

**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-009007**Date Inspected:** 05-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Yumin**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 (3BW)**

Caltrans Quality Assurance (QA) inspector observed a joint survey of bottom panel flatness at Segment 3BW. The surface flatness survey data was taken on the exterior side of the bottom panel on the northeast side of the segment (close to Segment 4AW and on the counterweight side). The out of flatness measurement across the bottom panel in the transverse direction in between the WT stiffener and the longitudinal shear plate near the segment splice is 8mm in 630mm. This exceeds the maximum 5mm out of flatness requirement per the approved State letter.

This QA Inspector randomly observed the following work in progress:

**OBG # TRIAL ASSEMBLY YARD (1AW-1AAW)****SMAW Process:**

Welding of weld joint -039 and 040 located on PCMK SP404-001. Welder is identified as 037743  
ZPMC CWI is identified as Li Jia. The welding variables recorded by QC appeared to comply with the  
WPS-B-P-2211-B-U2-FCM-1.

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# WELDING INSPECTION REPORT

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OBG # TRIAL ASSEMBLY YARD (2AE)

FCAW Process:

Welding of weld joint –174 and 183 located on PCMK SSD54-PP014. Welder is identified as 048801 ZPMC CWI is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-1G (1F)-FCM-Repair-1.

SMAW Process:

Welding of weld joint –163 and 176 located on PCMK SSD17-PP015. Welder is identified as 048801 ZPMC CWI is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-1G (1F)-FCM-Repair-1.

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

**Summary of Conversations:**

The incident report is issued for the above mentioned discrepancy observed in 3BW. 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 , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Manikandan,Murugan	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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