

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-012259**Date Inspected:** 31-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**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 Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

TRAIL ASSEMBLY

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as Segment Lift 5. The weld designations reviewed are as follows:

OBW5A-011,015,019,023,030,033.

OBE5A-013,016,022,025,028,031.

This QA inspector performed MT of of the repaired area previously tested and accepted by ABFJV Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as Segment Lift 6. The weld designations reviewed are as follows:

OBW6-003(02 location inside and 1 location outside).

OBG # TRIAL ASSEMBLY YARD (6BW)

SMAW Process:

Welding of weld joint -001 located on PCMK LD11A, longitudinal diaphragm web to flange weld at 6BW PP43.

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Welder is identified as 068917. ZPMC CWI is identified as Li Yang. Welding was been performed against welding repair report B-WR10380 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-FCM-Repair-1.

OBG # TRIAL ASSEMBLY YARD (7AW)

SMAW Process:

Welding of weld joint --001 located on PCMK SEG033B, longitudinal diaphragm flange to floor beam weld at 7AW PP49. Welder is identified as 037932. ZPMC CWI is identified as Li Yang. Welding was been performed against welding repair report B-WR10059 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-FCM-Repair-1.

OBG # TRIAL ASSEMBLY YARD (6AE)

SMAW Process:

Welding of weld joint located on PCMK X106H to Edge panel --of 6AE at PP39.25. Welder is identified as 048047. 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 (6AE)

SMAW Process:

Welding of weld joint located on PCMK X106H to Edge panel --of 6AE at PP39.5. Welder is identified as 216086. 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 Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Chadra

Quality Assurance Inspector

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Reviewed By: McClendon, Timothy

QA Reviewer