

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-010345**Date Inspected:** 10-Nov-2009**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 dimensional check along with QA inspector Mr.Manjunath. S. Math on U-Rib for below segment. Reports forwarded to team leader for further action.

6AE-6BE (Before welding)

OBG # TRIAL ASSEMBLY YARD

This QA inspector performed dimensional check along with QA inspector Mr.Manjunath. S. Math on T-Rib for below segment. Reports forwarded to team leader for further action.

5BE (PP33-PP33.5)

5BE (PP33.5-PP34)

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (6BE)

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During Clamping fixture was fixing the position for 6AE and 6BE, it was found that the corner point between Bottom panel and side panel beside the strut plate had unfitness. To rectify this ZPMC performed cutting of weld joint -021 located on PCMK SEG028B Longitudinal Diaphragm of 6BE. Cutting was been performed against Welding Repair Report B-WR8442 Rev.0.

OBG # TRIAL ASSEMBLY YARD (6AE-6BE)

FCAW Process:

Welding of weld joint -004 located on PCMK OBE6B Bottom panel of 6AE-6BE. Welder is identified as 220063. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231T.

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:	Miller,Mark	QA Reviewer
