

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-015428**Date Inspected:** 04-Jul-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**Summary of Items Observed:**

CWI Inspector: 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:

OBG Bay 14

This QA Inspector observed ZPMC welder Ms. Wang Min, stencil 044771 was using submerged arc welding procedure WPS-B-T-2221-B-U3C-S-2 to make OBG segment 13AE bottom plate butt weld BP3033-001-004. This QA Inspector observed ZPMC QC personnel monitoring this welding and this QA Inspector measured a welding current of approximately 600 amps and 31.0 volts. Ms. Wang Min appeared to be certified to make this weld and the base material was preheated with electric heating elements. Items observed by this QA Inspector appeared to be progressing in compliance with project specifications.

This QA Inspector observed ZPMC welder Mr. Liu Yong Sheng, stencil 055483 was using shielded metal arc welding process to make tack welds on East Cable Anchorage Bearing Stiffener Plate X4742L. This QA Inspector observed a welding current of approximately 155 amps, the shielded metal arc welding electrodes are stored in a heated rod container and Mr. Liu Yong Sheng appeared to be certified to make these tack welds. Items observed on this date appeared to generally comply with applicable contract documents.

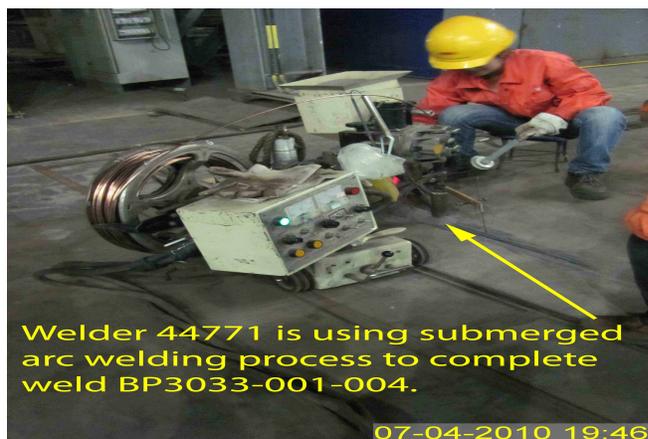
WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA Inspector observed ZPMC welder Mr. Liu Dung, stencil 046467 was using shielded metal arc procedure WPS-B-P-2112-FCM-1 to make OBG segment 13AW stiffener plate tack weld RS3435G. This QA Inspector observed Mr. Liu Dung appeared to have used a torch to preheat the base material prior to welding and Mr. Liu Dung appeared to be certified to make this weld. This QA Inspector observed a welding current of approximately 180 amps. Items observed on this date appeared to generally comply with applicable contract documents.

OBG Segment Trial Assembly

Earlier in the day there was a heavy rain and there are many puddles of water around the ground surrounding the OBG Segment Trial Assemblies. QA Inspector observed no ZPMC personnel appeared to be performing welding in the OBG Segment Trial Assembly area. Several workers were using power tools to tighten bolts on OBG segment 7DW adjacent to where cross beam 8 will be attached. This QA Inspector observed ABF have performed ultrasonic inspections of OBG segment 11DW hold back welds and several workers are grinding various welds in OBG segment 12CW.



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