

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020175**Date Inspected:** 04-Jan-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:** See Below**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**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations relative to the work being performed.

OBG Segment Name: 9AW / North of Bay 14

This Caltrans QA Inspector observed that ZPMC has created two (2) weld joints that are not on the approved drawings. The weld location is identified on piecemark #X74A angle at intermediate panel points 71.5 and 72.5. AWS D1.5-2002 Section 3.1.4; "The location of welds shall not be changed without approval". Section 3.1.5; "Welds shall be prohibited on the work except as follows:

- (2) All welds detailed on approved shop drawings
- (3) Repair welds authorized by this code
- (4) Other welds approved by the Engineer

This QA inspector generated a Quality Assurance-Incident Report for the welding violation. See Quality Assurance-Incident Report, dated 01-04-10 for additional information. ZPMC QC inspector is identified as Mr. Li Ping.

OBG Segment Name: Bikepath #BK4 / Bay 19

This Caltrans QA inspector observed that the ZPMC has deviated from the current approved shop drawings by welding the cope hole at the interior stiffener plate identified as BKX11K, segment Bk4, (1) location. AWS D1.5 (2002) - Section 6.5.1: "The Inspector shall make certain that the size, length, and location of all welds conform to the requirements of this code and to the detail drawings and that no unspecified welds have been added without approval."

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA inspector generated a Quality Assurance-Incident Report for the welding violation. See Quality Assurance-Incident Report, dated 01-04-10 for additional information. ZPMC QC inspector is identified as Mr. Lv Li Qing.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

“As noted within the contents of this report.”

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.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
