

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-020174**Date Inspected:** 05-Jan-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:** See Below**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**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations relative to the work being performed.

OBG Segment Name: Bikepath #BK4 / Bay 19

This Caltrans QA inspector observed ZPMC heat straightening in progress on Bikepath BK4 assembly. QA observed plate member identified as BKPL7A with variations in straightness. QA performed verification measurements and found a portion of the plate straightness to be more than 6mm but less than 8mm out-of-straightness. However, ZPMC elected to proceed with hydraulic jacking and oxy-fuel flame torch heat straightening without engineering approval. AWS D1.5/2002 Section 3.7.3; Members distorted by welding shall be heat straightened by mechanical means or by carefully supervised application of a limited amount of localized heat as approved by the engineer. Caltrans Special Provisions Section 8-3: "For material less than or equal to 16 mm thick, the Contractor shall not heat straighten members more than 6 in 1000 without prior approval of the Engineer.

This QA inspector generated a Quality Assurance-Incident Report for the heat straightening violation. See Quality Assurance-Incident Report, dated 01-05-10 for additional information. ZPMC QC inspector is identified as Mr. Zhou Cheng.

OBG Segment Name: 9BW / North of Bay 17

This Caltrans QA inspector observed Flux Cored Arc Welding (FCAW) in progress. Welder is identified as #045232 welding CJP weld in the 1G position using WPS-B-T-2231-B-U2-F-1. The weld is identified as #FB027-008-164. ZPMC QC inspectors are identified as Mr. Li Ping and certified welding inspector (CWI), Mr.

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Li Yan Hua. The welding variables recorded by QC appeared to comply with the WPS.

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

Summary of Conversations:

“As noted within the contents of this report.”

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:	Hasler, Mike	Quality Assurance Inspector
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Reviewed By:	Riley, Ken	QA Reviewer
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