

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019399**Date Inspected:** 21-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)**Location:** Shanghai, China**CWI Name:** Li Yang and Zhu Zhong Hai**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 Trial Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. S. Manjunath Math 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:

Orthotropic Box Girder (OBG) at Trial Assembly Areas

Bike Path at Bay # 8

This QA Inspector performed Dimension Control Inspection on the Bike Path bottom plate for flatness check across the longitudinal butt weld. Flatness check was performed on following mentioned Bike Paths and Bike Path are identified as:

BK004A-059.

The QA Inspector measured the flatness using 600mm long straight edge across the Butt (CJP) weld and using 1500mm long straight edge between the stiffeners which are plug weld to bottom plate.

Observed flatness within the allowable tolerance.

The result of the inspection was informed to ZPMC QC Supervisor Mr. Liu Famen, ABF Mr. Wang Zhong Yuan

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and Caltrans Lead Inspector Mr. Mark Miller and Mr. Hiranch Patel.

Bike Path at Bay # 3

This QA Inspector performed Dimension Control Inspection on the Traveler Rail against the Inspection Notification 08247 dated January 21, 2011.

The following check was performed on the Traveler Rail 20TR2-042.

Measured the overall length.

Measured the overall sweep.

Measured the thickness at typical section-Fixed End.

Measured the thickness at typical section-Sliding End.

Measured the Flange width at typical section-Fixed End.

Measured the Flange width at typical section-Sliding End.

Measured the depth at typical section-Fixed End.

Measured the depth at typical section-Sliding End.

Measure the Flange curl at typical section-Fixed End.

Measure the Flange curl at typical section-Sliding End.

Segment 12BW to Segment 12CW (I- Rib Splice weld)

This QA Inspector observed the in-process welding by Shielded Metal Arc Welding (SMAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as SP3038-001-033. The welder identification was 041713 observed welding in the 3G (Vertical) position using approved Welding Procedure Specification WPS-B-P-2213-B-U2-FCM-1. The piece mark was identified as the Side Panel Corner Assembly, I-Rib splice, Cross Beam side.

Please reference the pictures attached for more comprehensive details.

Segment 12BW to Segment 12CW (I- Rib Splice weld)

This QA Inspector observed the in-process welding by Shielded Metal Arc Welding (SMAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as SP3038-001-031. The welder identification was 047333 observed welding in the 3G (Vertical) position using approved Welding Procedure

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Specification WPS-B-P-2213-B-U2-FCM-1. The piece mark was identified as the Side Panel Corner Assembly, I-Rib splice, Cross Beam side.

Segment 12BW to Segment 12CW (Deck Panel Transverse Splice)

This QA Inspector observed the in-process welding by Shielded Metal Arc Welding (SMAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as CA3012-001. The welder identification was 046704 and 040611 and was observed welding in the 1G (Flat) position using approved Welding Procedure Specification WPS-B-P-2211-B-U2-FCM-1. The piece mark was identified as the Deck Panel Corner Assembly, transverse splice weld.

Segment 12BW (Bottom Panel to Side Panel hold back weld)

This QA Inspector observed the in-process welding by Shielded Metal Arc Welding (SMAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as Seg3006A-011. The welder identification was 040611 and was observed welding in the 4G (Overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1. The piece mark was identified as weld connecting Bottom Panel to Side Panel hold back weld at work point W3.

Segment 12BE to Segment 12CE

This QA Inspector observed the repair welding by Shielded Metal Arc Welding (SMAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as OBE12E-003. The welder identification was 040378 and observed welding in the 4G (Overhead) position using approved Welding Procedure Specification WPS-345-SMAW-4G(4F)-Repair-FCM-1. The piece mark was identified as the Transverse splice and Temporary attachment removal area. ZPMC performed repair welding in accordance with Critical Welding Report B-CWR2126.

Segment 12BW to Segment 12CW (T- Rib Splice weld)

This QA Inspector observed the in-process welding by Shielded Metal Arc Welding (SMAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as SP3051-001-038. The welder identification was 046709 and observed welding in the 4G (Overhead) position using approved Welding Procedure Specification WPS-B-P-2213-B-U2-FCM-1. The piece mark was identified as the Side Panel, T-Ribs at transverse splice, Cross Beam side.

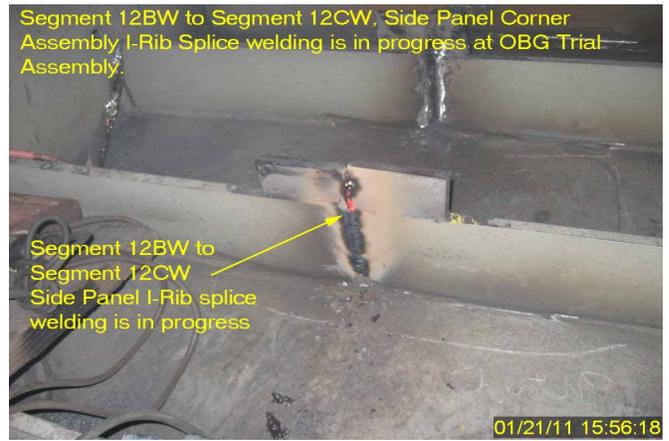
Segment 12BW to Segment 12CW (T- Rib Splice weld)

This QA Inspector observed the in-process welding by Shielded Metal Arc Welding (SMAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as SP3050-001-042. The welder identification was 046709 and observed welding in the 3G (Vertical) position using approved Welding Procedure Specification WPS-B-P-2213-B-U2-FCM-1. The piece mark was identified as the Side Panel, T-Ribs at transverse splice, Counter Weight side.

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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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 150000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Math,Manjunath	Quality Assurance Inspector
Reviewed By:	Dsouza,Christopher	QA Reviewer
