

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-010588**Date Inspected:** 01-Dec-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 measured and recorded root gap and offset along with ABF for below segment. Reports forwarded to team leader for further action

5CW-6AW

This QA Inspector randomly observed the following work in progress:

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

Welding of weld joint -007 located on PCMK SEG030A, weld joint between bottom panel and side panel of 6AE crossbeam side. Welder is identified as 037743. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2114-Tc-U4b-FCM-1.

OBG # TRIAL ASSEMBLY YARD (2AW-2BW)

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SMAW Process:

Welding of weld joint – 006 located on PCMK CA102 of corner assembly longitudinal weld between Deck panel and Edge panel of 2AW-2BW (Crossbeam side). Welder is identified as 054013. ZPMC CWI is identified as Li Yang. Welding was been performed against ABF UT report: UT-2W-005R2 dated 29th Nov. 09. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-FCM-Repair-1. Y locations identified as 4160, 5765, 5775, 4100 and 5990.

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

SMAW Process:

Welding of weld joint – 008 located on PCMK OBW1A, bottom panel between 1AW to 1BW. Welder is identified as 066258. ZPMC CWI is identified as Li Yang. Welding was been performed against ABF UT report: UT-1W-017R2 dated 30th Nov. 09. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1. Y locations identified as 515, 5330 and 5750.

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
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Reviewed By:	Miller,Mark	QA Reviewer
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