

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025918**Date Inspected:** 03-Aug-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Corporation, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Mai Quin Li**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:** Bike Path Components**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 # 14

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 # 9

WELDING

This QA Inspector observed the following work in progress:

During random in process inspection this QA observed ZPMC personnel Heat Straightening Bike Path Traveler Rail member as identified as 3018TR2-001. Heat Straightening is being performed to bring handrail into tolerance. ZPMNC Quality Control (QC) inspector identified as Mr. Mai Quin Li was present to monitor the heat straightening process. The heat straightening process did appear to comply with Heat Straightening Report HSR (B) 10415.

OBG Bay # 16

WELDING

This QA Inspector observed the following work in progress:

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

During random in process inspection this QA observed ZPMC personnel Heat Straightening Bike Path Handrail member as identified as BKR-FS1-001, between panel points PP17 & 23. Heat Straightening is being performed to bring handrail into tolerance. ZPMNC Quality Control (QC) inspector identified as Mr. Mai Quin Li was present to monitor the heat straightening process. The heat straightening process did appear to comply with Heat Straightening Report HS # 10418 (B).

OBG Bay # 19

WELDING

This QA Inspector observed the following work in progress:

FCAW welding of welds BK9003A5-001-213, located on Bike Path, BK9003A. Welder is identified as 062794. ZPMC Quality Control (QC) is identified as Mr. Peng Wen Jun. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

FCAW welding of welds BK9003A5-001-215, located on Bike Path, BK9003A. Welder is identified as 062806. ZPMC Quality Control (QC) is identified as Mr. Peng Wen Jun. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

FCAW welding of welds BK9003A5-001-216, located on Bike Path, BK9003A. Welder is identified as 062808. ZPMC Quality Control (QC) is identified as Mr. Peng Wen Jun. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

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



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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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