

**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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009032**Date Inspected:** 08-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**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:** OBG Fabrication**Summary of Items Observed:**

CWI Inspectors: Mr. Zhu Zon Hai, Mr. Lv Li Qing

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. This QA Inspector observed the following:

**OBG Bay 14**

This QA Inspector observed ZPMC welder Mr. Xue Xiang Liang, stencil 066478 is using shielded metal arc welding procedure WPS-B-P-2211-TC-U4b-FCM to make tack welds between OBG side plates SP142a and SP169A. The QA Inspector observed a welding current of approximately 165 amps. This QA Inspector observed the shielded metal arc welding electrodes are being stored in an electrically heated electrode storage container which is warm to the touch. This QA Inspector observed that Mr. Xue Xiang Liang is certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Ms. Wang Min, stencil 044771 is using welding procedure specification WPS-B-P-2221-TC-U4b-FCM to make submerged arc groove weld SEG065A-006. This QA Inspector observed ZPMC Quality Control personnel monitoring this welding and this QA Inspector observed a welding current of approximately 580 amps and 33.0 volts and Ms. Wang Min is certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

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## WELDING INSPECTION REPORT

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This QA Inspector observed ZPMC welder Mr. Tu Zhi Wu, stencil 0214945 has used flux cored welding procedure WPS-B-T-2133 to make weld SSD19A-PP89-125. The QA Inspector observed ZPMC QC Inspector Mr. Zhang Xian Ji has recorded a welding current of 209 amps and 25.1 volts. This QA Inspector observed that Mr. Tu Zhi Wu is certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Dong Chang Xi, stencil 070046 is using flux cored welding procedure WPS-B-T-2132 to make OBG weld SSD19-pp90-109. The QA Inspector observed that ZPMC QC Inspector Mr. Tian Lei has recorded a welding current of 307 amps and 30.3 volts. Items observed on this date appeared to generally comply with applicable contract documents.

**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 Eric Tsang phone: 150-0042-2372 , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Dawson,Paul	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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