

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-013145**Date Inspected:** 04-Apr-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 witnessed final tension verification for lower and upper chevron (North & South) of Segment 7AE and 7BE. Witnessed 10% on a random basis the bolts and found the tension to be in general compliance. The panel point and bolt size designations are as follows:

PP48 to PP 52:

M22 X 80 – DHGM 220050 – 486 NM

For further information, Please see the pictures below

OBG # TRIAL ASSEMBLY YARD

This QA Inspector performed dimensional survey with QA Inspector Mr. Manjunath for the Skin Flatness across Transverse Splice Joints at Location B1, B2, B3, B4, T1 and T2 for below segment. Readings forwarded to team leader for further action.

7BE-7CE (PP52-PP53)

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- 5M string line, 600 and 630mm straight edge.

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (Lift 7W)

SMAW Process:

Welding of weld joint –004 located on PCMK CA031, Corner assembly longitudinal weld joining edge and deck panel. Welder is identified as 045196. ZPMC CWI is identified as Li Yang. Welding was been performed against critical welding repair report B-CWR1229 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-FCM-Repair-1.

OBG # TRIAL ASSEMBLY YARD (CB7)

SMAW Process:

Welding of weld joint –222 located on SSD27-PP51, 7BW-FL3 weld. Welder is identified as 220067. ZPMC CWI is identified as Li Yang. Welding was been performed against welding repair report B-WR10512 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-Tc-U4b-FCM-1.

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.

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Inspected By: Manikandan,Murugan

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer