

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-019229**Date Inspected:** 11-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.

This QA Inspector randomly observed the following work in progress:

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

The QA Inspector observed the welding operation per the FCAW process on weld joint no. 002 in the (1G) flat position on bottom panel piece mark no. OBW12D. The location was the transverse splice weld joining the bottom panel of segment 12BW and 12CW at work point W4 to W3. The welder ID was 049220. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231T-ESAB.

The QA Inspector observed the welding operation per the FCAW process on weld joint no. 002 in the (1G) flat position on bottom panel piece mark no. OBW12D. The location was the transverse splice weld joining the bottom panel of segment 12BW and 12CW at work point W4 to W3. The welder ID was 054660. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231T-ESAB.

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

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The QA Inspector observed the welding operation per the SMAW process on weld joint no. 024 in the (2F) horizontal position on side panel WT stiffener piece mark no. SP3009-001. The location was the hold back of WT stiffener fillet weld of segment 12CE. The welder ID was 040270. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212-FCM-1.

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 023 in the (2F) horizontal position on side panel WT stiffener piece mark no. SP3005-001. The location was the hold back of WT stiffener fillet weld of segment 12BE. The welder ID was 040270. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212-FCM-1.

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

The QA Inspector observed the welding operation per the FCAW process on weld joint no. 031 in the (3G) vertical position on side panel WT stiffener piece mark number SP3020-001. The location was the complete joint penetration groove weld joining the WT stiffeners of segment 12BE and 12CE. 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-2233-ESAB.

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

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 005 in the (4G) overhead position on edge and side panel piece mark no. CA3003. The location was the complete joint penetration groove weld joining the edge and side panel of segment 12BE at work point E1. The welder ID was 050289. The ZPMC CWI was identified as Li Yang. 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. 001 in the (4G) overhead position on edge and side panel piece mark no. CA3005. The location was the complete joint penetration groove weld joining the edge and side panel of segment 12CE at work point E1. The welder ID was 050289. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-Tc-U4b-FCM-1.

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

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 002 in the (4G) overhead position on side panel piece mark no. OBW12D. The location was the transverse splice weld joining the side panel of segment 12AW and 12BW at work point W4 to W6. The welder ID was 046709. The welding was performed against critical welding repair report B-CWR2709 Rev.01. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-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

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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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