

**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-009850**Date Inspected:** 14-Oct-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.

**OBG # TRIAL ASSEMBLY YARD**

This QA inspector witnessed final tension verification for longitudinal diaphragm (LD) to LD of Lift 2 East cross beam side. Witnessed 10% on a random basis and the tension found to be in general compliance. The panel point, location and bolt size designations are as follows:

M24 X 95 (PP16 and PP17) Green Tag Number: 380

M27 X 80 (PP16 and PP17) Green Tag Number: 381

**OBG # TRIAL ASSEMBLY YARD (Lift 1 East)**

This QA inspector performed visual testing and dimensional check on cope hole and welds access for OBG lift 1 East segment for smoothness. Noted comments in ABF inspection report no: CWAHIR-1E-03 and forwarded to lead inspector for further action.

This QA Inspector randomly observed the following work in progress:

**OBG # TRIAL ASSEMBLY YARD (Lift 1 West)**

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# WELDING INSPECTION REPORT

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**SMAW Process:**

Welding of weld joint –007 located on PCMK OBW1A. Welder is identified as 220067.  
ZPMC CWI is identified as Xu Yumin. Welding was been performed against Critical Welding Repair Report B-CWR831. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

**SMAW Process:**

Welding of weld joint –007 located on PCMK OBW1A. Welder is identified as 054467.  
ZPMC CWI is identified as Xu Yumin. Welding was been performed against Critical Welding Repair Report B-CWR831. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

OBG # TRIAL ASSEMBLY YARD (Lift 2 West)

**SMAW Process:**

Welding of weld joint –003 located on PCMK OBW2A. Welder is identified as 048659.  
ZPMC CWI is identified as Xu Yumin. Welding was been performed against Critical Welding Repair Report B-CWR827. 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 –003 located on PCMK OBW2A. Welder is identified as 049769.  
ZPMC CWI is identified as Xu Yumin. Welding was been performed against Critical Welding Repair Report B-CWR827. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-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
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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