

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-014828**Date Inspected:** 21-May-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 performed dimensional survey for the Skin Flatness across Transverse Splice Joints at Location B1, B2, B3, B4, T1 and T2 for below segment along with ABF using 5M string line, 600mm and 630mm straight edge. Reports forwarded to team leader for further action.

7CW-7DW

OBG # TRIAL ASSEMBLY YARD

This QA Inspector measured and recorded root gap and offset for below segment transverse splice weld in fit-up stage. Reports forwarded to team leader for further action.

9AE-9BE

OBG # TRIAL ASSEMBLY YARD

This QA Inspector measured and recorded dimension of corner assembly cope holes at each panel point and

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intermediate panel point for below segment. Smoothness checked and recorded were locations exhibited radii edge discontinuities that do not appear to comply with the contract documents. Reports forwarded to team leader for further action.

7AW-PP 47.5, PP 48, PP 48.5 and PP 49

7BW-PP 49.5, PP 50, PP 50.5, PP 51, PP 51.5 and PP 52

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (9AE-9BE)

FCAW Process:

Welding of weld joint – 003 located on PCMK OBE9, Deck panel transverse splice weld of segment 9AE and 9BE. Welder is identified as 053748. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-223(2)1T-1.

FCAW Process:

Welding of weld joint – 002 located on PCMK OBE9, Deck panel transverse splice weld of segment 9AE and 9BE. Welder is identified as 054458. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-223(2)1T-1.

FCAW Process:

Welding of weld joint – 001 located on PCMK OBE9, Deck panel transverse splice weld of segment 9AE and 9BE. Welder is identified as 054458. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-223(2)1T-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 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan, Murugan	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
