

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-025306**Date Inspected:** 08-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Corporation, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Mai Quin Li**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:** Bike Path Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Delbert Humphrey was present during the times noted above for observations relative to the work being performed at ZPMC.

OBG Bay # 14

WELDING

This QA observed the following components in this bay, OBG, Steel Barriers. This QA observed no work being performed on the above mentioned components during the time QA was present.

OBG Bay # 16

WELDING

This QA Inspector observed the following work in progress:

FCAW welding of weld identified as BKSA009-001-004, located on Cantilever Truss Assembly BKSA009-001. Welder is identified as 201074. ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-FCAW-1F-ESAB.

OBG Bay # 19

WELDING

This QA Inspector observed the following work in progress:

FCAW welding of weld identified as BK24A11-001-011, located on Bike Path, BK24A11-001. Welder is

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

identified as 062808. ZPMC Quality Control (QC) is identified as Mr. Peng Wen Jun. The welding variables recorded by QC appeared to comply with WPS-B-T-2231-ESAB.

OBG Bay # 13

WELDING

This QA observed the following components in this bay, OBG, Steel Barriers. This QA observed no work being performed on the above mentioned components during the time QA was present.

OBG Bay # 28

WELDING

This QA observed the following components in this bay, OBG, Mock-Up Service Hand Rails. This QA observed no work being performed on the above mentioned components during the time QA was present.

OBG, Paint Yard and Paint Bay 2

WELDING

This QA Inspector observed the following work in progress:

Upon request by Caltran Quality Assurance(QA)Paint Inspector. This Quality Assurance(QA) found steel barrier E5-SB22A-001 to have insufficient welds in weld area 026 and welds to close to bolt holes causing interference with bolting assembly. In formed ABF Quality Control Mr. Gao Zhen Kun. Location is at Paint Yard in front of Bay 2.

Upon request by Caltran Quality Assurance(QA) Paint Inspector. This Quality Assurance(QA) found steel barriers E2-SB25A-001 to have a notch in the side of base plate approximately 5mm in depth. In formed ABF Quality Control Mr. Gao Zhen Kun. Location is at Paint Yard in front of Bay 2.

Upon request by Caltran Quality Assurance(QA) Paint Inspector. This Quality Assurance(QA) found steel barriers W5-SB38BA-001 to have a notch in the front shell, part #w5-p-68, approximately 6mm in depth. In formed ABF Quality Control Mr. Gao Zhen Kun. Location is at Paint Yard in front of Bay 2.

Upon request by Caltran Quality Assurance(QA)Paint Inspector. This Quality Assurance(QA) found steel barrier W2-SB27-001 to have insufficient welds in weld area 026 and welds to close to bolt holes causing interference with bolting assembly. In formed ABF Quality Control Mr. Gao Zhen Kun. Location is at Paint Yard in front of Bay 2.

Description of Incident: During the Quality Assurance (QA) random visual inspection of OBG Steel Barriers, W2-SB27-002-026 & E5-SB22A-001-026 in front of Paint Shop #2, this QA Inspector discovered the following issues:

- Tack welds not incorporated into the final weld need to be removed on BKPL82A.
- The fillet weld horizontal leg extended to the edge of the bolt hole causing interference with the bolting assembly.

-The following Steel Barriers are identified as:

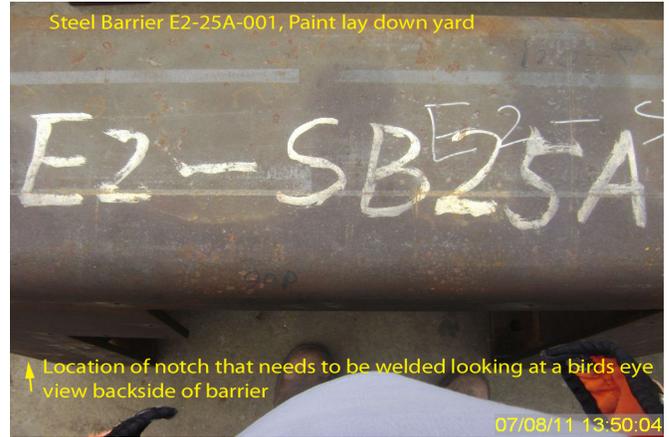
- Inside Paint Shop #2, the Steel Barrier is identified as W2-SB27-002-026.
- In front of Paint Shop #2, the Steel Barrier is identified as E5-SB22A-001-026.

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

- A total of 12 bolt holes on 3 bottom base plates to front shell of steel barriers are affected.

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



WELDING INSPECTION REPORT

(Continued Page 4 of 4)



Summary of Conversations:

No relevant conversations were reported on this date.

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, 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Humphrey, Delbert	Quality Assurance Inspector
----------------------	-------------------	-----------------------------

Reviewed By:	Hall, Steven	QA Reviewer
---------------------	--------------	-------------