

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-010248**Date Inspected:** 05-Nov-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 (Lift 1 West)

This QA inspector performed visual testing and dimensional check on cope hole and welds access for OBG lift 1 West segment for smoothness. Smoothness found to be in general compliance with the ABF inspection report no: CWAHIR-1W-03.

OBG # TRIAL ASSEMBLY YARD

This QA inspector performed dimensional check along with ABF on T-Rib for below segments and readings found to be out of tolerance. Reports forwarded to team leader for further action.

6AE- PP38

6AE- PP39

This QA Inspector randomly observed the following work in progress:

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

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SMAW Process:

Welding of weld joint -008 located on PCMK OBW1A Bottom panel of 1AW-1BW. Welder is identified as 066258. ZPMC CWI is identified as Xu Yumin. Welding was been performed against Critical Welding Repair Report

B-CWR875 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1.

SMAW Process:

Welding of weld joint -008 located on PCMK OBW1A Bottom panel of 1AW-1BW. Welder is identified as 067571. ZPMC CWI is identified as Xu Yumin. Welding was been performed against Critical Welding Repair Report

B-CWR875 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1.

SMAW Process:

Welding of weld joint -008 located on PCMK OBW1A Bottom panel of 1AW-1BW. Welder is identified as 048659. ZPMC CWI is identified as Xu Yumin. Welding was been performed against Critical Welding Repair Report

B-CWR875 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1.

SMAW Process:

Welding of weld joint -008 located on PCMK OBW1A Bottom panel of 1AW-1BW. Welder is identified as 054467. ZPMC CWI is identified as Xu Yumin. Welding was been performed against Critical Welding Repair Report

B-CWR875 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1.

SMAW Process:

Welding of weld joint -008 located on PCMK OBW1A Bottom panel of 1AW-1BW. Welder is identified as 066326. ZPMC CWI is identified as Xu Yumin. Welding was been performed against Critical Welding Repair Report

B-CWR875 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1.

SMAW Process:

Welding of weld joint -008 located on PCMK OBW1A Bottom panel of 1AW-1BW. Welder is identified as 059769. ZPMC CWI is identified as Xu Yumin. Welding was been performed against Critical Welding

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Repair Report

B-CWR875 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1.

SMAW Process:

Welding of weld joint -008 located on PCMK OBW1A Bottom panel of 1AW-1BW. Welder is identified as 066261. ZPMC CWI is identified as Xu Yumin. Welding was been performed against Critical Welding

Repair Report

B-CWR875 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-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 , who represents the Office of Structural Materials for your project.

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