

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-021110**Date Inspected:** 26-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 12BE to Segment 12CE (Side 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 OBW12E-002. The welder identification was 067752 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 Side Panel, Cross Beam side at transverse splice. ZPMC performed repair welding in accordance with Critical Welding Repair Report B-CWR2805.

Please reference the pictures attached for more comprehensive details.

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

This QA Inspector observed the repair welding by Shielded Metal Arc Welding (SMAW) process on a Complete

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

Joint Penetration (CJP) groove weld. The Weld joint was designated as OBW12E-002. The welder identification was 040403 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 Side Panel, Bike Path side at transverse splice. ZPMC performed repair welding in accordance with Critical Welding Repair Report B-CWR2812.

Please reference the pictures attached for more comprehensive details.

Segment 12AE (Partial Height Diaphragm, Stiffener)

This QA Inspector observed the in-progress welding by Shielded Metal Arc Welding (SMAW) process on a Fillet weld. The Weld joint was designated as Seg3001AG-102. The welder identification was 066459 and observed welding in the 3F (Vertical) position using approved Welding Procedure Specification WPS-B-T-2132-ESAB. The piece mark was identified as the weld connecting the Partial Height Diaphragm Stiffener to the Floor Beam.

Please reference the pictures attached for more comprehensive details.

Segment 12BW to Segment 12CW (Bottom Panel, T-Ribs hold back weld repair)

This QA Inspector observed the repair welding by Shielded Metal Arc Welding (SMAW) process on a Complete Joint Penetration (CJP) groove weld. The welder identification was 202316 and 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 the Bottom Panel T-Ribs hold back. ZPMC performed repair welding in accordance with Critical Welding Repair Report B-CWR2026.

Segment 12AE (Lower Chevron)

This QA Inspector observed the ZPMC personnel performing the Rotation-of-Nut for the bolts installed at the Lower Chevron at East and West side at Cross Beam side.

Please reference the pictures attached for more comprehensive details.

Segment 12AE to Segment 12BE (Bottom Panel, T-Ribs match drilling)

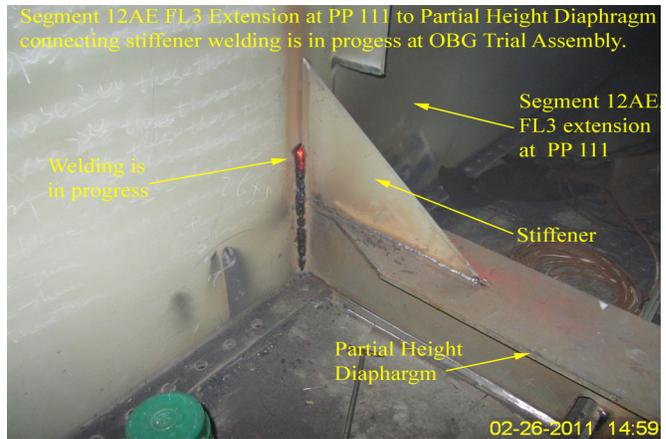
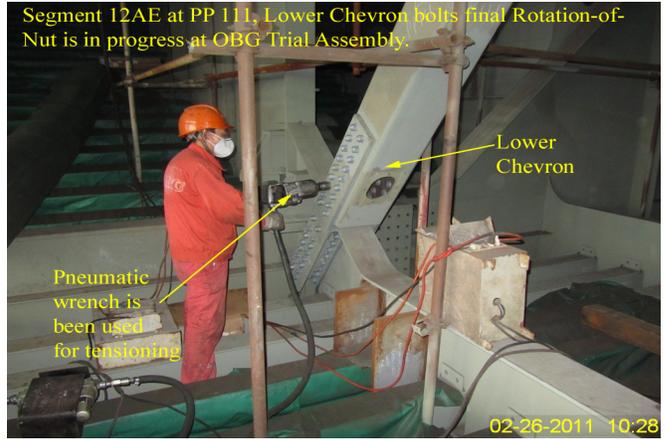
This QA Inspector observed the ZPMC personnel performing match drilling for the Bottom Panel T-Ribs at flange for the Segment 12AE to Segment 12BE between Panel Points (PP) 112 and PP 113.

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.

WELDING INSPECTION REPORT

(Continued Page 3 of 4)



WELDING INSPECTION REPORT

(Continued Page 4 of 4)



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
