

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-015403**Date Inspected:** 27-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: Wuzhi Cheng
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: 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.

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD(8BE-8CE)

FCAW Process:

Welding of weld joint – 045 to 048 located on PCMK Retro-G-01-B1/B2/B3, Retrofit plate at side panel of Segment 8CE. Welder is identified as 220013. ZPMC CWI is identified as Wuzhi Cheng. Those locations are identified earlier as out of tolerance for skin flatness by joint survey of CT and ABF. Welding was performed against ZPMC report GGL-MQ-1666. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

OBG # TRIAL ASSEMBLY YARD (8CW)

SMAW Process:

Welding of weld joint – 039 located on PCMK OBW8E, Counterweight connection plate of 8CW at PP 68. Welder is identified as 067904. ZPMC CWI is identified as Wuzhi Cheng. The welding variables recorded by QC

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appeared to comply with the WPS-B-P-2213-FCM-1.

SMAW Process:

Welding of weld joint – 063 and 064 located on PCMK OBW8E, Counterweight connection plate of 8CW at PP 68. Welder is identified as 067904. ZPMC CWI is identified as Wuzhi Cheng. The welding variables recorded by QC appeared to comply with the WPS-B-P-2114-FCM-1.

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

SMAW Process:

Welding of weld joint – 009 located on PCMK OBE9B, Side panel transverse splice weld joins segment 9BE and 9CE. Welder is identified as 062092. ZPMC CWI is identified as Wuzhi Cheng. 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 – 010 located on PCMK OBE9B, Side panel transverse splice weld joins segment 9BE and 9CE. Welder is identified as 048659. ZPMC CWI is identified as Wuzhi Cheng. 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 – 013 located on PCMK EP163-001, Edge panel I Rib CJP weld joins segment 9BE and 9CE. Welder is identified as 054467. ZPMC CWI is identified as Wuzhi Cheng. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-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 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
