

**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-010743**Date Inspected:** 10-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 (Lift 5 West)**

This Quality Assurance (QA) inspector observed I-Rib joining weld between 5AW-5BW crossbeam side (W5) were misaligned and welded. The offset measurement across the weld is 5mm.

-The weld is identified as: DP620A-001-025

-The Weld is a Complete Joint Penetration (CJP) butt weld joining the 5AW I-Rib to the 5BW I-Rib.

This QA Inspector randomly observed the following work in progress:

**OBG # TRIAL ASSEMBLY YARD (6AW-6BW)****FCAW Process:**

Welding of weld joint -002 located on PCMK OBW6B, Side panel counterweight side. Welder is identified as 220063. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233T-1.

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

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## WELDING INSPECTION REPORT

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FCAW Process:

Welding of weld joint –004 located on PCMK OBW6B, Side panel crossbeam side. 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-2233T-1.

OBG # TRIAL ASSEMBLY YARD (5BW-5CW)

SMAW Process:

Welding of weld joint – 013 located on PCMK OBW5A, bottom panel. Welder is identified as 054467. ZPMC CWI is identified as Li Yang. Welding was been performed against welding repair report B-WR8833 and ZPMC UT report: B-787-UT-9882. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1.

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

FCAW Process:

Welding of weld joint –023 located on PCMK DP635-001, Deck panel I-Rib CJP weld. Welder is identified as 048659. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-3213-B-U3B.

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 discrepancy observed in Lift 5West. 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
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

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