

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-020590**Date Inspected:** 15-Feb-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

Segment 12BE to Segment 12CE (Bottom Panel, Transverse Splice weld)

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 OBE12C-001. The welder identification was 044515 and observed welding in the 1G (Flat) position using approved Welding Procedure Specification WPS-345-SMAW-1G(1F)-FCM-Repair-1. The piece mark was identified as the Bottom Panel, at transverse splice. ZPMC performed repair welding in accordance with Welding Repair Report B-WR20190.

Please reference the pictures attached for more comprehensive details.

Segment 12BE to Segment 12CE (Transverse Splice weld)

This QA Inspector observed the back-gouging is in-process for the weld repair areas on the Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as OBE12E-002. The piece mark was identified as

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the Side Panel, Cross Beam side at transverse splice.

Segment 12BE to Segment 12CE (Transverse Splice weld)

This QA Inspector observed the grinding work at back-gouged areas for the weld repair areas on the Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as OBE12E-003. The piece mark was identified as the Side Panel, Bike Path side at transverse splice.

Segment 12AW to Cross Beam # 17

This QA Inspector observed the Fit-up work using temporary attachments between the I-Ribs of Segment 12AW FL3 Bottom Plate to the Cross Beam # 17 I-Ribs between PP 110 to PP 111. The welder was identified as 062200.

Please reference the pictures attached for more comprehensive details.

Segment 12BE to Segment 12CE

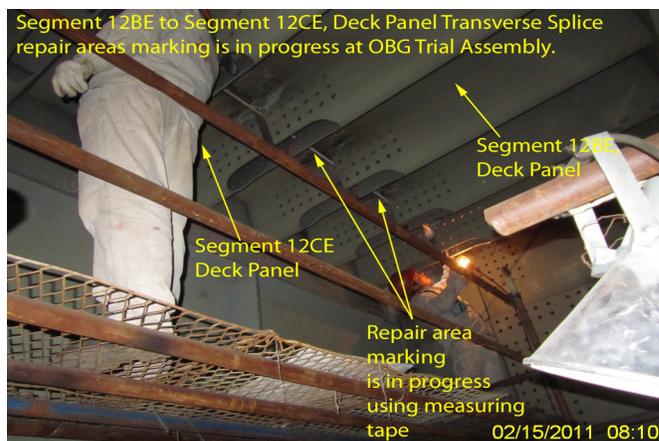
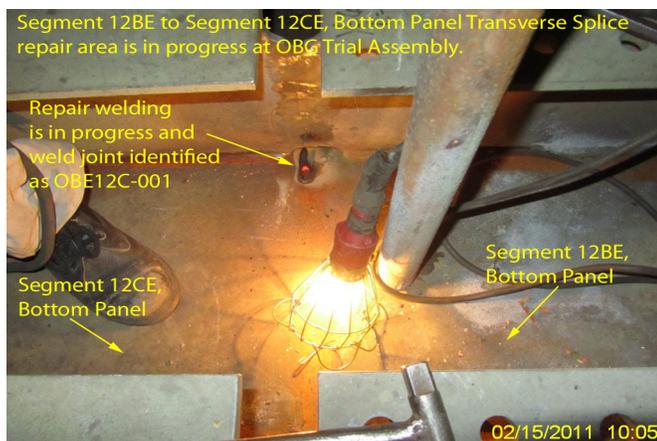
This QA Inspector observed the ZPMC personnel and ABF QA performing the repair location marking for carbon arc gouging at Deck Panel transverse splice for Segment 12BE to Segment 12CE. The weld joint is identified as OBE12-003.

Please reference the pictures attached for more comprehensive details.

Segment 12AW

This QA observed that ZPMC was not performing any work on the above mentioned components during the time, this QA inspectors was present.

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



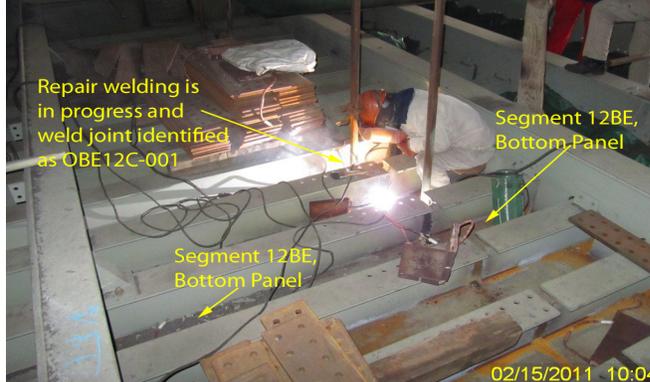
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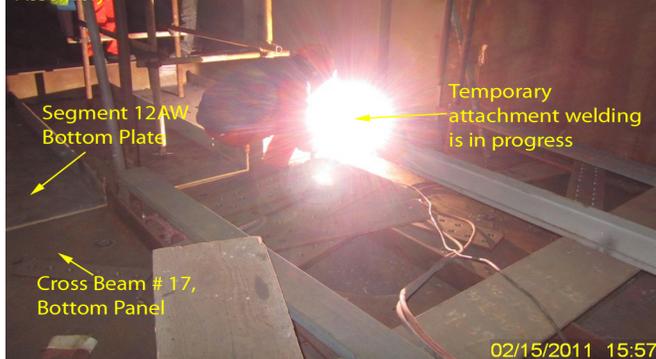
Segment 12BE to Segment 12CE, Deck Panel Transverse Splice repair areas marking is in progress at OBG Trial Assembly.



Segment 12BE to Segment 12CE, Bottom Panel Transverse Splice repair welding is in progress at OBG Trial Assembly.



Segment 12AW Bottom Plate to Cross Beam # 17 Bottom Panel, Fit-up is in progress for the I- Stiffeners to I-Stiffeners at OBG Trial Assembly



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: Math,Manjunath

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer
