

**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-010415**Date Inspected:** 24-Nov-2009**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 witnessed final tension verification for I stiffener splice at transition location (North and South) of 1AW. 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:

PP-8.5 to PP9:

M22 X 100 – DHGM 220049 – 493 NM

**OBG # TRIAL ASSEMBLY YARD (Lift 5 West)**

This QA inspector performed visual testing and dimensional check on cope and welds access hole for OBG lift 5 West segment for smoothness. Noted comments in ABF inspection report no: CWAHIR-5W-03 and forwarded to lead inspector for further action.

**OBG # TRIAL ASSEMBLY YARD**

This QA inspector performed dimensional survey for skin flatness using 630mm straight edge along with QA

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inspector (Mr. Manjunath) for below segments and readings found to be in general compliance.

6AW, 6BW and 6CW

This QA Inspector randomly observed the following work in progress:

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

SMAW Process:

Welding of weld joint – 008 located on PCMK OBW1A of 1AW-1BW bottom panel. Welder is identified as 068917. ZPMC CWI is identified as Li Yang. Welding was been performed against Critical Welding Repair Report B-CWR907 Rev.0 and UT report number- UT-1W-017.The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

OBG # TRIAL ASSEMBLY YARD (6AE-6BE)

SMAW Process:

Welding of weld joint – 005 located on PCMK OBE6B of 6AE-6BE Side panel. Welder is identified as 066761. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

SMAW Process:

Welding of weld joint –006 located on PCMK OBE6B of 6AE-6BE Side panel. Welder is identified as 067571. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

OBG # TRIAL ASSEMBLY YARD (6AE-6BE)

SMAW Process:

Welding of weld joint –005 located on PCMK OBE6 of 6AE-6BE Edge panel. Welder is identified as 066236. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2213-B-U2-FCM-1.

OBG # TRIAL ASSEMBLY YARD (6AE)

FCAW Process:

Welding of weld joint –035 located on PCMK SSD25-PP39 of 6AE-FL3. 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-2132.

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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

**Summary of Conversations:**

The incident report is issued for the above mentioned dimensional discrepancy observed in 5BE. And prior to issue it was informed to ZPMC QC and ABF QA.

**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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