

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-015622**Date Inspected:** 14-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Tao**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.

Bay#19

During random visual inspection of the Bike path BK 004A-008, BK004A-010 and BK004A-011, this QA inspector observed ZPMC personnel perform flame cutting on internal BKX7P stiffeners. The BKX7P stiffeners was welded (Fillet) to the top plate of the bike path. Required NDT work was performed and accepted by ZPMC and CT on these welds.

According to RFI 1690-R4, the interior end diaphragm plate will be welded with stringer plates. The BKX7P stiffener creates an obstacle during the fit up of end diaphragm plate. The cutting was performed, approximately 1200mm on both the ends. ZPMC personnel have required grinding flush the cutting area and performing NDT inspection. According to approved drawing this weld is not fracture critical weld. For further information, please see attached pictures.

Bay#19

During random in-process inspection of bike path, this QA inspector observed the following work was performed on the bike paths

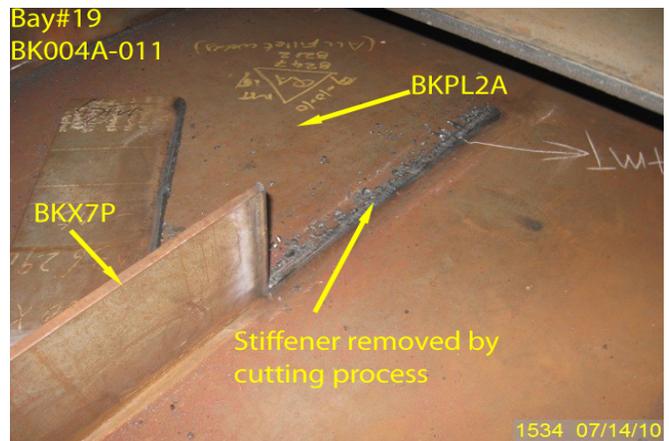
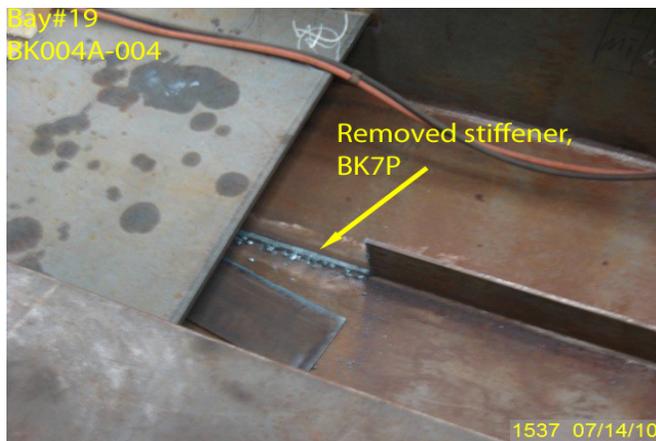
1. BK004A-004 Welding of bearing plates to center plates, bearing plate to side plates and bearing plates to stringer plates were completed. Welding of horizontal anchor house plate to longitudinal members was completed. Welding of end closure plate and bottom diaphragm plate was completed.
2. BK004A-005 Welding of bearing plate was completed. Rectification work is in process.

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3. BK004A-007 End closure plate, Interior diaphragm and longitudinal diaphragm plate removed by carbon arc gouging. Required repair work was completed and heat straightening (HS) at both the end was completed. Required NDT work completed by ZPMC and CT. Fit up of bearing plate was completed.
4. BK004A-008 Welding of Side Plates to Top Plate (DP), center plate and intermediate X7 stiffener is in process. Performed welding on center plate to top plate, end diaphragm plates to side plate and stringer plate. MT of internal fillet welds is in process by ZPMC.
5. BK004A-010 Welding of Side Plates to Top Plate (DP), center plate and intermediate X7 stiffener is in process. Performed welding on center plate to top plate, end diaphragm plates to side plate and stringer plate. MT of internal fillet welds completed by ZPMC. CT inspection not complete.
6. BK004A-011 MT completed by ZPMC and CT for all internal fillet welds. Fit-up of bearing plate is in process
7. BK004A-012 Welding of Side Plates to Top Plate (DP), center plate and intermediate X7 stiffener is in process. Performed welding on center plate to top plate, end diaphragm plates to side plate and stringer plate. Fit up of bearing plate was completed.
8. BK005A-001 All repair work completed after removing the parts. Heat straightening was completed. MT of base metal repair locations completed by ZPMC and CT. Fit up of bearing plate was completed.
9. BK006A-001 Removing of parts was completed. Heat straightening was completed. Required NDT work completed by ZPMC and CT. Welding of bearing plate was completed. Rectification work is in process.
10. BK006A-002 Removing of parts was completed. Heat straightening was completed. MT of base metal repair locations completed by ZPMC and CT. Fit up of bearing plate was completed.

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



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.

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Inspected By:	Patel, Hiranch	Quality Assurance Inspector
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Reviewed By:	McClendon, Timothy	QA Reviewer
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