

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-011989**Date Inspected:** 06-Feb-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 segments. Reports forwarded to team leader for further action

7BW-7CW

Please see the attached pictures below.

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (7AW-7BW)**FCAW Process:**

Welding of weld joint -031 and 032 located on PCMK SP429-001, side panel hold back area. Welder is identified as 066673. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233T.

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OBG # TRIAL ASSEMBLY YARD (7AW-7BW)

FCAW Process:

Welding of weld joint –037 and 038 located on PCMK BP089-001, bottom panel hold back area. Welder is identified as 050316. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2-F.

FCAW Process:

Welding of weld joint –041 and 042 located on PCMK BP143-001, bottom panel hold back area. Welder is identified as 045280. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2-F.

OBG # TRIAL ASSEMBLY YARD (7BW-7CW)

FCAW Process:

Welding of weld joint –008 located on PCMK OBW7C, bottom panel transverse splice weld joining 7BW and 7CW. Welder is identified as 066673. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231T.

OBG # TRIAL ASSEMBLY YARD (7BW-7CW)

FCAW Process:

Welding of weld joint –006 located on PCMK OBW7C, Side panel transverse splice weld joining 7BW and 7CW at counterweight side. Welder is identified as 066673. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233T.

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 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