

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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011572**Date Inspected:** 16-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 performed T-Rib dimensional survey along for below segments. Reports forwarded to team leader for further action

6BW-6CW

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (5CE)**SMAW Process:**

Welding of weld joint – 004 located on PCMK CA024, Corner assembly longitudinal weld joining edge and Deck panel of 5CE. Welder is identified as 044772. ZPMC CWI is identified as Li Yang. Welding was performed against Critical welding repair report B-CWR1075 Rev. 0 and UT Repair report UT-5E-018. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

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OBG # TRIAL ASSEMBLY YARD

FCAW Process:

Welding of weld joint – 005, 006 and 007 located on PCMK BK001-024, Bike path cantilever. Welder is identified as 220066. Welding was been performed against welding repair report B-WR9899 Rev. 0. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-1G (1F)-Repair.

FCAW Process:

Welding of weld joint – 005, 006 and 007 located on PCMK BK001-019, Bike path cantilever. Welder is identified as 066261. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-1G (1F)-Repair.

OBG # TRIAL ASSEMBLY YARD (6BW-6CW)

SMAW Process:

Welding of weld joint –013 and 014 located on PCMK EP041-001, Edge panel I Rib at Counterweight side. Welder is identified as 066261. 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 (5BW-5CW)

SMAW Process:

Welding of weld joint –005 located on PCMK SEG023A, Bottom panel to side panel longitudinal weld at work point W4. Welder is identified as 037743. Welding was been performed against Critical welding repair report B-CWR1074 Rev. 0. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1.

OBG # TRIAL ASSEMBLY YARD (6AW-6BW)

Heat straightening of longitudinal diaphragm located on 6AW-6BW Crossbeam side. ZPMC CWI is identified as Li Yang. Heat straightening was been performed and appeared to comply with the HSR1 (B)-7992 Rev.0 dated 11th Dec. 2009. The weld designations reviewed are as follows:

SEG029B-007/008

SEG029C-038/039

SEG027D-035/038

SEG027F-035/038

LD009A-01 to 010

LD010A-01 to 010

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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
Reviewed By:	Miller,Mark	QA Reviewer
