

**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-013802**Date Inspected:** 28-Apr-2010**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 visual inspection and dimensional checks on weld access cope holes on OBG 9DW. The following locations exhibited radii edge appears that do not comply with the contract documents. Reports forwarded to team leader for further action.

**OBG # TRIAL ASSEMBLY YARD**

This QA inspector performed dimensional check along with ABF on longitudinal diaphragm to check offset for web and flange for below segment. Reports forwarded to team leader for further action

7DE-7EE

**OBG # TRIAL ASSEMBLY YARD**

This QA inspector performed dimensional check along with ABF for skin flatness for below segment using 5M string line, 600mm and 630mm straight edge. Reports forwarded to team leader for further action

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# WELDING INSPECTION REPORT

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7DE-7EE

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD

SMAW Process:

Welding of weld joint – 018 located on PCMK DP640-001, Deck panel I Rib joins 7CW and 7DW segment. Welder is identified as 037996. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-4114-1.

SMAW Process:

Welding of weld joint – 002 located on PCMK CA05, Corner assembly longitudinal weld joining Edge and Deck panel of segment 8AE. Welder is identified as 067609. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-Tc-U4b-FCM-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
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<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer
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