

**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-010929**Date Inspected:** 30-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.

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (6CE)

SMAW Process:

Welding of weld joint – 001 located on PCMK SSD32-PP45.5, Unequal angle welded with corner assembly. Welder is identified as 044710. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2113.

OBG # TRIAL ASSEMBLY YARD (6AW)

FCAW Process:

Welding of weld joint – 004 located on PCMK OBW6F, Counter weight connection plate. Welder is identified as 220066. 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.

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## WELDING INSPECTION REPORT

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OBG # TRIAL ASSEMBLY YARD (5AE-5BE)

SMAW Process:

Welding of weld joint – 008 located on PCMK OBE5, Deck panel. Welder is identified as 048659. ZPMC CWI is identified as Li Yang. Welding was been performed against welding repair report # B-WR9313 Rev. 0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1.

OBG # TRIAL ASSEMBLY YARD (5AE-5BE)

SMAW Process:

Welding of weld joint – 009 located on PCMK OBE5, Deck panel corner assembly. Welder is identified as 048659. ZPMC CWI is identified as Li Yang. Welding was been performed against welding repair report # B-WR9320 Rev. 0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1.

OBG # TRIAL ASSEMBLY YARD (6AE)

Gouging of corner assembly stiffener Complete Joint Penetration weld joint located on PCMK X3S connected with web plates and deck plates of 6AE (PP38-PP39) crossbeam side. ZPMC CWI is identified as Li Yang. Gouging was been performed against welding repair report # B-WR9540 Rev. 0.

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>	Miller,Mark	QA Reviewer

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