DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-020177
Date Inspected: 02-Jan-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name: See Below

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No		
Electrode to specification:	☐ Yes	☐ No	☑ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A	
Qualified Welders:	☐ Yes	☐ No	☑ N/A	**Weld Procedures Followed:**	☐ Yes	☐ No	☑ N/A	
Approved Drawings:	☑ 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

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.

Bay 19

This Caltrans QA Inspector performed plate straightness verification on bottom plate subassembly identified as BP026-013, BP025-013 and BP026-014. Plate straightness measurements were performed in accordance Caltrans Special Provisions, Section 8-3 requirements. Which states: “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”. Caltrans QA inspector found that the plates mention above were found in non-conformance, and would require engineer approval prior to straightening. However, ZPMC performed heat straighten plate on subassembly BP026-014, after being informed by ZPMC Quality Control inspector that they could not heat straighten the plate without engineer approval. This QA inspector generated a Quality Assurance-Incident Report for the heat straightening violation. See Quality Assurance-Incident Report, dated 01-02-10 for additional information. ZPMC QC inspector/ Certified Welding Inspector (CWI), is identified as Mr. Lv Li Qing.
Plate subassembly dimensions for out-of-straightness, are as follows:
BP026-013
Three (3) locations: (1) Plate 12mm, #X35A >6~<8mm, W@ splice weld 3side, 380x80mm (2) >6~9mm, E@ splice weld 2 side, 635x170 (3) >6~10mm, E@ splice weld side, 495x670mm.
BP025-013
Seven (7) locations: (1) Plate 12mm, #X34A >6~8mm, W@ splice weld 2, 345x380mm (2) >6~8mm, W@ splice weld 3, 630x520mm (3) >6~8mm, E@ splice weld 4, 470x445mm (4) >6~15mm, E-between splice weld 3

& 4, 700x535mm (5) >6~8mm, E@ splice weld 3, 780x270mm (6) Plate #X35A >6~8.5mm, S- between stiffener weld 47 & 48, 360x380 (7) >6~10mm S-between stiffener weld 49 & 50, 445x330mm.

BP026-014
One (1) location: (1) Plate 12mm, #X34A >6~ 12.5mm, E@ splice weld 3, 655x640mm
Note: A-denotes stiffener side, B-denotes plate side, E-denotes east side of assembly, W-denotes west side of assembly, S-denotes south end of assembly.

The following digital pictures illustrate plate subassembly out-of-straightness. Photos please see; Z:\Inspector Reports\B293 Hasler.

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
Reviewed By:	Riley,Ken	QA Reviewer