

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-026627**Date Inspected:** 25-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 Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lei/Wen/Shigang**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 Bike Path**Summary of Items Observed:**

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

Bay 9

In Process Inspection FCAW

This QA Inspector observed the following work in progress: FCAW welding of weld joint 031 located on 3017TR1-001. Welder is identified as 059443. ZPMC Quality Control (QC) is identified as Chen Shigang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Bay 16

This QA Inspector performed VT review of randomly selected welds located on base plate (BKX73B) of Bike Path BK21. The following issues have been noted.

- Linear Indications on base plate BKX73B
- Linear Indications are located at temporary attachment removal areas.
- Indications were confirmed by MT
- Indications were clearly marked on the plate
- See attached pictures for additional information.

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ZPMC personal need to remove the indications and perform required repair work and NDT.

Bay 19

In Process Inspection FCAW

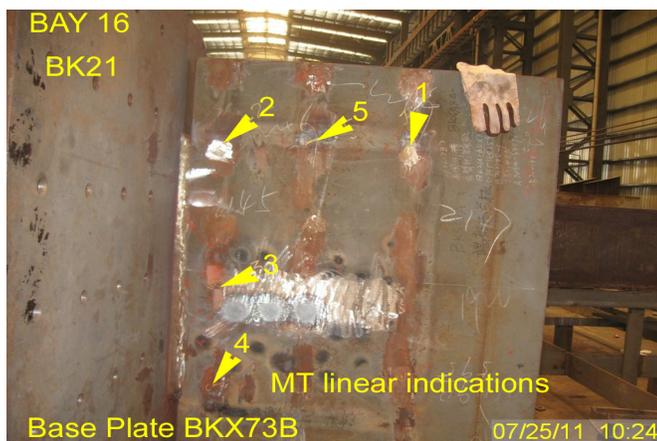
This QA Inspector observed the following work in progress: FCAW welding of weld joint 001 located on BK9003A10-001. Welder is identified as 062794. ZPMC Quality Control (QC) is identified as Peng Wen Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA Inspector observed the following work in progress: FCAW welding of weld joint 002 located on BK9003A10-001. Welder is identified as 062794. ZPMC Quality Control (QC) is identified as Peng Wen Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA Inspector observed the following work in progress: FCAW welding of weld joint 011 located on BK9003A10-001. Welder is identified as 062794. ZPMC Quality Control (QC) is identified as Peng Wen Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA Inspector observed the following work in progress: FCAW welding of weld joint 012 located on BK9003A10-001. Welder is identified as 062794. ZPMC Quality Control (QC) is identified as Peng Wen Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

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

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Inspected By:	Leavitt, Scott	Quality Assurance Inspector
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Reviewed By:	Clifford, William	QA Reviewer
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