**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 #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

# WELDING INSPECTION REPORT

**Resident Engineer:** Pursell, Gary
**Address:** 333 Burma Road
**City:** Oakland, CA 94607

**Report No:** WIR-009840
**Date Inspected:** 03-Oct-2009

**Project Name:** SAS Superstructure
**Prime Contractor:** American Bridge/Fluor Enterprises, a JV
**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

**OSM Arrival Time:** 645
**OSM Departure Time:** 1845
**Location:** Shanghai, China

**CWI Name:** Xu Yumin

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **Inspected CWI report:** | ☐ Yes | ☑ No | ☐ N/A | **CWI Present:** | ☑ Yes | ☐ No | |
| **Electrode to specification:** | ☑ Yes | ☐ No | ☐ N/A | **Rod Oven in Use:** | ☑ Yes | ☐ No | ☐ N/A |
| **Qualified Welders:** | ☑ Yes | ☐ No | ☐ N/A | **Weld Procedures Followed:** | ☑ Yes | ☐ No | ☐ N/A |
| **Approved Drawings:** | ☑ Yes | ☐ No | ☐ N/A | **Verified Joint Fit-up:** | ☑ 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 observed ZPMC excavated 1st location of WRR B-WR7916(2230-2600mm)of 1AAW-1AW(Deck panel), in that observed approximately 10 transverse crack visually.For further information, please see the attached pictures below.

OBG # TRIAL ASSEMBLY YARD

This QA inspector performed dimensional check along with ABF on Longitudinal diaphragm for below segments and readings found to be out of tolerance. Further corrections required and ABF agree to offer again after rectification.

5BW-5CW
5BE-5CE

This QA Inspector randomly observed the following work in progress:

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

FCAW Process:

Welding of weld joint –025 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-2234-C-U2-F.

FCAW Process:

Welding of weld joint –247, 117 and 113 located on PCMK OBW1. Welder is identified as 220067.
ZPMC CWI is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-Tc-U5-F.

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

SMAW Process:

Welding of weld joint –080 located on PCMK OBE1. Welder is identified as 045268.
ZPMC CWI is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-B-P-2114-FCM-1.

SMAW Process:

Welding of weld joint –088 located on PCMK OBE1. Welder is identified as 050433.
ZPMC CWI is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-B-P-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.

| | | |
|---|---|---|
| **Inspected By:** | Manikandan,Murugan | Quality Assurance Inspector |
| **Reviewed By:** | Carreon,Albert | QA Reviewer |