

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-015400**Date Inspected:** 23-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 # OUTSIDE YARD

This QA Inspector performed joint Survey Inspection along with ABF for the following Segment 11AE from Panel Point 95 to 97. The measurements are recorded in the designated sheet and forwarded to team leader for further action.

Inspection details as follows

1) Radius measurement on corner assembly cope holes.

OBG # TRIAL ASSEMBLY YARD

This QA Inspector performed dimensional survey on X37B stiffener to confirm offset for the below segment. Relevant pictures and survey data are forwarded to team leader for further action.

7DW – PP 57.75

For further information, please see the attached pictures below.

WELDING INSPECTION REPORT

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This QA Inspector randomly observed the following work in progress:

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

FCAW Process:

Welding of weld joint – 026 located on PCMK BP125-001, T-Rib CJP weld joints segment 9BE and 9CE. Welder is identified as 220066. 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 – 026 located on PCMK BP071-001, T-Rib CJP weld joints segment 9BE and 9CE. Welder is identified as 222396. 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.

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.

Inspected By: Manikandan, Murugan

Quality Assurance Inspector

Reviewed By: Carreon, Albert

QA Reviewer