

**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-015714**Date Inspected:** 20-Jul-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

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>
<b>Inspected CWI report:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
		<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG Components	

**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

**ZPMC SHIP # 19 (7BW)**

This QA Inspector along with Mr. Murugan Manikandan photographed and documented at various locations on OBG 7BW prior to the shipment of (Voyage 4) en-route to Yerba Buena Island, California, USA. The following locations are where the photographs were taken and the photographs are available for review upon request.

OBG 7BW (Panel Point 51.5 thru Panel point 52) the following sequential members were photographed and documented:

1. Truss post – Crossbeam side of segment 7BW – PP 51.5.
2. Corner Assembly – Crossbeam side of segment 7BW – PP 52.
3. Longitudinal Diaphragm - Crossbeam side of segment 7BW – PP 52.
4. Chevron Diagonal members (upper and lower) - Crossbeam side of segment 7BW– PP 52.
5. Sea fasteners- 7BW – PP 52.
6. Longitudinal Diaphragm – Counter weight side of segment 7BW – PP 52.
7. Corner Assembly – Counter weight side of segment 7BW – PP 52.
8. Truss post – Counter weight side of segment 7BW – PP 51.5.

**ZPMC SHIP # 19 (7CW)**

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This QA Inspector along with Mr. Murugan Manikandan photographed and documented at various locations on OBG 7CW prior to the shipment of (Voyage 4) en-route to Yerba Buena Island, California, USA. The following locations are where the photographs were taken and the photographs are available for review upon request.

OBG 7CW (Panel Point 52.5 thru Panel point 55) the following sequential members were photographed and documented:

1. Truss post – Crossbeam side of segment 7CW – PP 52.5, PP 53.5 and PP 54.5.
2. Corner Assembly – Crossbeam side of segment 7CW – PP 53 to PP 55.
3. Longitudinal Diaphragm - Crossbeam side of segment 7CW – PP 53 to PP 55.
4. Chevron Diagonal members (upper and lower) - Crossbeam side of segment 7CW – PP 53 to PP 55.
5. Sea fasteners- 7CW – PP 53 to PP 55.
6. Longitudinal Diaphragm – Counter weight side of segment 7CW – PP 53 to PP 55.
7. Corner Assembly – Counter weight side of segment 77CW – PP 53 to PP 55.
8. Truss post – Counter weight side of segment 7CW – PP 52.5, PP 53.5 and PP 54.5.

ZPMC SHIP # 19 (7DW)

This QA Inspector along with Mr. Murugan Manikandan photographed and documented at various locations on OBG 7DW prior to the shipment of (Voyage 4) en-route to Yerba Buena Island, California, USA. The following locations are where the photographs were taken and the photographs are available for review upon request.

OBG 7DW (Panel Point 55.5 thru Panel point 58) the following sequential members were photographed and documented:

1. Truss post – Crossbeam side of segment 7DW – PP 55.5, PP 56.5 and PP 57.5.
2. Corner Assembly – Crossbeam side of segment 7DW – PP 56 to PP 58.
3. Longitudinal Diaphragm - Crossbeam side of segment 7DW – PP 56 to PP 58.
4. Chevron Diagonal members (upper and lower) - Crossbeam side of segment 7DW – PP 56 to PP 58.
5. Sea fasteners- 7DW – PP 56 to PP 58.
6. Longitudinal Diaphragm – Counter weight side of segment 7DW – PP 56 to PP 58.
7. Corner Assembly – Counter weight side of segment 7DW – PP 56 to PP 58.
8. Truss post – Counter weight side of segment 7DW – PP 55.5, PP 56.5 and PP 57.5.

ZPMC SHIP # 19 (7EW)

This QA Inspector along with Mr. Murugan Manikandan photographed and documented at various locations on OBG 7EW prior to the shipment of (Voyage 4) en-route to Yerba Buena Island, California, USA. The following locations are where the photographs were taken and the photographs are available for review upon request.

OBG 7EW (Panel Point 58.5 thru Panel point 60.5) the following sequential members were photographed and documented:

1. Truss post – Crossbeam side of segment 7EW –PP 58.5, PP 59.5 and PP 60.5
2. Corner Assembly – Crossbeam side of segment 7EW – PP 59 and PP 60.
3. Longitudinal Diaphragm - Crossbeam side of segment 7EW – PP 59 and PP 60.

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4. Chevron Diagonal members (upper and lower) - Crossbeam side of segment 7EW – PP 59 and PP 60.
5. Sea fasteners- 7EW – PP 59 and PP 60.
6. Longitudinal Diaphragm – Counter weight side of segment 7EW – PP 59 and PP 60.
7. Corner Assembly – Counter weight side of segment 7EW – PP 59 and PP 60.
8. Truss post – Counter weight side of segment 7EW –PP 58.5, PP 59.5 and PP 60.5.

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 Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Chadra	Quality Assurance Inspector
<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer

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