

**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-011609**Date Inspected:** 19-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**

This QA inspector measured and recorded root gap and offset for below segments. Reports forwarded to team leader for further action.

6CW-7AW

**OBG # TRIAL ASSEMBLY YARD**

This QA inspector performed T-Rib dimensional survey along for below segments. Reports forwarded to team leader for further action

6CW-7AW

**OBG # TRIAL ASSEMBLY YARD**

This QA inspector performed U-Rib dimensional joint survey along ABF for below segments. Reports forwarded to team leader for further action

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6CW-7AW

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (5AW-5BW)

SMAW Process:

Welding of weld joint – 007 located on PCMK SEG021A, Longitudinal weld joining bottom and side panel of 5AW and 5BW. Welder is identified as 054467. Welding was been performed against Critical welding repair report B-CWR1046 and UT-5W-015R1 dated 15th Jan. 2010. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1

SMAW Process:

Welding of weld joint – 021 located on PCMK SEG023, Longitudinal weld joining bottom and side panel of 5AW and 5BW. Welder is identified as 054467. Welding was been performed against Critical welding repair report B-CWR1046 and UT-5W-015R1 dated 15th Jan. 2010. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1

OBG # TRIAL ASSEMBLY YARD (7AE-7BE)

SAW Process:

Welding of weld joint –002 and 003 located on PCMK OBE7, Deck panel transverse splice joining 7AE and 7BE. 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) T-2.

SAW Process:

Welding of weld joint –004 located on PCMK OBE7, Deck panel transverse splice joining 6BW and 6CW. 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) T-2.

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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