

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-019139**Date Inspected:** 07-Jan-2011**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 (11BE)

This QA Inspector along with Mr. Manoj Prabhune photographed and documented at various locations on OBG 11BE prior to the shipment of (Voyage 7) en-route to Yerba Buena Island, California, USA. The following locations are where the photographs were taken and the photographs are available for review upon request.

OBG 11BE (Panel Point 98 thru Panel point 100.5) the following sequential members were photographed and documented:

1. Truss post – Crossbeam side of segment 11BE – PP 98.5, 99.5 and PP 100.5.
2. Corner Assembly – Crossbeam side of segment 11BE – PP 98, 99 and PP 100.
3. Longitudinal Diaphragm - Crossbeam side of segment 11BE – PP 98, 99 and PP 100.
4. Chevron Diagonal members (upper and lower) - Crossbeam side of segment 11BE – PP 98, 99 and PP 100.
5. Sea fasteners- 11BE – PP 98, 99 and PP 100.
6. Chevron Diagonal members (upper and lower) – Bike path side of segment 11BE – PP 98, 99 and PP 100.
7. Longitudinal Diaphragm – Bike path side of segment 11BE – PP 98, 99 and PP 100.
8. Corner Assembly – Bike path side of segment 11BE – PP 98, 99 and PP 100.
9. Truss post – Bike path side of segment 11BE – PP 98.5, 99.5 and PP 100.5.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (12BE and 12CE)

The QA Inspector observed the welding operation per the FCAW process on weld joint no. 002 in the (1G) flat position on deck panel piece mark no. OBE12A. The location was the complete joint penetration groove weld joining the deck panel of segment 12BE and 12CE at work point E5 to E2. The welder ID was 040458. 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-1.

The QA Inspector observed the welding operation per the FCAW process on weld joint no. 003 in the (1G) flat position on deck panel piece mark no. OBE12A. The location was the complete joint penetration groove weld joining the deck panel of segment 12BE and 12CE at work point E5 to E2. 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-223(2)1T-ESAB-1.

The QA Inspector observed the welding operation per the FCAW process on weld joint no. 003 in the (1G) flat position on deck panel piece mark no. OBE12A. The location was the complete joint penetration groove weld joining the deck panel of segment 12BE and 12CE at work point E5 to E2. The welder ID was 047353. 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-1.

The QA Inspector observed the welding operation per the FCAW process on weld joint no. 012 in the (1G) flat position on deck panel piece mark no. CA6502. The location was the complete joint penetration groove weld joining the deck panel of segment 12BE and 12CE at work point E5 to E2. 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-223(2)1T-ESAB-1.

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
