Bottom Panel, T-Ribs hold back weld.

Segment 11EW

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

This QA Inspector observed the in process fillet welding operation by the Flux Cored Arc Welding (FCAW) process. The weld joint was designated as BP109-001~027/028. The welder identification was 049220 and was observed welding in the 2F (Horizontal) position using approved Welding Procedure Specification WPS-B-T-2132-ESAB. The piece mark was identified as the Bottom Panel, T-Ribs hold back weld.

Segment 12AW

This QA Inspector observed the in process fillet welding operation by the Flux Cored Arc Welding (FCAW) process. The weld joint was designated as BP3019-001~043/044. The welder identification was 053486 and was observed welding in the 2F (Horizontal) position using approved Welding Procedure Specification WPS-B-T-2132-ESAB. The piece mark was identified as the Bottom Panel, T-Ribs hold back weld.

Segment 11EW

This QA Inspector observed the in process fillet welding operation by the Flux Cored Arc Welding (FCAW) process. The weld joint was designated as SP786-001~025/026. The welder identification was 040709 and was observed welding in the 2F (Horizontal) position using approved Welding Procedure Specification WPS-B-T-2132-ESAB. The piece mark was identified as the Side Panel, T-Ribs hold back weld.

Please reference the pictures attached for more comprehensive details.

Segment 12AW

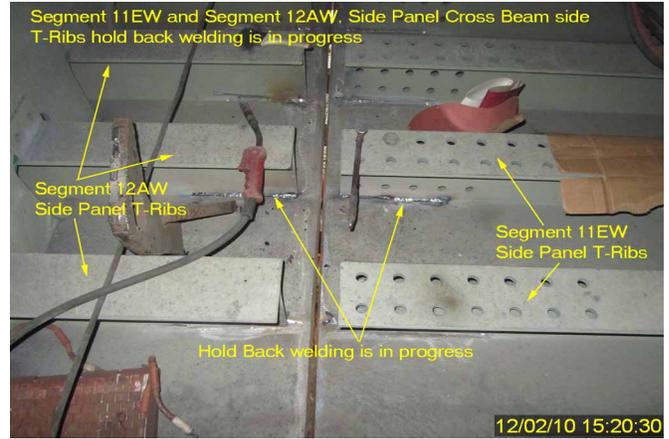
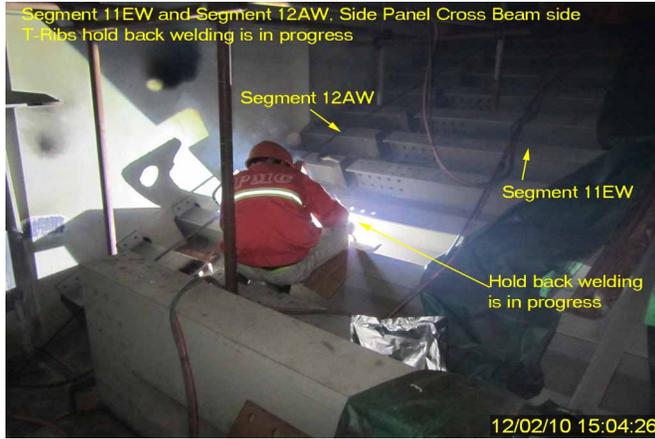
This QA Inspector observed the in process fillet welding operation by the Flux Cored Arc Welding (FCAW) process. The weld joint was designated as SP3037-001~005/006. The welder identification was 040709 and was observed welding in the 2F (Horizontal) position using approved Welding Procedure Specification WPS-B-T-2132-ESAB. The piece mark was identified as the Side Panel, T-Ribs hold back weld.

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.

WELDING INSPECTION REPORT

(Continued Page 4 of 4)



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 150000422372, who represents the Office of Structural Materials for your project.

Inspected By: Math,Manjunath

Quality Assurance Inspector

Reviewed By: Dsouza,Christopher

QA Reviewer