

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-026110**Date Inspected:** 05-Aug-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:

During random in process inspection this QA observed ZPMC personnel Heat Straightening Bike Path Handrail member as identified as BKR-FS1-001, between panel points PP17 & 23. Heat Straightening is being performed to bring handrail into tolerance. ZPMNC Quality Control (QC) inspector identified as Mr. Mai Quin Li was present to monitor the heat straightening process. The heat straightening process did appear to comply with Heat Straightening Report HS # 10418 (B).

OBG Bay # 19

WELDING

This QA Inspector observed the following work in progress:

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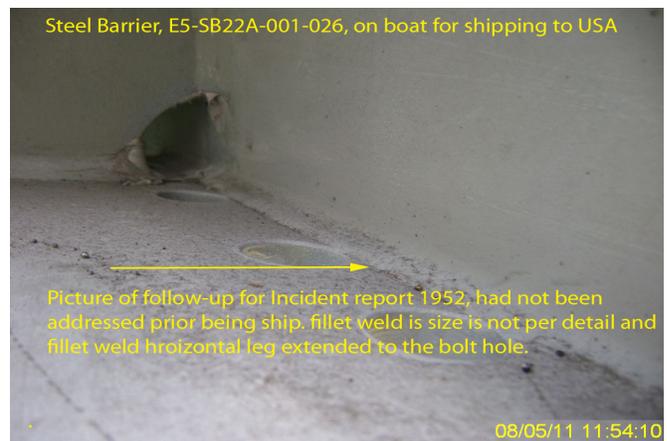
FCAW welding of welds BK9003A5-001-214, located on Bike Path, BK9003A. Welder is identified as 062794. ZPMC Quality Control (QC) is identified as Mr. Peng Wen Jun. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

OBG, Boat for shipping

As requested by Caltrans to do a follow-up on punch list item 3718, TC-RFI-0466R0, applied to E2-SAS-1, E5-SAS-1W2-SAS-1, W5-SAS-1. Found 15mm single-sided fillet weld to be of correct size upon measuring with a fillet gage. The un-welded side of the stiffener plate E5-SP-6, E2-SP-5, had not been caulked as per TC-RFI-0466R0. This QA asked AB/F Jeff Chan if items above had been repaired he said he didn't know and he would find out.

As requested by Caltrans to do a follow-up on Incident Report 1952, punch list item 3734, steel barrier W2-SB27-002, weld number 026 & punch list 3718, E5-SB22A-001, weld number 026, found that weld size was not 10mm as per detail and fillet weld horizontal leg extended to the edge of the bolt hole causing interference with bolting assembly had not been repaired. Prior to performing follow-up this QA asked ZPMC Quality Control (QC) inspector identified as Mr. Mai Quin Li if the items mentioned above had been repaired. Mr. Mai Quin Li said that he did not know that they were on the boat. Prior to performing follow-up this QA asked AB/F Jeff Chan if items above had been repaired he said he didn't know and he would find out.

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



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.

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Inspected By: Humphrey, Delbert

Quality Assurance Inspector

Reviewed By: Hall, Steven

QA Reviewer