

**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-010643**Date Inspected:** 06-Dec-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 performed U-Rib dimensional survey along with ABF for below segment. Reports forwarded to team leader for further action

5CW-6AW

**OBG # TRIAL ASSEMBLY YARD**

This QA inspector measured and recorded root gap and offset along with QA inspector (Mr.Manjunath) for below segment. Reports forwarded to team leader for further action

6BE-6CE (Side panel and Edge Panel)

**OBG # TRIAL ASSEMBLY YARD**

This QA inspector measured and recorded root gap and offset along with QA inspector (Mr.Manjunath) for below segment. Reports forwarded to team leader for further action

6AW-6BW

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This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (6AW-6BW)

FCAW Process:

Welding of weld joint –003 located on PCMK OBW6, Bottom panel. Welder is identified as 066674. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231T-1.

FCAW Process:

Welding of weld joint –003 located on PCMK OBW6, Bottom panel. Welder is identified as 220067. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231T-1.

OBG # TRIAL ASSEMBLY YARD (5CW)

FCAW Process:

Welding of weld joint –001 located on PCMK CA002, Corner assembly. Welder is identified as 066746. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-Tc-U5-F.

OBG # TRIAL ASSEMBLY YARD (5CW)

FCAW Process:

Welding of weld joint –030 located on PCMK SEG027B, Corner assembly. Welder is identified as 066746. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-Tc-U5-F.

OBG # TRIAL ASSEMBLY YARD (5BW)

SMAW Process:

Welding of weld joint – 008 located on PCMK OBW5G, counterweight connecting plate of 5BW. Welder is identified as 037743. ZPMC CWI is identified as Li Yang. Welding was been performed against Welding repair report: B-WR8591 Rev.0 and ZPMC UT report: B787-UT-9613. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-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.

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# WELDING INSPECTION REPORT

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## 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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