

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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013160**Date Inspected:** 17-Mar-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 deck panel to deck panel diaphragm dimensional survey along with QA inspector (Mr. Manoj) for below segment using right angle and straight edge 710mm. Reports forwarded to team leader for further action.

6AW- PP37 (East side)

6CW- PP47 (West side)

This QA Inspector randomly observed the following work in progress:

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

Buttering of X37A corner assembly stiffener connected with web plates and deck plates. ZPMC CWI is identified as Li Yang. Welding was been performed against welding repair report # B-WR11081 Rev. 0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-Repair.

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

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

SMAW Process:

Welding of weld joint –008 located on PCMK OBE7C, bottom panel. Welder is identified as 067572. 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.

SMAW Process:

Welding of weld joint –008 located on PCMK OBE7C, bottom panel. Welder is identified as 062092. 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 (7BE-7CE)

SMAW Process:

Welding of weld joint –010 located on PCMK OBE7A, Edge panel. Welder is identified as 048659. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2213-B-U2-FCM-1.

Please see the attached picture below

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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Manikandan, Murugan	Quality Assurance Inspector
----------------------	---------------------	-----------------------------

Reviewed By:	Miller, Mark	QA Reviewer
---------------------	--------------	-------------