

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-011621**Date Inspected:** 21-Jan-2010**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.

This QA Inspector randomly observed the following work in progress:

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

SMAW Process:

Welding of weld joint – 011 located on PCMK SEG030B, Longitudinal diaphragm web to floor beam at work point W3. Welder is identified as 048659. Welding was performed against welding repair report B-WR9695 and UT Report B787-UT-10551. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F)-FCM-Repair-1

OBG # TRIAL ASSEMBLY YARD (6CE-7AE)

SMAW Process:

Welding of weld joint – 011 located on PCMK SEG030B, Longitudinal diaphragm flange to floor beam at work point W3. 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.

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OBG # TRIAL ASSEMBLY YARD (7AE-7BE)

FCAW Process:

Welding of weld joint –001 located on PCMK OBE7B, Side panel transverse splice joining 7AE and 7BE cross beam side. Welder is identified as 220066. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233T.

FCAW Process:

Welding of weld joint –002 and 001 located on PCMK OBE7B, Side panel transverse splice joining 7AE and 7BE cross beam side. Welder is identified as 220067. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233T.

FCAW Process:

Welding of weld joint –002 located on PCMK OBE7B, Side panel transverse splice joining 7AE and 7BE cross beam side. Welder is identified as 053742. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233T.

FCAW Process:

Welding of weld joint –002 located on PCMK OBE7B, Side panel transverse splice joining 7AE and 7BE cross beam side. Welder is identified as 037705. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233T.

OBG # TRIAL ASSEMBLY YARD (6BW-6CW)

SMAW Process:

Welding of weld joint – 001 and 002 located on PCMK OBW6C, Side panel transverse splice counterweight side. Welder is identified as 048659. Welding was been performed against critical welding repair report B-CWR1098. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-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
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Reviewed By:	Miller,Mark	QA Reviewer
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