

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-025313**Date Inspected:** 30-Jun-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 # 16

WELDING

This QA Inspector observed the following work in progress:

FCAW welding of weld identified as BKSA9A-011, located on Cantilever Truss Assembly BK21A. 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.

This QA Inspector took measurements for gap between barriers, on E5-SKYWAY-002, steel barrier, found front gap to be 3.5, details call for 2mm gap, back was tight fit, details call for 2mm gap, top was a tight fit, details call for 2mm gap. This work is in progress.

This QA Inspector took measurements for gap between barriers, on E5-SAS, steel barrier, found front to be 2mm, details call for 2mm gap, back was found to be 7mm gap, details call for 10mm gap, top was found to be 26mm gap, detail call for 30mm gap. This work is in progress.

OBG Bay # 19

WELDING

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This QA Inspector observed the following work in progress:

Parts for BK9003 were being laying out dimensions and cutting to size.

FCAW welding of weld identified as BK024A11-069, located on Bike Path, BK024A. Welder is 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.
Threads were being drilled in holes on backside of steel barrier W5-SB30C-001.

OBG Bay # 28 WELDING

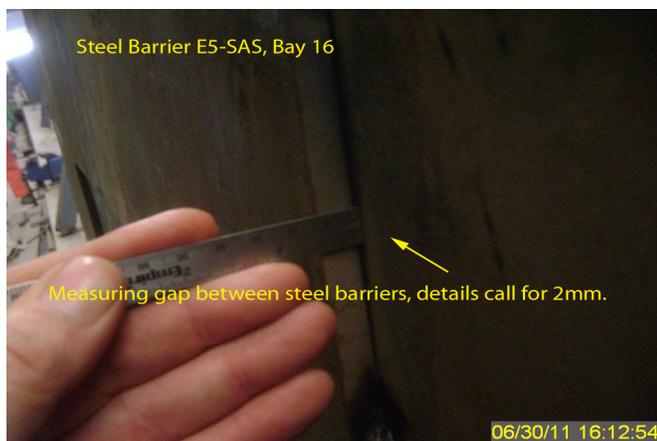
This QA observed the following components in this bay, OBG, Mock-Up Service Hand Rails. This QA observed no work being performed on the above mentioned components during the time QA was present.

Bay #19 NDT

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 09620.

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an UT report for this date. Time of inspection was 8:45 hours. The members are identified as follows OBG Components. The weld designations reviewed are as follow: BK24A10-001-002, 003, 004, 033, 071, 034.

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



WELDING INSPECTION REPORT

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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
