DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-018471
Date Inspected: 30-Nov-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 645
OSM Departure Time: 1845
Location: Shanghai, China

CWI Name: An Qing Xiang.

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☐ Yes	☐ No	☑ N/A
				Approved WPS:	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: Orthotropic Box Girder(OBG)

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

Trial assembly yard, Segment 11A-11B(East & West), SP-C4, 5 & E7, 8.

This QA inspector carried out random dimensional measurements at OBG segment 11AW-11BW & 11AE-11BE transverse splice on side panels. This QA inspector measured excessive concavity in side panel splice welds.

The measured concavity measured found to within acceptable limits.

Trial assembly yard, 11EE-12AE, SP-BP-E4, hold back area.

FCAW welding of weld joint SEG074A-011, SEG3001A-015; located at Trial assembly yard. Welder is identified as 047353; ZPMC Quality Control Inspector (QC) is identified as An Qing Xiang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-ESAB. The attached photographs provide additional detail.

This QA Inspector carried out NDE on following
Trail assembly yard, 11CE-11DE.

This QA Inspector performed verification Ultrasonic Testing (ABF Request No: 11292010-1) in accordance with ABF/CT Pattern “D” UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as weld between Bottom panel & Side panel at the

transverse splice between OBG segment 11CE-11DE. The weld designations were as;

1) SEG070A-012. (11CE-11DE, BP-SP-E3, Hold back area);
2) SEG072A-043. (11CE-11DE, BP-SP-E3, Hold back area).

Trail assembly yard, 11DW-11EW.

This QA Inspector performed verification Ultrasonic Testing (ABF Request No: 11292010-1) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as weld between Side panels at the transverse splice between OBG segment 11DW-11EW. The weld designations were as;

OBW11C-006, 007. (11DW-11EW, SP-C4, 5).

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

Summary of Conversations:

No relevant conversations.

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, 1500.042.2372, who represents the Office of Structural Materials for your project.

Inspected By:	Juvekar,Amit	Quality Assurance Inspector
Reviewed By:	Dsouza,Christopher	QA Reviewer