DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-023684
Date Inspected: 17-May-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Corporation, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name: Mr. Mai Quin Li

Inspected CWI report:	☐ Yes	☑ No	☐ N/A
Electrode to specification:	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A

CWI Present:	☑ Yes	☐ No	
Rod Oven in Use:	☑ Yes	☐ No	☐ N/A
Weld Procedures Followed:	☑ Yes	☐ No	☐ N/A
Verified Joint Fit-up:	☐ Yes	☑ No	☐ N/A
Approved WPS:	☑ Yes	☐ No	☐ N/A
Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: Traveler Rails & Handrail

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

OBG Bay # 16 WELDING

This QA Inspector observed the following work in progress:

SMAW welding # 6 fillet weld, P45 (25 x25 bar) to P19 Pipe (PX36), located on BKR-FS2-2, OBG Bike Path Handrail components. Welder is identified as 053753. ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-B-T-2112.

SMAW welding # 6 fillet weld, P45 (25 x25 bar) to P19 Pipe (PX36), located on BKR-FS2-2, OBG Bike Path Handrail components. Welder is identified as 205770. ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-B-T-2112.

SMAW welding # 6 fillet weld, P45 (25 x25 bar) to P19 Pipe (PX36), located on BKR-FS2-2, OBG Bike Path Handrail components. Welder is identified as 201905. ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-B-T-2112.

OBG Bay # 14 WELDING

This QA Inspector observed the following work in progress:

SMAW welding of weld identified as TR3021-TR2-001, located on Splice Plate, TR3021-TR2. Welder is identified as 045268. ZPMC Quality Control (QC) is identified as Mr. Shao Jian Yuan. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G/2F-Fcm-Repair-1 & BWR-20756.

SMAW welding of weld identified as TR3021-TR2-004, located on Splice Plate, TR3021-TR2. Welder is identified as 045268. ZPMC Quality Control (QC) is identified as Mr. Shao Jian Yuan. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G/2F-Fcm-Repair-1 & BWR-20706.

SMAW welding of weld identified as TR3021-TR2-005, located on Splice Plate, TR3021-TR2. Welder is identified as 067752. ZPMC Quality Control (QC) is identified as Mr. Shao Jian Yuan. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G/2F-Fcm-Repair-1 & BWR-20706.

OBG Bay # 13 WELDING

This QA observed the following components in this bay, OBG, Steel Barriers. This QA observed no work being performed on the above mentioned components during the time QA was present.

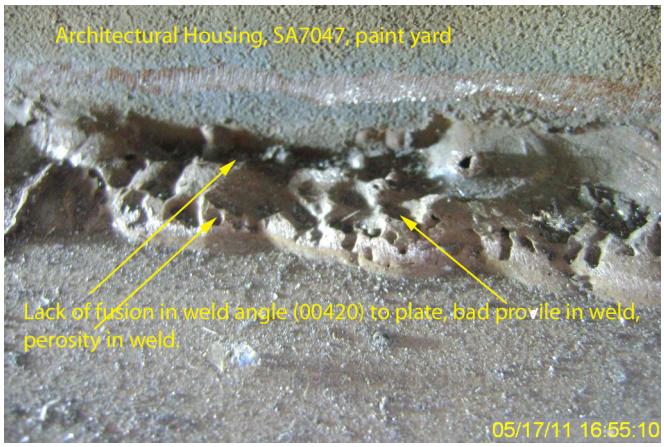
OBG Bay # 28 WELDING

This QA observed the following components in this bay, OBG, Mock-Up Service Hand Rails. This QA observed no work being performed on the above mentioned components during the time QA was present.

Paint Yard

This QA was requested to look a welds on the Architectual Housing # SA7047. On angle identified as ABF-00420. This QA observed lack of penetration angle ABF-00420 to plate, porosity, bad profile welds. Talked with Zhang Wein QC for ZPMC, he said he would discuss with ABF on how to repair it.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Summary of Conversations:

No relevant conversations were reported on this date.

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, 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Humphrey,Delbert	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer