

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-018529**Date Inspected:** 08-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 (11EE-12AE)

This QA Inspector along with QA Inspector Mr. Manjunath S Math performed dimensional joint survey inspection on the B1, B2, B3, B4, T1 and T2 work point across transverse splice joints to verify the skin flatness using 5 meter string line, 600mm and 630mm 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 11EE to Segment 12AE – PP 108 to PP 109

For additional information please reference the pictures below:

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (12AW-12BW)

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 088 in the (3G) vertical position on side panel WT stiffener piece mark no. SP3046-001. The location was the complete joint penetration groove weld joining the WT stiffeners of segment 12AW and 12BW. The welder ID was 041713. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

WPS-B-P-2213-B-U2-FCM-1.

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 038 in the (3G) vertical position on bottom panel WT stiffener piece mark no. BP3021-001. The location was the complete joint penetration groove weld joining the WT stiffeners of segment 12AW and 12BW. The welder ID was 046704. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2213-B-U2-FCM-1.

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 162 in the (3G) vertical position on side panel WT stiffener piece mark no. SP3037-001. The location was the complete joint penetration groove weld joining the WT stiffeners of segment 12AW and 12BW. The welder ID was 040656. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2213-B-U2-FCM-1.

OBG # TRIAL ASSEMBLY YARD (11EW-12AW)

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 001 in the (4G) overhead position on edge and side panel piece mark no. CA092. The location was the complete joint penetration groove weld joining side and bottom panel of segment 11EW at work point W6. The welder ID was 046709. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-Tc-U4b-FCM-1.

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 002 in the (4G) overhead position on edge and side panel piece mark no. SEG3004AA. The location was the complete joint penetration groove weld joining side and bottom panel of segment 12AW at work point W6. The welder ID was 046709. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-Tc-U4b-FCM-1.

OBG # TRIAL ASSEMBLY YARD

The QA Inspector observed the welding operation per the FCAW process on weld joint no. 005 in the (3G) vertical position on bike path cantilever piece mark no. BK001-012. The location was the complete joint penetration groove weld joining the web plate of bike path cantilever 11DE at panel point 105. The welder ID was 052763. The ZPMC CWI was identified as Li Yang. The welding was performed against welding repair report B-WR17985. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-3G (3F)-ESAB-Repair.

The QA Inspector observed the welding operation per the FCAW process on weld joint no. 005 in the (3G) vertical position on bike path cantilever piece mark no. BK001-013. The location was the complete joint penetration groove weld joining the web plate of bike path cantilever 11EE at panel point 107. The welder ID was 047353. The ZPMC CWI was identified as Li Yang. The welding was performed against welding repair report B-WR17985. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-3G (3F)-ESAB-Repair.

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