

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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014621**Date Inspected:** 28-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:****Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:****Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhou 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.

During random in-process visual inspection of bike path assembly BK004A-004, this Quality Assurance Inspector (QA) discovered the following issue:

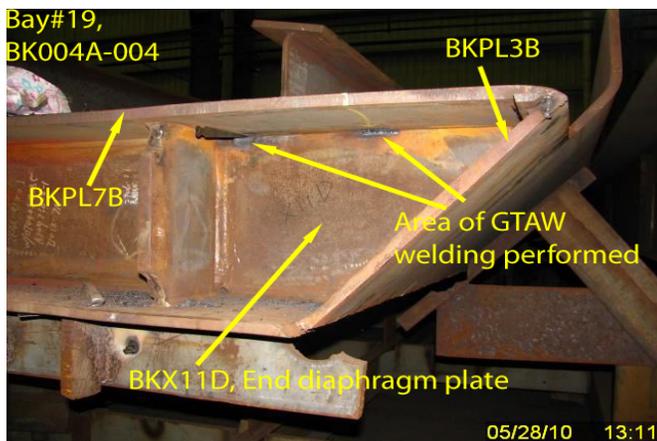
- Weld buttering being performed at the leading edge of an intended tight fit joint, between the end diaphragm plate (BKX11D) and the bearing plate (BKPL7B) with an unapproved welding process.
- The welding process being utilized during the repair was Gas Tungsten Arc Welding (GTAW).
- The welder is identified as ZP09-1381.
- The ZPMC QC Mr. Zhou Cheng was unable to identify the consumables used at the time of welding.
- Bike Path: BK004A-004 is located in Bay 19.

For further information, please see the attached pictures below. Please see incident report generated by QA inspector B298 on this date.

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