

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-015068**Date Inspected:** 24-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 below segment along with ABF on WT stiffener at Transverse segment splice to confirm vertical and horizontal offset using 1M straight edge. Reports forwarded to team leader for further action.

8CE-9AE

OBG # TRIAL ASSEMBLY YARD

This QA inspector observed in Deck panel for skin flatness at the 7DE to 7EE segment transverse splice weld joint.

The surface flatness survey data was taken on the exterior side (flat side of the weld) of the Deck panel. The out of flatness measurement across the transverse splice is 7mm over a length of 600mm, where the 600mm ruler is centered over the weld joint.

The Transverse weld splice is identified as: OBE7A-008

The location was at the Deck panel of Segment 7DE and 7EE.

Y= 1720 mm from Deck panel Corner assembly weld (Bike path side)

For further information, please see the attached pictures below.

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OBG # TRIAL ASSEMBLY YARD

This QA Inspector performed dimensional survey for the below segment along with ABF on longitudinal weld joins Corner assembly to side panel and Corner assembly to deck panel to confirm flatness using 600mm straight edge. Reports forwarded to team leader for further action.

7AE – PP 48 and PP 49

OBG # TRIAL ASSEMBLY YARD

This QA Inspector performed dimensional survey for the below segment along with ABF on longitudinal weld joins Corner assembly to side panel and Corner assembly to deck panel to confirm flatness using 600mm straight edge. Reports forwarded to team leader for further action.

7BE – PP 50, PP 51 and PP 52

OBG # TRIAL ASSEMBLY YARD

This QA Inspector performed dimensional survey for the below segment along with ABF on longitudinal weld joins Corner assembly to side panel and Corner assembly to deck panel to confirm flatness using 600mm straight edge. Reports forwarded to team leader for further action.

7CE – PP 53, PP 54 and PP 55

OBG # TRIAL ASSEMBLY YARD

This QA Inspector performed dimensional survey for the below segment along with ABF on longitudinal weld joins Corner assembly to side panel and Corner assembly to deck panel to confirm flatness using 600mm straight edge. Reports forwarded to team leader for further action.

7DE – PP 56, PP 57 and PP 58

OBG # TRIAL ASSEMBLY YARD

This QA Inspector performed dimensional survey for the below segment along with ABF on longitudinal weld joins Corner assembly to side panel and Corner assembly to deck panel to confirm flatness using 600mm straight edge. Reports forwarded to team leader for further action.

7EE – PP 59 and PP 60

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

The incident report is issued for the above mentioned discrepancy observed in 7DE to 7EE transverse splice weld joint. And prior to issue it was informed to ZPMC QC and ABF QA.

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