

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 #: 99.28**WELDING INSPECTION REPORT**

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-026410
Date Inspected: 26-Sep-2011

Project Name: SAS Superstructure **OSM Arrival Time:** 1200
Prime Contractor: American Bridge/Fluor Enterprises, a JV **OSM Departure Time:** 2200
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island **Location:** Shanghai, China

CWI Name:	Guo Xing Hui	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, Bike Path Hand Rail	

Summary of Items Observed:

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

Bay 19

This QA Inspector observed the following work in progress for Bay 19.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Guo Xing Hui.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Component: Bike Path
PCMK: BK9003A2-001
Weld Number: 005, 127
Welder: 062749
WPS-B-T-2132-ESAB

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 09973 from ZPMC for Bay 16. This QA inspector performed ultrasonic testing (UT) verification of welds after ZPMC had performed their UT inspection. The segment is identified as Bike Path. The weld designations reviewed are as follows.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

BK9003A2-001-001~004, 065~072

BK9003A8-001-066

Bay 16

Heat straightening of Hand Rail BKR-FS-38-001, BKR-FS-39-001, BKR-FS-40-001, and BKR-FS-41-001 under approved Heat Straightening procedure HSR 10418. The in process temperature was observed as 250°C. The ZPMC QC was identified as Ma Qian Li. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 numbers of applications was allowed. The distortion that was previously measured and recorded on the HSR was Maximum 5 mm.

This inspector monitored repair of Bike Path Hand Rail BKR-FS-23-001 according to Welding Repair Report B-WR21327. Existing hand rail welds were removed by cutting torch, ground smooth, and repositioned according to approved shop drawings, and rewelded by certified welder 201905. Welding variables recorded by ZPMC QC Ma Qian Li appeared to comply with the approved Welding Procedure Specification (WPS).

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



WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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:	Combs,Dennis	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
