

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-010735**Date Inspected:** 09-Dec-2009**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:** Li Yang**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:** Test Coupon**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dan Hernandez was present during the times noted above to observe the fit up, welding and related activities associated with the fabrication of the San Francisco Oakland Bay Self Anchored Suspension Bridge at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Tower Bay 10

This QA Inspector observed 18 ZPMC personnel performing welder qualification testing in the 3G/4G position using the Shielded Metal Arc Welding process; a 25mm thick x 150mm in length test coupon was used. ZPMC CWI Xu La Feng was present during welder qualification. WPS-B-P-2213-B-U2a-1 was used for the 3G position and WPS-B-P-2214-B-U2a-1 was used for the 4G position. Welders were assigned a number 1 thru 18; assigned number was stamped on the test coupon.

1: Qu Fengsong- (3G/4G) 4G test coupon was rejected by ZPMC CWI for exceeding 3mm weld reinforcement

2: Liu Tongxia- (3G/4G)

3: Hua Linming- (3G/4G)

4: Xu Jianwen- (3G/4G)

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- 5: Yun Qiang- (3G/4G) 4G test coupon was rejected by ZPMC CWI for exceeding 3mm weld reinforcement

- 6: Zhang Jichu- (3G/4G)

- 7: Miao Xueshan- (3G/4G)

- 8: Sun Daomin- (3G/4G) 4G test coupon was rejected by ZPMC CWI for exceeding 3mm weld reinforcement

- 9: Shen Yunchun- (3G/4G) 4G test coupon was rejected by ZPMC CWI for exceeding 3mm weld reinforcement

- 10: Zhang Shigang- (3G/4G) 4G test coupon was rejected by ZPMC CWI for exceeding 3mm weld reinforcement

- 11: Chen Hongyue- (3G/4G) 3G test coupon was rejected by ZPMC CWI for exceeding 3mm weld reinforcement

- 12: Zhang Zhiwei- (3G/4G)

- 13: Wei Jianeng- (3G/4G)

- 14: Wu Zhen- 3G

- 15: Sun Guangping- 4G 4G test coupon was visually rejected by ZPMC CWI

- 16: Shi Xingyu-4G

- 17: Chen Qiqiong- 4G

- 18: Tang Yong- 4G

ZPMC Quality Control (QC) Inspector is identified as Xu Le Feng. QA Inspector observed QC Inspector verify welding parameters. 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, 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By: Hernandez,Dan

Quality Assurance Inspector

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Reviewed By: Miller,Mark

QA Reviewer