

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006093**Date Inspected:** 08-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**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:** Tower Fabrication**Summary of Items Observed:**

Need corrections of ut weld numbers PSD 3-29-09

CWI Inspectors Mr. Wu Ming Kai, Mr. Lia Huaije

On this date CALTRANS OSM Quality Assurance (QA) Inspector Mr. Paul Dawson arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

This QA Inspector performed random ultrasonic (UT) inspections of approximately 10 percent length of East Tower Lift 3 Skin plate C stiffener to skin plate welds ESD1-FCSA3-2B/C-35. This weld had previously been ultrasonically inspected and accepted by ZPMC inspection personnel. The QA Inspector observed the weld that was ultrasonically inspected by this QA Inspector appear to comply with AWS D1.5 UT requirements. For additional information on this inspection see the TL6027 Ultrasonic Test Report.

This QA Inspector performed random ultrasonic (UT) inspections of approximately 10 percent length of West lift 2 skin plate D welds WSD1-SA340-D/F-9, WSD1-SA340-E/F-9, WSD1-SA340-E/F-26. These welds had previously been ultrasonically inspected and accepted by ZPMC inspection personnel. The QA Inspector observed the welds that were ultrasonically inspected by this QA Inspector appear to comply with AWS D1.5 UT requirements. For additional information on this inspection see the TL6027 Ultrasonic Test Report.

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This QA Inspector performed random ultrasonic (UT) inspections of approximately 10 percent length of North lift 2 skin plate weld NSD1-SA223-D/E-1. This weld had previously been ultrasonically inspected and accepted by ZPMC inspection personnel. The QA Inspector observed the weld that was ultrasonically inspected by this QA Inspector appear to comply with AWS D1.5 UT requirements. The other seven stiffener to skin plate welds have been ultrasonically rejected by ZPMC Inspectors. For additional information on this inspection see the TL6027 Ultrasonic Test Report.

This QA Inspector performed random ultrasonic (UT) inspections of approximately 10 percent length of West Lift 2 Skin plate D stiffener to skin plate welds WSD1-SA209-DD-8, WSD1-SA209-DD-15, WSD1-SA209-DD-22. These welds have previously been ultrasonically inspected and accepted by ZPMC inspection personnel. The QA Inspector observed the welds that were ultrasonically inspected by this QA Inspector appear to comply with AWS D1.5 UT requirements. For additional information on this inspection see the TL6027 Ultrasonic Test Report.

The QA Inspector observed ZPMC welder Ms. Liu Xiaoyan stencil 207745 is using welding procedure specification WPS-B-T-2221-B-S2 to make submerged arc groove weld SSD1-FDSA-1A/D-5A. The QA Inspector observed ZPMC Quality Control personnel monitoring this welding and The QA Inspector observed ZPMC Quality Control personnel measuring Ms. Liu Xiaoyan having a welding current of approximately 330 amps and 30.0 volts. Items observed by the QA Inspector appear to comply with project specifications.

The QA Inspector observed ZPMC welder Ms. Wang Shouqin stencil 201750 is using welding procedure specification WPS-B-T-2221-B-S2 to make submerged arc groove weld SSD1-FDSA-1A/D-6A. The QA Inspector observed ZPMC Quality Control personnel monitoring this welding and QC CWI Inspector Mr. Chen Shan Hua has recorded Ms. Wang Shouqin having a welding current of approximately 665 amps, 31.2 volts and a travel speed of 535 mm per minute. Items observed by the QA Inspector appear to comply with project specifications.

This QA Inspector performed random ultrasonic (UT) inspections of approximately 10 percent length of West Tower Lift 3 Skin plate E stiffener to skin plate welds WSD1-FESA3-1A/D-18. This weld had previously been ultrasonically inspected and accepted by ZPMC inspection personnel. The QA Inspector observed the weld that was ultrasonically inspected by this QA Inspector appear to comply with AWS D1.5 UT requirements. For additional information on this inspection see the TL6027 Ultrasonic Test Report and the photograph below.

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Summary of Conversations:

See above.

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 Serge Sinevod phone: 134-8257-0045 , who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
