

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-009851**Date Inspected:** 15-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Yumin**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 longitudinal diaphragm (LD) stiffener to Floor beam Stiffener (3250mm above Bottom panel – North & South) of Segment 2AE. Witnessed 10% on a random basis and the tension found to be in general compliance. The panel point, location and bolt size designations are as follows:

M22 X 80 (PP13, PP13.5, PP14) Green Tag Number: 382

M22 X 85 (PP13.5) Green Tag Number: 383

OBG # TRIAL ASSEMBLY YARD (1AAW-1AW)

This QA inspector collected data of ABF UT performance and reject able indications identified by UT for 1AAW-1AW Deck panel. Prepared and forwarded to team lead leader the Ultrasonic Transverse indication Evaluation Sheet and Scatter graph for further action.

OBG # TRIAL ASSEMBLY YARD (1AW-1BW)

This QA inspector performed Ultrasonic Testing (UT) and collected data of Caltrans QA Inspectors B205 and

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B287 reject able indications identified by UT for 1AW-1BW Bottom panel. Prepared and forwarded to team lead leader the Ultrasonic Transverse indication Evaluation Sheet and Scatter graph for further action.

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (5BE-5CE)

SMAW Process:

Welding of weld joint located on PCMK LD15E of longitudinal diaphragm (LD) 5CE. Welder is identified as 220064. ZPMC CWI is identified as Xu Yumin. Welding was been performed against Welding Repair Report B-WR8063. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F)-FCM-Repair-1.

OBG # TRIAL ASSEMBLY YARD (5BE-5CE)

This QA Inspector observed ZPMC performing heat straightening on longitudinal diaphragm LD of 5AE and 5BE. The areas performed heat straightening complies with Heat straightening report HSR1 (B)-7674 dated 09.09.26.

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
