

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023154**Date Inspected:** 24-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**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 and testing relative to the work being performed.

Bay 1

This QA inspector observed ZPMC in process of SMAW welding Bike Path Handrail sub-assemblies. ZPMC QC inspector Li Wei Lin was present at this time of this observation and informed this QA inspector of the work that is in process and identified Tian Lei as the CWI. It was stated that ZPMC had 1 welder and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- Bike Path Handrail Sub-assembly

WPS-B-P-2112

Welder- 215083, 048659

2F/FCAW (Post to Base Plate)

Bay 10**UT Inspection**

This Caltrans QA inspector received ZPMC non-destructive test (NDT) Inspection Notification, Doc. #08919 Item 1~11 from ZPMC for QAUT verification for built-up "C" channel splice assembly and bike path assembly. This QA inspector performed ultrasonic test (UT) verification, after ZPMC had performed their UT inspection of the following locations.

WELDING INSPECTION REPORT

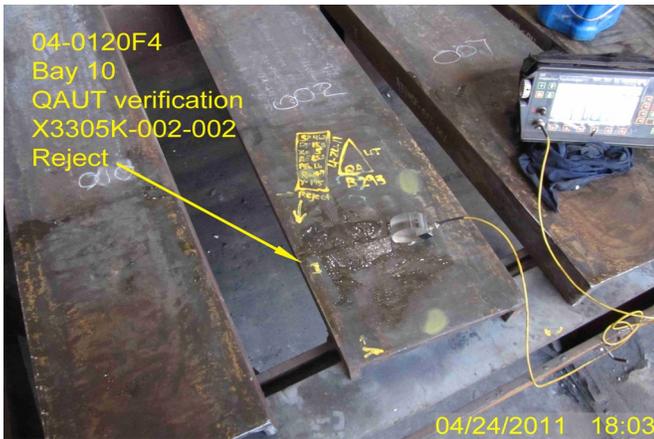
(Continued Page 2 of 2)

Item 1: BK014A6-001-173~176, Item 2: X3305K-001-001, 002, Item 3: X3305K-002-001, 002, Item 4: X3305K-003-001, 002, Item 5: X3305K-004-001, 002, Item 6: X3305K-005-001, 002, Item 7: X3305K-006-001, 002, Item 8: X3305K-007-001, 002, Item 9: X3305K-008-001, 002, Item 10: X3305K-009-001, 002, Item 11: X3305K-010-001, 002

At the time of the verification it was noted that the above component weld Item 3 X3305K-002-002 was found unacceptable in accordance with AWS D1.5 UT Acceptance-Rejection Criteria, Table 6.3. This QA inspector generated an Incident Report (IR) non-compliance welds. See Caltrans Ultrasonic Test Report (TL6027), dated 04-24-2011 for additional information.

The following digital picture illustrates built-up “C” channel splice assembly testing.

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 James Devey 15000026784, who represents the Office of Structural Materials for your project.

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