

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-020744**Date Inspected:** 18-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**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 & Tower**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 and testing relative to the work being performed.

Bay 1

During a random observation this QA inspector observed the following components for the Orthotropic Bridge Girder (OBG);

GQ2-F209; 16qty bracket assemblies

10TR1 & 10TR2; 30qty traveler rails

E2-SB12; 3qty steel barrier assemblies

Raw Materials (pipe, sq. tubing & sq. bar stock) for Bike Path Hand Rail Assemblies

This QA observed that ZPMC was not performing any work on the above mention components during the time, this QA inspector was present.

Bay 3

During a random observation this QA inspector observed the following components for the Orthotropic Bridge Girder (OBG);

Architectural Housing; AH3150, AH3151, AH3152

This QA observed that ZPMC was not performing any work on the above mention components during the time,

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this QA inspector was present.

Bay 4

During a random observation this QA inspector observed the following components for the Orthotropic Bridge Girder (OBG);

11TR3, 11TR1, 10TR1, 11TR2; 30+qty traveler rails

This QA observed that ZPMC was not performing any work on the above mention components during the time, this QA inspector was present.

Bay 6

During a random observation this QA inspector observed the following components for the Orthotropic Bridge Girder (OBG);

CB18, CB19, Floor Beam; 80+qty drilled splice plates
Galvanized Handrails; 80+qty

This QA observed that ZPMC was not performing any work on the above mention components during the time, this QA inspector was present.

Bay 7

During a random observation this QA inspector observed the following components for the Orthotropic Bridge Girder (OBG);

Galvanized Handrails; 80+qty

This QA observed that ZPMC was not performing any work on the above mention components during the time, this QA inspector was present.

Bay 8

During a random observation this QA inspector observed the following components for the Orthotropic Bridge Girder (OBG);

BK4A-060; 1qty bike path assembly
BK4A-059; 1qty bike path assembly
BK4A-063; 1qty bike path assembly
BK4A-062; 1qty bike path assembly

This QA observed that ZPMC was not performing any work on the above mention components during the time, this QA inspector was present.

Bay 10

This QA inspector performed a random observation for the OBG. During the observation performed it was noted

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that at Bay 10 ZPMC was in process of SMAW welding bike path assembly components. ZPMC Certified Welding Inspector (CWI) Guo Yan Fei was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 5 welders performing critical weld repair (CWR1869), weld build-up on the flange of 6 interior longitudinal diaphragms (BKX32S, BKX32X, BKX32V, BKX55A, BKX55C, BKX32W) and identified the welders by ZPMC welder identification number appointed to then by ZPMC.

The following digital picture illustrates the welding of the flange build -up weld.

This QA inspector observed ZPMC welder stitch welding interior longitudinal diaphragm to deck plate. The bike path assembly is identified as BK9A. ZPMC Certified Welding Inspector (CWI) Guo Yan Fei was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 1 welder performing welding and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Bike Path Assembly
BK9A-001/BKX24A
WPS-B-P-2112
Welder-052889
2F//SMAW

The following picture illustrates stitch welding longitudinal diaphragm to deck plate.

This QA inspector observed ZPMC welder welding bike path bottom cover plate complete joint penetration splice weld. The bike path assembly is identified as BK8A. ZPMC Certified Welding Inspector (CWI) Guo Yan Fei was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 1 welder performing welding and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Bike Path Assembly
Weld-BK008A-001-018
WPS-B-T-2231-ESAB
Welder-052075
1G//CJP/FCAW

QA inspector observed the following components for the Orthotropic Bridge Girder (OBG);

Lift 6 North & South Tower Head Assembly

This QA observed that ZPMC was not performing any work on the above mention components during the time, this QA inspector was present.

Bay 11

During a random observation this QA inspector observed the following components for the Orthotropic Bridge Girder (OBG);

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BK4A-064; 1qty bike path assembly
BK4A-024; 1qty bike path assembly
BK4A-003; 1qty bike path assembly
BK4A-057; 1qty bike path assembly
BK4A-002; 1qty bike path assembly
Lift 6 East & West Tower Head Cover Assembly

This QA observed that ZPMC was not performing any work on the above mention components during the time, this QA inspector was present.

Bay 12

During a random observation this QA inspector observed the following components for the Orthotropic Bridge Girder (OBG);

Segment 14W; 80+qty splice plates

This QA observed that ZPMC was not performing any work on the above mention components during the time, this QA inspector was present.

Trial Assembly

During a random observation this QA inspector observed the following components for the Orthotropic Bridge Girder (OBG);

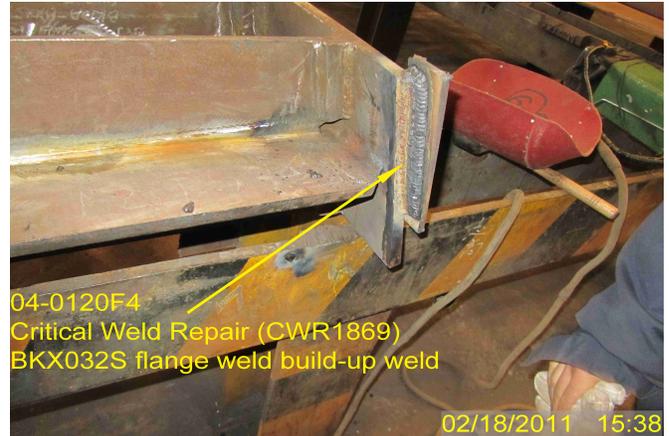
Segment 12AE, 12BE, 12CE assemblies
Segment 12AW, 12BW, 12CW assemblies
CB19 Crossbeam assembly
CB18 Crossbeam assembly

This QA observed that ZPMC was not performing any work on the above mention components during the time, this QA inspector was present.

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

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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 James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By: Hasler, Mike

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer