

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-020103**Date Inspected:** 24-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Yu Jiao (ABF)**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:** BAY 14 OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Robert A. DeArmond was present during the time noted above and conducted observations relative to the work being performed.

OBG BAY 14

This QA Inspector observed the following work in progress:

FCAW welding of complete joint penetration weld joint(s) located on Grillage Plate Sub-Assembly, Segment 13A "W" Line identified as SA7512C weld number(s) 206, 207, 208, 209, and 210. Welder is identified as welder no. 062708. The welding variables recorded by ZPMC QC identified as Li Ping appeared to comply with applicable WPS(s) WPS-B-T-2231-ESAB.

FCAW welding of complete joint penetration weld joint(s) located on Grillage Plate Sub-Assembly, Segment 13A "W" Line identified as SA7512C weld number(s) 269, 270, 272, and 273. Welder is identified as welder no. 066002. The welding variables recorded by ZPMC QC identified as Li Ping appeared to comply with applicable WPS(s) WPS-B-T-2231-ESAB.

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SMAW welding of complete joint penetration weld joint(s) located on Grillage Plate Sub-Assembly, Segment 13A “W” Line identified as SA7512 weld number(s) 225, and 226. Welder is identified as welder no. 067611. The welding variables recorded by ZPMC QC identified as Li Ping appeared to comply with applicable WPS(s) WPS-B-P-2211-TC-U4b-FCM 1.

SMAW welding of complete joint penetration weld joint(s) located on Grillage Plate Sub-Assembly, Segment 13A “W” Line identified as SA7512 weld number(s) 223, and 227. Welder is identified as welder no. 037780. The welding variables recorded by ZPMC QC identified as Li Ping appeared to comply with applicable WPS(s) WPS-B-P-2211-TC-U4b-FCM 1.

SMAW welding of complete joint penetration weld joint(s) located on Grillage Plate Sub-Assembly, Segment 13A “W” Line identified as SA7512 weld number(s) 224, and 228. Welder is identified as welder no. 066002. The welding variables recorded by ZPMC QC identified as Li Ping appeared to comply with applicable WPS(s) WPS-B-P-2211-TC-U4b-FCM 1.

OBG BAY 13

During the Quality Assurance (QA) random in-process observations of the fabrication of East Saddle Grillage, located in Bay 13, this Caltrans QA Inspector observed the following issue:

The connection plate (X3811A) to the Grillage Plate A (X3788A, 3787A, X3786A) Partial Joint Penetration corner welds with root openings between 9mm to 11mm in a total of three (3) locations. -The welds are designated as SA7038-015, 020 and 024. The welds are designated on the contract drawings as Seismic Performance Critical Members (SPCM).

For further information, please see the attached pictures below.

OBG BAY 14

During a random visual inspection of the Orthotropic Box Girder (OBG) Longitudinal Diaphragm, this Caltrans Quality Assurance (QA) Inspector observed the following issue.

ZPMC personnel performing base metal repair on the Longitudinal Diaphragm (LD3034) web at W3, panel point 119 +1500 of Segment 13AW without the Engineer’s approval. Repairs were being performed adjacent to the Vertical web splice identified as LD3034-003 and floor beam to LD weld identified as SEG3013F-006.

-The material utilized is A709 Grade 345 SPCM.

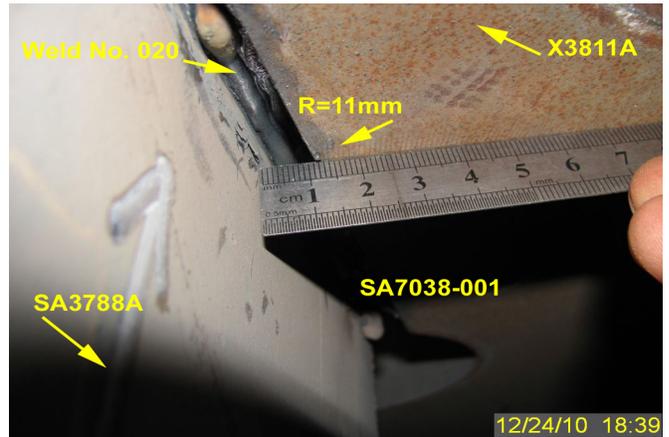
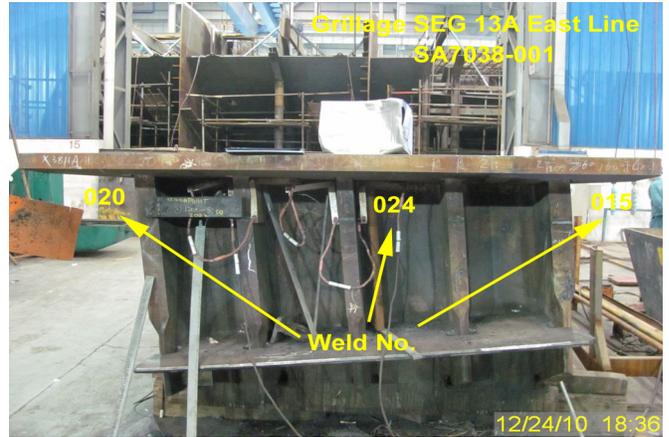
-The welding process used was SMAW.

For further information, please see the attached pictures below.

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



Summary of Conversations:

As mentioned above between QA and QC concerning this project

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 1500-0042-02372, who represents the Office of Structural Materials for your project.

Inspected By: DeArmond,Robert

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer