

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011570**Date Inspected:** 17-Jan-2010**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**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 Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, M. Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # TRIAL ASSEMBLY YARD

This QA inspector measured and recorded root gap and offset for below segment. Reports forwarded to team leader for further action.

7AE-7BE

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (6BW)**SMAW Process:**

Welding of weld joint – 005 located on PCMK CA027, Corner assembly longitudinal weld joining edge and Deck panel of 6BW. Welder is identified as 068764. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

OBG # TRIAL ASSEMBLY YARD (6CW)

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SMAW Process:

Welding of weld joint – 005 located on PCMK CA029, Corner assembly longitudinal weld joining edge and Deck panel of 6CW. Welder is identified as 068764. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

OBG # TRIAL ASSEMBLY YARD (7AE-7BE)

SMAW Process:

Welding of weld joint – 003 located on PCMK OBE7B, Bottom panel transverse splice joining 7AE and 7BE. Welder is identified as 053742. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-B-U2-F-3.

OBG # TRIAL ASSEMBLY YARD (7AE-7BE)

FCAW Process:

Welding of weld joint –002 and 003 located on PCMK OBE7, Deck panel transverse splice joining 7AE and 7BE. Welder is identified as 220066. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-223(2) T-2.

FCAW Process:

Welding of weld joint –004 located on PCMK OBE7, Deck panel transverse splice joining 6BW and 6CW. Welder is identified as 220067. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-223(2) T-2.

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

Summary of Conversations:

No Relevant Conversation.

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

Inspected By:	Manikandan,Murugan	Quality Assurance Inspector
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Reviewed By:	Miller,Mark	QA Reviewer
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