

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-010350**Date Inspected:** 18-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:** 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 performed Deck Panel to Deck Panel Diaphragm Survey for below segment. Reports forwarded to team leader for further action.

6BW- PP42

6BW- PP43

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (6AE-6BE)**SMAW Process:**

Welding of weld joint-031 between T-Rib to T-Rib CJP located on PCMK SP334-001 side panel of 6AE to 6BE. Welder is identified as 067571. ZPMC CWI is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-B-P-2213-B-U2-FCM-1.

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FCAW Process:

Welding of weld joint-036 between T-Rib to T-Rib CJP located on PCMK SP307-001 side panel of 6AE to 6BE. Welder is identified as 220067. ZPMC CWI is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2-F.

SMAW Process:

Welding of weld joint-021 between T-Rib to T-Rib CJP located on PCMK SP361-001 side panel of 6AE to 6BE. Welder is identified as 067589. ZPMC CWI is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-B-P-2213-B-U2-FCM-1.

OBG # TRIAL ASSEMBLY YARD (6AE)

SMAW Process:

Welding of weld joint-014 T-Rib fillet weld located on PCMK PP516-001 hold back area of 6AE I-Rib. Welder is identified as 068764. ZPMC CWI is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-B-T-4114-1.

OBG # TRIAL ASSEMBLY YARD (6BE)

SMAW Process:

Welding of weld joint-004 T-Rib fillet weld located on PCMK PP517-001 hold back area of 6BE I-Rib. Welder is identified as 068764. ZPMC CWI is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-B-T-4114-1.

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.

Inspected By:	Manikandan,Murugan	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
