

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-013695**Date Inspected:** 30-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 performed dimensional check along with ABF on longitudinal diaphragm to check offset for web and flange for below segment. Reports forwarded to team leader for further action

7DE-7EE

OBG # TRIAL ASSEMBLY YARD

This QA inspector performed dimensional check along with ABF for skin flatness for below segment using 5M string line, 600mm and 630mm straight edge. Reports forwarded to team leader for further action

7DE-7EE

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (CB7)

WELDING INSPECTION REPORT

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SMAW Process:

Welding of weld joint – 018 located on PCMK SP207-007, Cross beam 7. Welder is identified as 067765. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2114-FCM-1.

SMAW Process:

Welding of weld joint – 020 located on PCMK SP202-007, Cross beam 7. Welder is identified as 067829. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2114-FCM-1.

SMAW Process:

Welding of weld joint – 020 located on PCMK SP201-007, Cross beam 7. Welder is identified as 039932. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2114-FCM-1.

OBG # TRIAL ASSEMBLY YARD (7DW-7EW)

SMAW Process:

Welding of weld joint – 020 located on PCMK BP092-001, Bottom panel T-rib web to web CJP weld joints 7DW and 7EW. Welder is identified as 067588. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2213-B-U2a-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.

Inspected By:	Manikandan,Murugan	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
