

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-011256**Date Inspected:** 08-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 (5CW-6AW)**

During the Quality Assurance (QA) random in-process visual inspection of the OBG segments in the Trial Assembly area, this QA inspector discovered the following issue:

- Base metal repairs (BMR) were being performed without prior approval of the Engineer at locations of removed temporary attachments.
- These BMR's were located along the 5CW to 6AW Deck Panel field splice.
- The Deck Plates on 5CW are identified as: DP272A
- The Deck Plates on 6AW are identified as: DP273A
- The lengths of the BMR's were approximately 22mm to 100mm at fifteen (15) random locations on both sides of the 5CW to 6AW field splice weld.
- The material is A709M Grade 345 Non-SPCM.

This QA Inspector randomly observed the following work in progress:

**OBG # TRIAL ASSEMBLY YARD (6CE-7AE)**

SMAW Process:

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## WELDING INSPECTION REPORT

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Buttering of longitudinal diaphragm web located on PCMK LD16A of 6CE- Bike path side. Welder is identified as 066481. ZPMC CWI is identified as Li Yang. Welding was been performed against welding repair report B-WR9738 Rev. 0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-Repair.

SMAW Process:

Buttering of longitudinal diaphragm web located on PCMK LD15A of 6CE- Cross beam side. Welder is identified as 037743. ZPMC CWI is identified as Li Yang. Welding was been performed against welding repair report B-WR9738 Rev. 0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-Repair.

OBG # TRIAL ASSEMBLY YARD (6CE-7AE)

SMAW Process:

Welding of weld joint – 008 located on PCMK EP89-001, Edge panel I-Rib stiffener. Welder is identified as 054467. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2114-FCM-1.

SMAW Process:

Welding of weld joint – 006 located on PCMK EP77-001, Edge panel I-Rib stiffener. Welder is identified as 048659. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2114-FCM-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.

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