

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-011487**Date Inspected:** 17-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. Gong Liang Zhu, 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:

Heavy Dock Towers

This QA Inspector observed ZPMC welder Mr. Ma Yusheng, stencil 040759 is using flux cored welding procedure WPS-B-T-2333-TC-P4-F to make weld WSD1-SA279-F/H-10. This weld is located on the exterior of the base of West tower lift 1 on the Heavy Dock. This QA Inspector observed ZPMC QC Inspector Mr. Sun Zi Wang is monitoring this welding, Mr. Ma Yusheng appears to be certified to make this weld and this QA Inspector measured a welding current of approximately 220 amps and 26.5 volts. Items observed by this QA Inspector appear to be progressing in compliance with project specifications.

This QA Inspector observed ZPMC welder Mr. Li Ming Yan, stencil 040706 is using flux cored welding procedure WPS-B-T-2333-TC-P4-F to make weld WSD1-SA279-F/H-27. This weld is located on the exterior of the base of West tower lift 1 on the Heavy Dock. This QA Inspector observed ZPMC QC Inspector Mr. Sun Zi Wang is monitoring this welding, Mr. Li Ming Yan appears to be certified to make this weld and this QA Inspector measured a welding current of approximately 215 amps and 24.0 volts. Items observed by this QA

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Inspector appear to be progressing in compliance with project specifications.

This QA Inspector observed ZPMC welder Mr. Li Xing Quan, stencil 062126 is using flux cored welding procedure WPS-B-T-2333-TC-P4-F to make weld WSD1-SA279-F/H-33. This weld is located on the exterior of the base of West tower lift 1 on the Heavy Dock. This QA Inspector observed ZPMC QC Inspector Mr. Sun Zi Wang is monitoring this welding, Mr. Li Xing Quan appears to be certified to make this weld and this QA Inspector measured a welding current of approximately 210 amps and 25.0 volts. Items observed by this QA Inspector appear to be progressing in compliance with project specifications.

This QA Inspector observed ZPMC welder Mr. Wang Daping, stencil 040736 is using flux cored welding procedure WPS-B-T-2333-TC-P4-F to make weld WSD1-SA279-F/H-33. This weld is located on the exterior of the base of West tower lift 1 on the Heavy Dock. This QA Inspector observed ZPMC QC Inspector Mr. Sun Zi Wang is monitoring this welding, Mr. Wang Daping appears to be certified to make this weld and this QA Inspector measured a welding current of approximately 205 amps and 23.5 volts. Items observed by this QA Inspector appear to be progressing in compliance with project specifications.

This QA Inspector observed ZPMC welder Mr. Yin Guo Qiang, stencil 056792 is using flux cored welding procedure WPS-B-T-2333-TC-P4-F to make weld WSD1-SA279-F/H-33. This weld is located on the exterior of the base of West tower lift 1 on the Heavy Dock. This QA Inspector observed ZPMC QC Inspector Mr. Sun Zi Wang verifying the base material adjacent to this welding is above 65 degrees Celsius and below 220 degrees Celsius and Mr. Yin Guo Qiang appears to be certified to make this weld. This QA Inspector observed the welding parameters that have been recorded by QC Inspector Mr. Sun Zi Wang appear to comply with project specifications.

OBG BAY 14

This QA Inspector observed ZPMC welder Mr. Zhang Zing Quan stencil 044774 is using flux cored welding procedure WPS-345-FCAW-1G(1F)-Repair to make traveler rail repair weld 11TR2-014-011. This QA Inspector measured a welding current of approximately 320 amps and 29.0 volts. This QA Inspector observed Mr. Zhang Zing Quan appears to be certified to make this weld. The weld repair document that lists this weld repair does not have any number assigned to allow tracking of this repair. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Yuan Wensong, stencil 055491 is using flux cored welding procedure WPS-345-FCAW-1G(1F)-Repair to make traveler rail repair weld 11TR1-014-014. This QA Inspector observed ZPMC measuring a welding current of 307 amps and 30.6 volts. This QA Inspector observed Mr. Yuan Wensong appears to be certified to make this weld. The weld repair document that lists this weld repair does not have any number assigned to allow tracking of this repair. 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

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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
