

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-011809**Date Inspected:** 30-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.

OBG # TRIAL ASSEMBLY YARD

This QA inspector measured and recorded root gap and offset for below segments. Reports forwarded to team leader for further action

7AW-7BW (Bottom panel and Side panel)

This QA Inspector randomly observed the following work in progress:

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

Welding of weld joint -005 located on PCMK SEG028B, longitudinal weld joining bottom panel and Side panel of 6AE at work point E4. Welder is identified as 054467. ZPMC CWI is identified as Li Yang. Welding was been performed against critical welding repair report B-CWR445 Rev.0 and UT report UT-6E-025 dated 25th Jan. 2010. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

OBG # TRIAL ASSEMBLY YARD (6BE)

SMAW Process:

Welding of weld joint –021 located on PCMK SEG028B, longitudinal weld joining bottom panel and Side panel of 6AE at work point E4. Welder is identified as 066261. ZPMC CWI is identified as Li Yang. Welding was been performed against critical welding repair report B-CWR1146 Rev.0 and UT report UT-6E-026. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1.

OBG # TRIAL ASSEMBLY YARD (6AE)

SMAW Process:

Welding of weld joint located on PCMK X106H to Edge panel of 6AE at PP40.25. Welder is identified as 044779. ZPMC CWI is identified as Li Yang. Welding was been performed against critical welding repair report B-WR9848 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F)-FCM-Repair-1.

OBG # TRIAL ASSEMBLY YARD (6BE)

SMAW Process:

Welding of weld joint located on PCMK X106H to Edge panel of 6BE at PP40.5 and PP40.75. Welder is identified as 049339. ZPMC CWI is identified as Li Yang. Welding was been performed against critical welding repair report B-WR9848 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F)-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.

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