

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017179**Date Inspected:** 20-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) Chanxing Island**Location:** Shanghai, China

CWI Name: Mr. Geng Wei
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A

Bridge No: 34-0006**Component:** OBG Bike Path and Segment**Summary of Items Observed:**

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

Bay 14

This QA inspector observed ZPMC qualified welding personnel identified as 045270 perform Submerged Arc Welding (SAW) Welding on OBG Segment 13CW, weld joint identified as SEG3015-006. ZPMC QC is identified as Mr. Xia Chun Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2c-S-2.

Bay 16

This QA inspector observed ZPMC qualified welding personnel identified as 045143 perform Flux Core Arc Welding (FCAW) Welding on OBG Segment 13AW, weld joint identified as LD3031-001-029. ZPMC QC is identified as Mr. Wang Jie. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-FCAW-2G (2F)-FCM-Repair, which is used as per Critical Welding Repair Report (CWR) B-WR1910. See the attached picture.

OBG Segment 12AW

This QA inspector observed ZPMC qualified welding personnel identified as 051348 perform Shielded Metal Arc

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Welding (SMAW) Welding on base metal area such as bottom plate, edge plate, side plate, and floor beam of OBG Segment 12AW. ZPMC QC is identified as Mr. Wang Wei Ming. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-FCAW-2G (2F)-FCM-Repair, which is used as per Critical Welding Repair Report (CWR) B-WR1710.

Bay 19

This QA inspector observed ZPMC qualified welding personnel identified as 062749 perform Flux Core Arc Welding (FCAW) welding on Suspender bracket, weld joint identified as SB020-90-037, 043, 025 and 031. ZPMC QC is identified as Mr. Li Ming Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2232-Tc-U5-F.

This QA inspector observed ZPMC qualified welding personnel identified as 062783 perform FCAW welding on Suspender bracket, weld joint identified as SB020-88-061. ZPMC QC is identified as Mr. Li Ming Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2232-Tc-U5-F.

This QA inspector observed ZPMC qualified welding personnel identified as 062749 perform FCAW welding on Suspender bracket, weld joint identified as SB020-90-004. ZPMC QC is identified as Mr. Li Ming Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2231-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 062762 perform FCAW welding on Suspender bracket, weld joint identified as SB020-86- 001, 004. ZPMC QC is identified as Mr. Li Ming Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2231-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 062904 perform FCAW on Bike Path, weld joint identified as BK004A6-001-072 and 073. ZPMC QC is identified as Mr. Li Ming Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2132.

This QA inspector observed ZPMC qualified welding personnel identified as 062738 perform FCAW on Bike Path, weld joint identified as BK004A2-013-051 and 052. ZPMC QC is identified as Mr. Li Ming Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS -B-T-2132.

This QA inspector observed ZPMC qualified welding personnel identified as 062807 perform FCAW on Bike Path, weld joint identified as BK004A3-013-051 and 052. ZPMC QC is identified as Mr. Li Ming Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2333-Tc-P4-F.

This QA observed ZPMC personnel performing flame straightening by oxygen acetylene on OBG Bike Path BK004A-003 deck panel to deck panel CJP weld, which is used as per HSR(1)-5812. The joining deck panels are

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

identified as BKPL1 and BKPL2. The joint number is identified as BK004A-003-009.

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



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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 , who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Vibin

Quality Assurance Inspector

Reviewed By: McClendon,Timothy

QA Reviewer