

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-015128**Date Inspected:** 26-Jun-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 visual inspection and dimensional checks on weld access cope holes on segment 8AW. Inspection was performed against ABF Inspection report CWAHIR-10CW-01 dated 20th May, 2010. The locations exhibited radii edge discontinuities are identified and after repair appears to be comply with the contract documents.

OBG # TRIAL ASSEMBLY YARD

This QA Inspector observed ZPMC personnel installing retrofit plate at side and bottom panel of Segment 8BE between Panel point 64 and 65. These locations are identified earlier as out of tolerance for skin flatness by joint survey of CT and ABF. Installation was performed against ZPMC report GGL-MQ-1666.

OBG # TRIAL ASSEMBLY YARD

This QA Inspector observed ZPMC personnel installing retrofit plate at side and bottom panel of Segment 8CE between Panel point 67 and 68. These locations are identified earlier as out of tolerance for skin flatness by joint survey of CT and ABF. Installation was performed against ZPMC report GGL-MQ-1666.

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For additional information please reference the pictures below:

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (8CE)

SMAW Process:

Welding of weld joint – 046 located on PCMK SEG048B, Longitudinal weld joints bottom and side panel of 8CE at E4 location between panel point 70 and 71. Welder is identified as 053253. Welding was been performed against critical welding repair report B-CWR1618. ZPMC CWI is identified as Wuzhi Cheng. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

OBG # TRIAL ASSEMBLY YARD (9AE-9BE)

SMAW Process:

Welding of weld joint – 004 located on PCMK OBE9B, Side panel transverse splice weld joints segment 9AE and 9BE. Welder is identified as 053253. Welding was been performed against critical welding repair report B-CWR1592. ZPMC CWI is identified as Wuzhi Cheng. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F)-FCM-Repair-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 Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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