

**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-009263**Date Inspected:** 30-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.

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (1AAE-1AE)

SMAW Process:

Welding of weld joint -029 and 030 located on PCMK OBE1. Welder is identified as 045138.

ZPMC CWI is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-B-P-2113-FCM-1.

SMAW Process:

Welding of weld joint -037 and 038 located on PCMK OBE1. Welder is identified as 045133.

ZPMC CWI is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-B-P-2113-FCM-1.

OBG # TRIAL ASSEMBLY YARD (1AAW-1AW)

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# WELDING INSPECTION REPORT

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FCAW Process:

Welding of weld joint –059 and 060 located on PCMK OBW1. Welder is identified as 220064.  
ZPMC CWI is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

FCAW Process:

Welding of weld joint –059 and 060 located on PCMK OBW1. Welder is identified as 220066.  
ZPMC CWI is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

OBG # TRIAL ASSEMBLY YARD (1AW)

FCAW Process:

Welding of weld joint –077 located on PCMK SSD34-PP8.5. Welder is identified as 220064.  
ZPMC CWI is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133 and welding repair report B-WR7482.

OBG # TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress and found to be in general compliance:

1. ABF Magnetic Particle Testing (MT) is in progress on 5CE – PP36 floor beam flange weld.
2. ABF MT is in progress on 5CW – PP36 floor beam flange weld.
3. ZPMC MT is in progress on cable tray bolt holes in T-Stiffeners at PP14 and PP15 in 2AW after misdrilled hole repair.

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>	Carreon,Albert	QA Reviewer
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