

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-021111**Date Inspected:** 25-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) 111 (Cross Beam Side at work point W4).

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

Segment 12BW to Segment 12CW (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-001. The welder identification

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was 040611 and observed welding in the 3G (Vertical) position using approved Welding Procedure Specification WPS-345-SMAW-3G(3F)-FCM-Repair-1. The piece mark was identified as the Side Panel, at transverse splice. ZPMC performed repair welding in accordance with Welding Repair Report B-WR20193.

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.

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-002. The welder identification was 202316 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 Corner Assembly, at transverse splice.

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.

Please reference the pictures attached for more comprehensive details.

Segment 12BW to Segment 12CW (Side Panel, Transverse Splice 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 040611 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 T-Ribs hold back. ZPMC performed repair welding in accordance with Welding Repair Report B-WR20193.

Segment 12BW (Deck Panel and Edge Panel connecting 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 CA3009-006. The welder identification was 046709 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 Deck Panel to Edge

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Panel hold back weld at work point W5. ZPMC performed repair welding in accordance with Welding Repair Report B-WR20283.

Segment 12CW (Deck Panel and Edge Panel connecting weld)

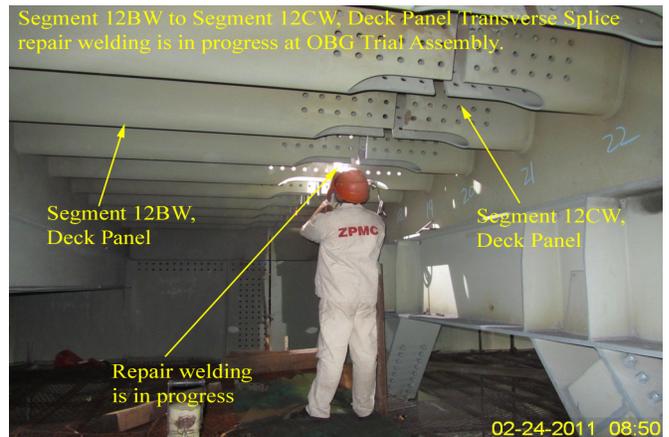
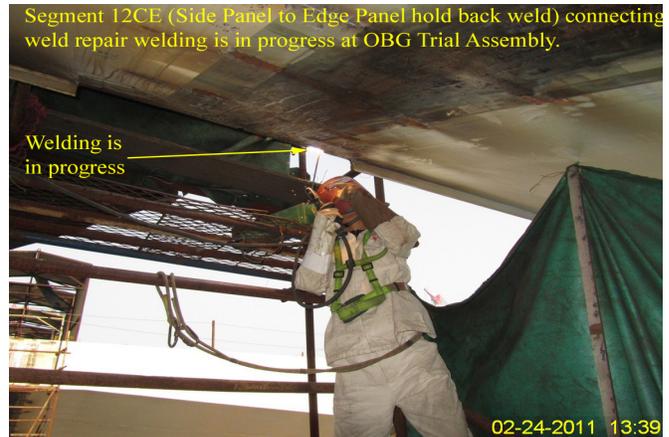
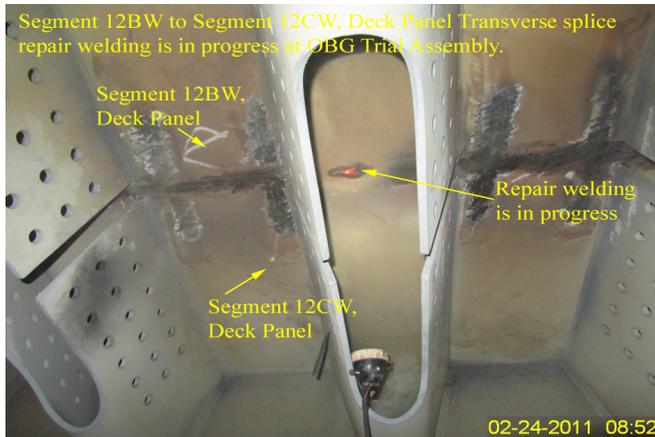
This QA Inspector observed the repair welding by Shielded Metal Arc Welding (SMAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as CA3011-002. The welder identification was 046709 and was observed welding in the 4G (Overhead) position using approved Welding Procedure Specification WPS-345-SMAW-4G(4F)-FCM-Repair-1. The piece mark was identified as Deck Panel to Edge Panel hold back weld at work point W5. ZPMC performed repair welding in accordance with Welding Repair Report B-WR20283.

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.



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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.

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