

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-009999**Date Inspected:** 03-Nov-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. Shen Fu You, Mr. Lv Li Qing, Mr. Liu Xiao Zhong

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 13

This QA Inspector observed ZPMC welder Ms. Jin Chen Mao, stencil 058551 using flux cored welding procedure WPS-B-T-2132 to make OBG weld SSD070B-021 at panel point 102. This QA Inspector observed a welding current of approximately 300 amps and 31.2 volts. This QA Inspector observed that Ms. Jin Chen Mao 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. Zhao Jibo, stencil 055564 has recently used flux cored welding procedure WPS-B-T-2132 to make OBG weld SEG070C-009. This QA Inspector observed ZPMC QC Inspector Mr. Zhong Guo Hui has recorded a welding current of 295 amps and 30.4 volts. This QA Inspector observed that Mr. Zhao Jibo appears to be 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. Chen Fenglian, stencil 206623 is using the flux cored welding

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process to make OBG Corner Assembly weld CSD5-PP95-003. This QA Inspector measured a welding current of 300 amps and 31.7 volts. This QA Inspector confirmed that Ms. Chen Fenglian appears to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

OBG Bay 14

This QA Inspector observed ZPMC welder Ms. Wang Min, stencil 048296 has been using submerged arc welding procedure specification WPS-B-T-2221-B-L2C-S-2 to make groove weld SEG068*-004. This QA Inspector observed Ms. Wang Min appears to be certified to make this weld. This QA Inspector observed QC personnel have recorded a welding current of approximately 609 amps and 30.9 volts. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Ms. Jiang Xiv Rong, stencil 058243 is using shielded metal arc welding procedure specification WPS-B-P-2113 to weld diaphragm a plate to deck plate DP231-001. This QA Inspector observed a welding current of approximately 145 amps and Ms. Jiang Xiv Rong 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. Items observed on this date appeared to generally comply with applicable contract documents.

Outside of OBG Bay 13

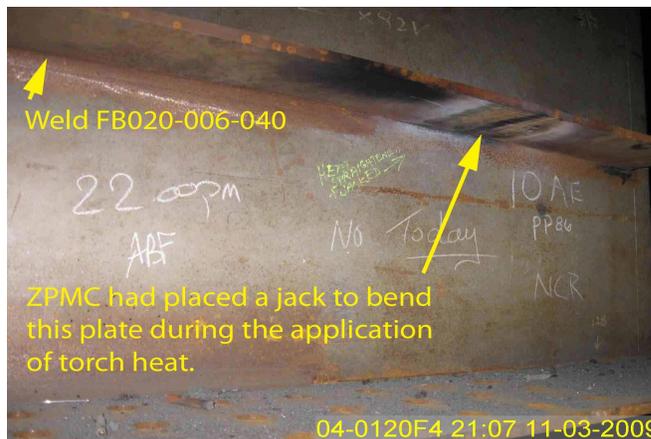
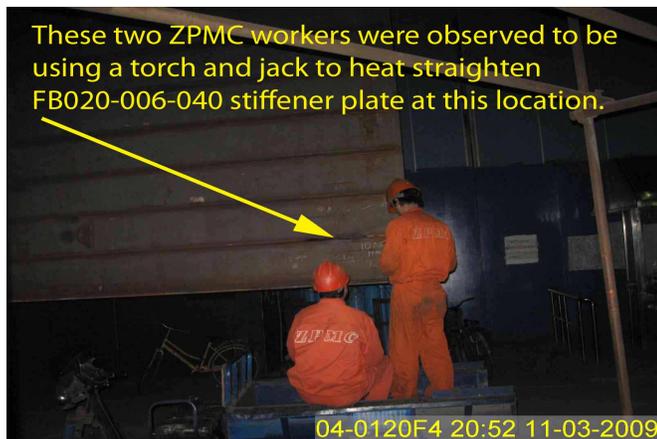
This QA Inspector issued an incident report for the following:

ZPMC personnel were observed by this QA inspector to be using a torch to heat and a jack to straighten OBG 10AE, FB020-006-040 stiffener plate at panel point 86. ZPMC QC representatives were not present at the front of OBG Bay 13 where this activity took place, the workers did not appear to have any way to monitor the temperature of the steel and no approved heat straightening documentation was at the location of this work. See the photographs below for additional information.



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

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
