

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019205**Date Inspected:** 03-Dec-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:	N/A	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

This QA inspector performed VT of the bike path component internal area previously tested by ZPMC Quality Control personnel. The part is internal components, before welding of closure plates. The member is identified as OBG Components. The bike path designations reviewed are as follows:

BK004A-006- Closure box.

Bike Path-DCP

-During random DCP check, this QA inspector observed out of flatness across the weld exceed the allowable tolerance.

-The component is Bike Path bottom cover plate, seam weld.

-The thickness of the bottom plate is 6mm.

-According to the Standard Specification 1999, Section 55, flatness of the splice weld is measured by 600mm straight edge and the allowable tolerance is 5mm.

-Maximum out of flatness was observed as 7 mm on bike path BK004A-001, weld#BK004A2-001-016,
9.5mm on bike path BK004A-003, weld#BK004A2-003-016.
7.5mm on bike path BK004A-003, weld#BK004A2-008-016-full length.
7.5mm on bike path BK004A-003, weld#BK004A2-008-018.
10mm on bike path BK004A-003, weld#BK004A2-010-018.

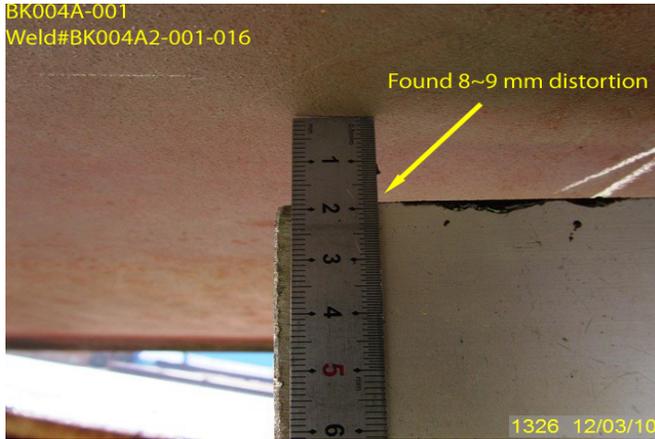
For further information, please find attached pictures

WELDING INSPECTION REPORT

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For further information, please see the attached pictures below. Please see incident report on this date.

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
