

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-018921**Date Inspected:** 30-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 (11DW)

This QA Inspector along with QA inspector Mr. Manjunath S Math and ABF QA inspector performed the dimensional survey inspection on the corner assembly X37B and X37C brackets to verify the road barrier bolt hole between deck panel and brackets cope hole on Lift 11E. 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 11DW – PP 103.25, 103.75, 104.25, 104.75, 105.25 and 105.75

OBG # TRIAL ASSEMBLY YARD (11EW)

This QA Inspector along with QA inspector Mr. Manjunath S Math and ABF QA inspector performed the dimensional survey inspection on the corner assembly X37B and X37C brackets to verify the road barrier bolt hole between deck panel and brackets cope hole on Lift 11E. 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 – PP 106.25, 106.75, 107.25, 107.75, 108.25 and 108.75

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OBG # TRIAL ASSEMBLY YARD (11DE)

This QA Inspector witnessed the final bolt tension verification on the bottom panel to 11DE FL3. The torque wrench S/N was X02-666. 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 bolt size designations were as follows:

M24 X 60 – DHGM 240001 – 633 NM

M24 X 65 – DHGM 240013 – 540 NM & 967 NM

M24 X 70 – DHGM 240010 – 1200 NM

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. 157 in the (4G) overhead 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 at crossbeam side. The welder ID was 041713. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

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

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 001 in the (4G) overhead position on deck panel piece mark no. OBW12. The location was the transverse splice weld joining segment 12AW and 12BW at work point W2 to W5. The welder ID was 057333. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

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

The QA Inspector observed the welding operation per the SMAW process on base metal in the (1G) flat position on deck panel. The location was the welding fixtures removed by means of grinding near transverse splice weld joint of segment 12AW and 12BW at work point W2 to W5. The welder ID was 040656. The welding was performed against critical welding repair report B-CWR2126. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1.

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

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 001 in the (1G) flat position on bottom panel piece mark no. OBE12B. The location was the transverse splice weld joining segment 12AE and 12BE at work point E4 to E3. The welder ID was 044515. The welding was performed against critical welding repair report B-WR19699. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1.

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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
Reviewed By:	Peterson,Art	QA Reviewer
