

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-017144**Date Inspected:** 29-Sep-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

FCAW welding of weld joint BK004A2-004-002, 008, 013, 012 located on Bike Path BK004A-004. Welder is identified as 062752 (2F). ZPMC QC is identified as Lui dao Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint BK004A1-012-008 located on Bike Path BK004A-012. Welder is identified as 062732 (1G). ZPMC QC is identified as Lui dao Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-B-U2-F.

FCAW welding of weld joint SB018-092-025, 031, 049, 055 located on Suspender Bracket SB092W. Welder is identified as 062755 (2G). ABF QC is identified as Peng wen Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint SB018-094-001, 005 located on Suspender Bracket SB094W. Welder is identified as 062808 (1G). ABF QC is identified as Peng wen Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U4b-F.

FCAW welding of weld joint SB021-094-001 located on Suspender Bracket SB094E. Welder is identified as

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058792 (1G). ABF QC is identified as Peng wen Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U4b-F.

During random inprocess inspection of the bike path BK004A-004, this QA inspector observed ZPMC personnel performed plug welding by FCAW on the Bottom Cover Plate, BKPL4A, BKPL4B and BKPL5A to the stringer plate flanges, BKX7.

The plug weld details is as; 15mm diameter hole, 60mm center to center distance.

The bottom cover plate thickness is 6mm.

The welds are identified as; BK004A2-004-014, 015, 017, 019, 020 located on Bike Path BK004A-004.

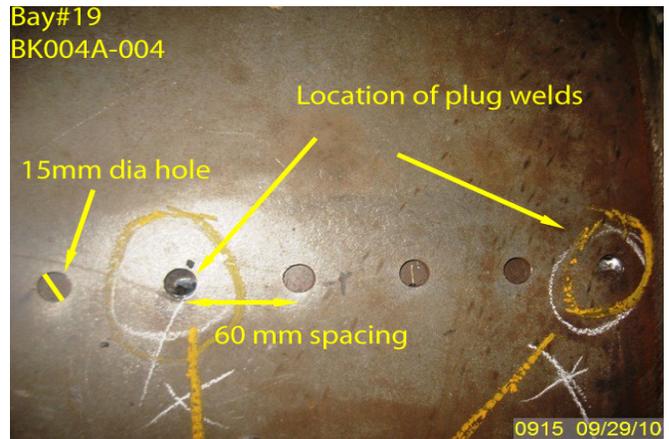
Welder is identified as 259902 (Flat+Plug).

ZPMC QC is identified as Lui dao Feng.

The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132-Plug-1.

For further information, please see attached pictures.

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.

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