

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-018609**Date Inspected:** 15-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 (11EW-12AW)

This QA Inspector along with QA Inspector Mr. Manjunath S Math performed dimensional joint survey inspection on the longitudinal diaphragm to verify the offset and sweep using 1000mm straight edge and string line. 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 11EW to Segment 12AW – PP 108 to PP 109

This QA Inspector randomly observed the following work in progress:

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

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 011 in the (1G) flat position on bottom and side 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 040611. The welding was performed against welding repair report B-WR18073. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1.

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The QA Inspector observed the welding operation per the SMAW process on weld joint no. 012 in the (1G) flat position on bottom and side 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-WR18072. 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. 002 in the (4G) overhead position on deck and edge panel piece mark no. CA3006. The location was the complete joint penetration groove weld joining deck and edge panel of segment 12AW at work point W2. The welder ID was 040656. The welding was performed against welding repair report B-WR18796. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1

OBG # TRIAL ASSEMBLY YARD (12AE)

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 149 in the (2F) horizontal position on side panel WT stiffener piece mark no. SP3002-001. The location was the hold back of WT stiffener fillet weld of segment 12AE. The welder ID was 040367. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-ESAB.

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 097 in the (2F) horizontal position on side panel WT stiffener piece mark no. SP3004-001. The location was the hold back of WT stiffener fillet weld of segment 12AE. The welder ID was 052763. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-ESAB.

OBG # TRIAL ASSEMBLY YARD (12AE-12BE)

The QA Inspector observed the welding operation per the SAW process on weld joint no. 003 in the (1G) flat position on deck panel piece mark no. OBE12. The location was the transverse splice weld joining segment 12AE and 12BE at work point E5 to E2. The welder ID was 040460. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-223(2)1T-ESAB. For additional information please reference the pictures below:

The QA Inspector observed the welding operation per the SAW process on weld joint no. 007 in the (1G) flat position on corner assembly deck panel piece mark no. CA6502. The location was the transverse splice weld joining segment 12AE and 12BE at work point E5 to E2. The welder ID was 050295. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-223(2)1T-ESAB.

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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
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Reviewed By:	Peterson, Art	QA Reviewer
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