

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-009036**Date Inspected:** 12-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. Li Yang, Mr. Li Zhi Jiang

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 2**

This QA Inspector observed ZPMC welder Mr. Lv Feng Yin, stencil 215676 is using welding procedure specification WPS-B-T-2132-3-3F (2F) to make flux cored weld FB3082-003-019. The QA Inspector observed ZPMC Quality Control personnel monitoring the base material temperature and other welding attributes. This QA Inspector measured a welding current of approximately 300 amps and 30.0 volts. Items observed by this QA Inspector appear to be progressing in compliance with project specifications.

This QA Inspector observed ZPMC welder stencil 206358 is using welding procedure specification WPS-B-T-2132-3-3F (2F) to make flux cored weld FB3023-001-051. The QA Inspector observed ZPMC Quality Control personnel monitoring the base material temperature and other welding attributes. This QA Inspector measured a welding current of approximately 300 amps and 29.5 volts. Items observed by this QA Inspector appear to be progressing in compliance with project specifications.

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## WELDING INSPECTION REPORT

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This QA Inspector observed ZPMC welder Mr. Rao Wei, stencil 049972 is using shielded metal arc process WPS-B-T-2112 to tack OBG floor beam FB3094-001 stiffener plates. This QA Inspector observed a welding current of approximately 160 amps, the base material is clean where the tack welds were being made and Mr. Rao Wei is certified to make this weld. 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 and it appears to be connected to the welding power supply cable. Items observed on this date appeared to generally comply with applicable contract documents.

### OBG Bay 9

This QA Inspector observed ZPMC welder Mr. Xiang Jie, stencil 59378 is using welding procedure WPS-B-T-2133 to make flux cored weld DP3030-001-016. This weld attaches a stiffener plate to the inside of closed rib for OBG deck panel DP3030-001. This QA Inspector observed the base material had been cleaned of oxides where the stiffener welds are to be installed. This QA Inspector observed a welding current of approximately 200 amps 25.0 volts and Mr. Xiang Jie 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. Xu Guo Yin, stencil 059443 is using welding procedure WPS-B-T-2133 to make flux cored weld DP3030-001-016. This weld attaches a stiffener plate to the inside of closed rib for OBG deck panel DP3030-001. This QA Inspector observed the base material had been cleaned of oxides where the stiffener welds are to be installed. This QA Inspector observed a welding current of approximately 185 amps 25.0 volts and Mr. Xu Guo Yin is certified to make this weld. 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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