

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-013579**Date Inspected:** 13-Mar-2010**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:** OBG Segment**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.

OBG Trial Assembly Yard

Segment 7AW/7BW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as OBW7-002. The welder is identified as #045196 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as OBW7-003. The welder is identified as #067752 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1.

Lift 6 East, 6 West

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

This QA Inspector observed grit blasting in progress.

Welder Qualification

This QA Inspector observed Welder Qualifications of ZPMC personnel. The weld test positions were in the 3G, 4G, 3F and 4F with the Shielded Metal Arc Welding (SMAW) and Flux Cored Arc Welding (FCAW) process. The WPS used for SMAW were WPS-B-P-2213-B-U2a-1 (3G), WPS-B-P-2113 (3F), WPS-B-P-2114 (4F), WPS-B-P-2214-B-U2a (4G) and WPS-B-T-2233-B-U2a-F-1 (3G) for FCAW. The following personnel, process, test plate number and position are as follows:

SMAW 4G

- #1 Shi Xing Yu
- #2 Jiang Tai An
- #3 Wang Yu Di
- #4 Zhang Shi Gang
- #5 Xue Xi Di
- #6 Shen Yun Chua
- #7 Sun Guang Ping
- #8 Chen Qi Dong
- #9 Zhu Cheng Dong
- #10 Jiao Teng

FCAW 3G

- #54 Zhang De Xia
- #64 Yang Shi Ge
- #65 Yang Ming Li
- #53 Guo Jia Lin
- #51 Ma Ming Hu
- #61 Zhang Qiang
- #63 Wang Zhi Fen
- #17 Jiao An Lei
- #15 Li Fu Meng
- #14 Han Wei Xian
- #47 Qu Qing Shan

SMAW 3G

- #60 Dai Ming Hui
- #65 Yang Ming Li
- #66 Li Meng Qiang
- #4 Wang Xian Ming
- #10 Li Yu Chao
- #5 Xu Nai Jun
- #2 Xu Nai Shen
- #8 Li Jia Jun

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

#12 Cheng Chong Lang
#7 Hong Jiang
#1 Wang Pei
#9 Xia Zheng Guo
#6 Li Ji Tang

SMAW 3F/4F

#58 Jiao An Lei 3F/4F
#55 Zhu Xin Xiang 3F/4F
#59 Xu Xiao Dong 3F
#57 Jia Yong Qiang 3F/4F
#56 Huo Xiao Fei 3F/4F
#24 Cheng Chang Yun 4F
#26 Wang Xiao Kun 3F/4F
#27 Zhang Qian 3F/4F
#28 Tian Chao 4F
#29 Yang You Li 3F
#30 Wang Feng Jun 3F/4F
#31 Chen Bin 3F
#32 Bai Zhan Feng 3F
#34 Zhang Ming 3F/4F
#35 Guo Zhun Bin 3F
#36 Zhu Li Zhao 3F
#37 Cui Zai Shun 3F/4F
#38 Zhang Gui Bao 3F
#39 Zhu Fa Chao 3F/4F
#40 San Pang Feng 3F
#41 Tao Wei Bing 3F
#42 Zhu you Ling 3F

The Welder Qualifications were monitored by ZPMC CWI Xu Le Feng and An Qing Xiang.

ZPMC Quality Control (QC) Inspector is identified as Zhang Hai Tao. 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.

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

Inspected By:	Hernandez,Dan	Quality Assurance Inspector
----------------------	---------------	-----------------------------

Reviewed By:	Carreon,Albert	QA Reviewer
---------------------	----------------	-------------
