

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-020931**Date Inspected:** 24-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 12AW (Lower Chevron Flatness Survey)

This QA Inspector performed Dimension Control Inspection along with ZPMC QC Mr. Hu Mei Gang on the Splice plate installed at Lower Chevron from East and West side to ensure flatness is within the allowable tolerance before snug tightening the bolts for Segment 12AW at Panel Points (PP) 109, 110, PP 111 and PP 112 (Cross Beam Side at work point W4) and (Counter Weight side at work point W3).

The QA Inspector measured the Flatness using 1(One) Meter Straight Edge and the results appeared to be in general compliance with contract requirements.

Note: At PP 111 (Cross Beam side) flatness not measured as it was not offered by ZPMC QC.

Segment 12BW to Segment 12CW (Bottom Panel, Transverse Splice weld)

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

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 OBW12C-001. The welder identification was 047353 and observed welding in the 4G (Overhead) position using approved Welding Procedure Specification WPS-345-SMAW-4G(4F)-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-WR20263.

Segment 12CE (Side Panel to Edge Panel hold back 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 Seg3002N-017. The welder identification was 044504 and was observed welding in the 4G (Overhead) position using approved Welding Procedure Specification WPS-345-SMAW-4G(4F)-FCM-Repair-1. The piece mark was identified as weld connecting the Side Panel to Edge Panel at work point E6.

Please reference the pictures attached for more comprehensive details.

Segment 12BW to Segment 12CW (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 OBW12C-001. The welder identification was 047353 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-WR20263.

Segment 12BW to Segment 12CW (Deck Panel, Transverse 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 OBW12A-001. The welder identification was 057333 and 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 the Deck Panel, at transverse splice.

Please reference the pictures attached for more comprehensive details.

Segment 12CE (Deck Panel to Edge Panel hold back 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 CA3003-006. The welder identification was 052493 and was observed welding in the 4G (Overhead) position using approved Welding Procedure Specification WPS-345-SMAW-4G(4F)-FCM-Repair-1. The piece mark was identified as weld connecting the Deck Panel to Edge Panel at work point E2.

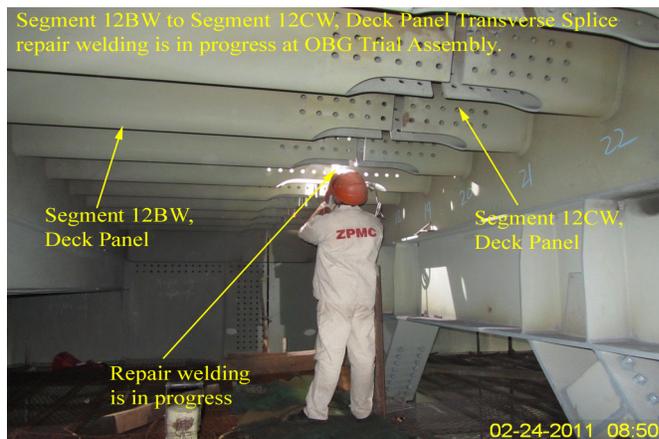
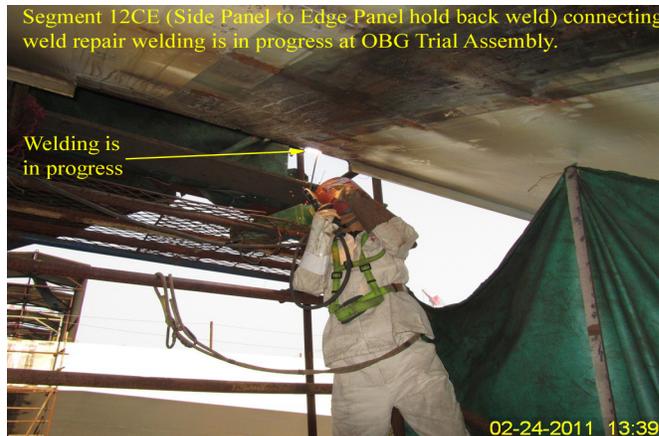
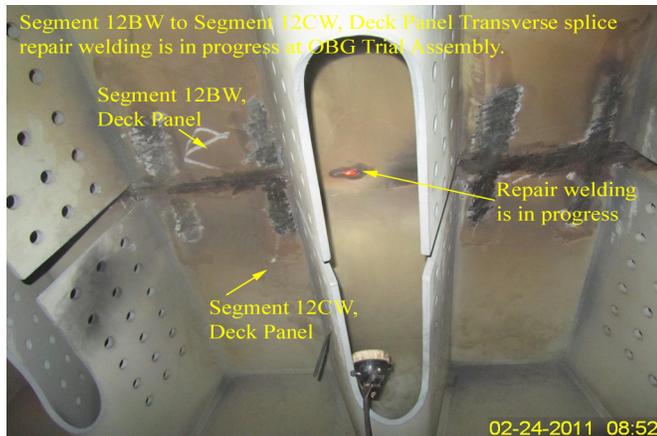
Segment 12AW (Bottom Panel to Longitudinal Diaphragm hold back weld)

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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 Seg3004X-051. The welder identification was 046704 and was observed welding in the 2G (Horizontal) position using approved Welding Procedure Specification WPS-345-SMAW-2G(2F)-FCM-Repair-1. The piece mark was identified as weld connecting the Bottom Panel to the Longitudinal Diaphragm at work point W3.

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 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Math,Manjunath

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer