

**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-013144**Date Inspected:** 08-Apr-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 check on WT stiffener at FL3 locations along with QA inspector (Mr. Manoj) for below segment. Reports forwarded to team leader for further action.

7DE – PP 56 and PP 57

**OBG # TRIAL ASSEMBLY YARD (7AW-7BW)**

This QA inspector witnessed final tension verification on T-Rib clips connecting floor beam with bottom panel and side panel of Segment 7AW-7BW. Witnessed 10% on a random basis the bolts and found the tension to be in general compliance. The panel point and bolt size designations are as follows:

PP48 to PP 52 (South and North side)

M16 X 45 – DHGM 160001 – 210 NM

M16 X 50 – DHGM 160003 – 200 NM

M16 X 65 – DHGM 160006 – 180 NM

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Wrench number: XO2-118.

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD

SMAW Process:

Welding of weld joint – 007 located on PCMK BK001-026, Bike path cantilever base plate located at PP 51. Welder is identified as 220069. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-Tc-U4b-F.

SMAW Process:

Welding of weld joint – 009 located on PCMK BK001-026, Bike path cantilever base plate located at PP 51. Welder is identified as 220069. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-Tc-U4b-F.

For further information, Please see the attached pictures below.

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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**Inspected By:** Manikandan,Murugan

Quality Assurance Inspector

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**Reviewed By:** Miller,Mark

QA Reviewer