

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020929**Date Inspected:** 22-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), Changxing Island **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 12BW to Segment 12CW (U-Rib to U-Rib)

This QA Inspector performed Dimension Control Inspection for measuring offset on the U-Rib to U-Rib from Counter Weight side towards Cross Beam side at a total of 37 locations on Segment 12BW to Segment 12CW between Panel Points (PP) 114 to PP 115 at the following locations:

The offset was measured within 50mm from the Deck Panel on U-Rib on the South and North side. The QA Inspector measured the Offset using 1(One) Meter Straight Edge.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition

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

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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 Seg3002A-004. The welder identification was 052493 and observed welding in the 4G (Flat) position using approved Welding Procedure Specification WPS-345-SMAW-4G(4F)-FCM-Repair-1. The piece mark was identified as the weld connecting the Bottom Panel to Side Panel hold back weld; work point E3. ZPMC performed repair welding in accordance with Welding Repair Report B-WR20198.

Please reference the pictures attached for more comprehensive details.

Segment 12CW (Longitudinal Diaphragm to Bottom 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 Seg3006S-035. The welder identification was 046709 and observed welding in the 2G (Horizontal) position using approved Welding Procedure Specification WPS-B-T-2232-ESAB. The piece mark was identified as the weld connecting the Longitudinal Diaphragm to Bottom Panel hold back at work point W3.

Please reference the pictures attached for more comprehensive details.

Segment 12CE (Longitudinal Diaphragm to Deck 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 DP3029-001-009. The welder identification was 052493 and observed welding in the 4G (Overhead) position using approved Welding Procedure Specification WPS-B-P-2214-Tc-U4b-FCM-1. The piece mark was identified as the weld connecting the Longitudinal Diaphragm to Deck Panel hold back at work point E3.

Segment 12BE (Lower Chevron)

This QA Inspector observed the ZPMC personnel performing the faying surfaces cleaning between the Splice Plates to the Lower Chevron at East and West side at Cross Beam side.

Please reference the pictures attached for more comprehensive details.

Segment 12AE (Lower Chevron)

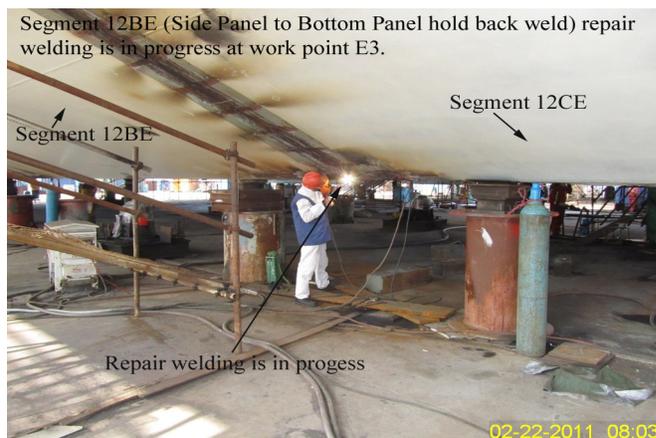
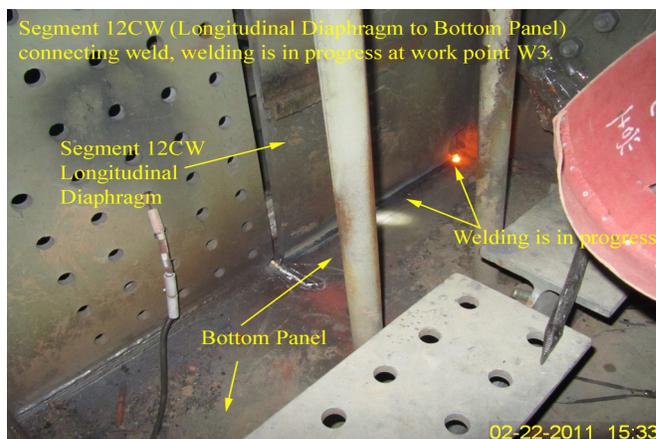
This QA Inspector observed the ZPMC personnel performing Rotation-of-Nut for the bolts connecting the Lower Chevron H-Beam to the Floor Beam at west side.

Please reference the pictures attached for more comprehensive details.

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

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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.

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Inspected By:	Math,Manjunath	Quality Assurance Inspector
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Reviewed By:	Miller,Mark	QA Reviewer
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