

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-014025**Date Inspected:** 17-May-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:** Jhou Cheng**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 Components**Summary of Items Observed:**

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

BAY#19

During random in-process observation of the fabrication of OBG Bike path identified as BK004A-004, this Caltrans Quality Assurance Inspector (QA) discovered the following issue:

-ZPMC welding personnel have welded 2 joints with a "no weld" specification on the approved shop drawings without the approval of the Engineer.

-The approved shop drawings specify the bottom end of the end diaphragms identified as BKX11B as having a tight fit with no weld to the bearing plates identified as BKPL7A and BKPL7B.

The OBG Bike path BK004A-004 is located inside the Fabrication Bay 19.

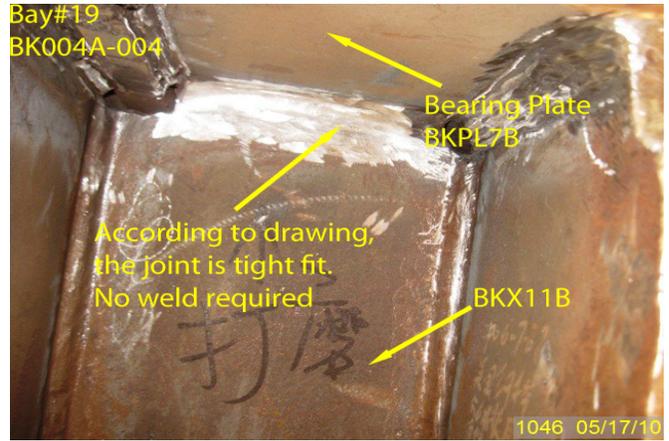
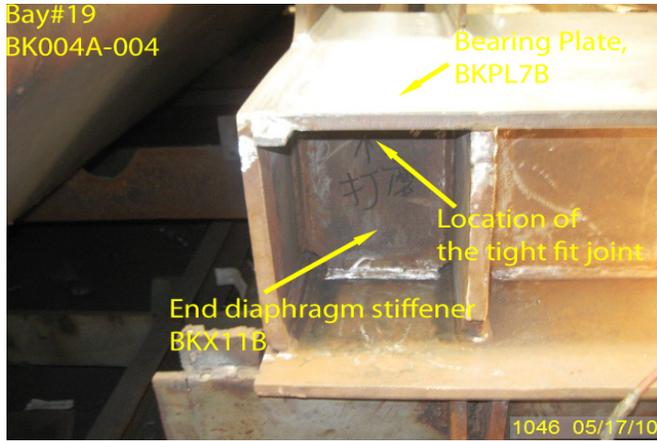
For further information, please see the attached pictures below.

During random in process observation of bike path, BK004A-001, this QA inspector observed Magnetic Particle Inspection (MT) was performed by ZPMC MT technician. According to the new fabrication procedure, ZPMC personnel removed the parts from the bike path by carbon arc gouging. After removing the parts the area requires NDT inspection.

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

WELDING INSPECTION REPORT

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Summary of Conversations:

No relevant conversations.

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 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Patel, Hiranch

Quality Assurance Inspector

Reviewed By: McClendon, Timothy

QA Reviewer