

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-011341**Date Inspected:** 06-Jan-2010**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 and Tower**Summary of Items Observed:**

CWI Inspectors: Mr. Zhu Tian Shu, Mr. Liu Fa Wen

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 3

This QA Inspector observed ZPMC welder Mr. Pan Shi Jun, stencil 204338 is using flux cored welding procedure WPS-B-T-2233-B-U2-F to make OBG cross beam 14 weld FB204-041-064. This QA Inspector observed a welding current of approximately 210 amps and 24.0 volts. This QA Inspector verified Mr. Pan Shi Jun appears to be certified to make this weld and that ZPMC QC Inspector Mr. Guo Yuan is monitoring this welding. Items observed on this date appeared to generally comply with applicable contract documents.

OBG BAY 5

This QA Inspector observed ZPMC welder Ms. Song Aiyong, stencil 215689 is using flux cored welding process WPS-345-FCAW-1G(1F)-Repair-1 add weld material to extend the length of traveler rail 10TR4-001 in accordance with critical weld repair BCWR-982. This QA Inspector observed a welding current of approximately 280 amps and 28.5 volts and Ms. Song Aiyong appears to be certified to make this weld. Items observed on this

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date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Ms. Ban Qiuyun, stencil 250353 is using flux cored welding process WPS-345-FCAW-1G(1F)-Repair-1 add weld material to extend the length of traveler rail 10TR3-018 in accordance with critical weld repair BCWR-982. This QA Inspector observed a welding current of approximately 290 amps and 29.5 volts and Ms. Ban Qiuyun 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 Mr. Si Gao Feng, stencil 204342 is using flux cored welding process WPS-345-FCAW-1G(1F)-Repair-1 add weld material to extend the length of traveler rail 10TR1-018 in accordance with critical weld repair BCWR-982. This QA Inspector observed a welding current of approximately 265 amps and 28.8 volts and Mr. Si Gao Feng 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 Mr. Shen Tianju, stencil 215083 is using the shielded metal arc welding process WPS-345-SMAW-1G(1F)-Repair add weld material to extend the length of traveler rail 10TR7-001 in accordance with critical weld repair BCWR-982. This QA Inspector observed a welding current of approximately 130 amps and Mr. Shen Tianju 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 Mr. Li Yuan Zheng, stencil 217185 is using flux cored welding process WPS-345-FCAW-1G(1F)-Repair-1 add weld material to extend the length of traveler rail 10TR1-024 in accordance with critical weld repair BCWR-982. This QA Inspector observed a welding current of approximately 310 amps and 29.8 volts and Mr. Li Yuan Zheng appears to be 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.

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