

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-018524**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), 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 (Lift 11W)

This QA Inspector witnessed the final bolt tension verification on the Catwalk support of Lift 11W. The torque wrench S/N was XO2-114. The QA inspector witnessed 10% of the bolts on a random basis and found the tensioning of the bolts appeared to be in general compliance with the contract specifications. The panel point and bolt size designations were as follows:

PP 95 to PP 108:

M16 X 40 – DHGM 160045– 200 NM

M16 X 45 – DHGM 160021– 180 NM

M16 X 50 – DHGM 160011 – 200 NM

OBG # TRIAL ASSEMBLY YARD (Lift 11W)

This QA Inspector witnessed the final bolt tension verification on the Cable tray support of Lift 11W. The torque wrench S/N was XO2-114. The QA inspector witnessed 10% of the bolts on a random basis and found the tensioning of the bolts appeared to be in general compliance with the contract specifications. The panel point and bolt size designations were as follows:

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

PP 95 to PP 108:

¾" X 21/2" – DHG 60581– 294 NM

For additional information please reference the pictures below:

OBG # TRIAL ASSEMBLY YARD (11EE)

This QA Inspector witnessed the final bolt tension verification on the side panel to floor beam clips of segment 11EE. The torque wrench S/N was XO2-114. The QA inspector witnessed 10% of the bolts on a random basis and found the tensioning of the bolts appeared to be in general compliance with the contract specifications. The panel point and bolt size designations were as follows:

PP 103, PP 107 and PP 108:

M16 X 45 – DHGM 160021– 180 NM

M16 X 65 – DHGM 160006 – 180 NM

This QA Inspector randomly observed the following work in progress:

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

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 001 in the (4G) overhead position on deck and edge panel piece mark no. CA090. The location was the complete joint penetration groove weld joining edge and deck panel of segment 11DE at work point E2. The welder ID was 040320. The welding was performed against critical welding repair report B-CWR2309. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 005 in the (4G) overhead position on deck and edge panel piece mark no. CA094. The location was the complete joint penetration groove weld joining edge and deck panel of segment 11EE at work point E2. The welder ID was 040320. The welding was performed against critical welding repair report B-CWR2309. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

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

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. SEG072A. The location was the complete joint penetration groove weld joining side and bottom panel of segment 11DE at work point E3. The welder ID was 053871. The welding was performed against critical welding repair report B-CWR2312. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

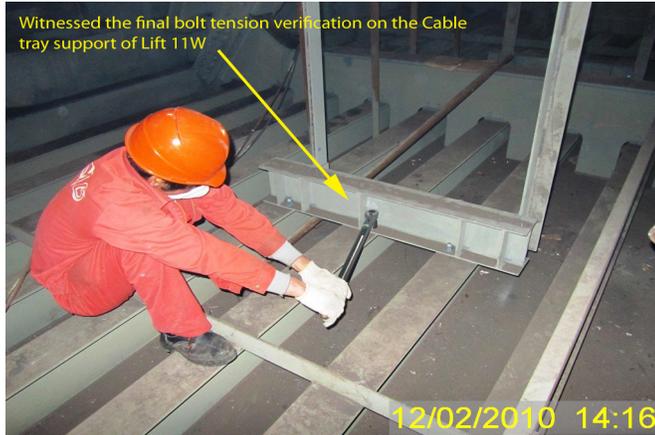
The QA Inspector observed the welding operation per the SMAW process on weld joint no. 014 in the (4G) overhead position on side and bottom panel piece mark no. SEG074A. The location was the complete joint penetration groove weld joining side and bottom panel of segment 11EE at work point E3. The welder ID was

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

053871. The welding was performed against welding repair report B-CWR2312. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

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
