

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017789**Date Inspected:** 31-Oct-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 Inspectors: ZPMC: Mr. Wang Jie, Mr. Geng Wei

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

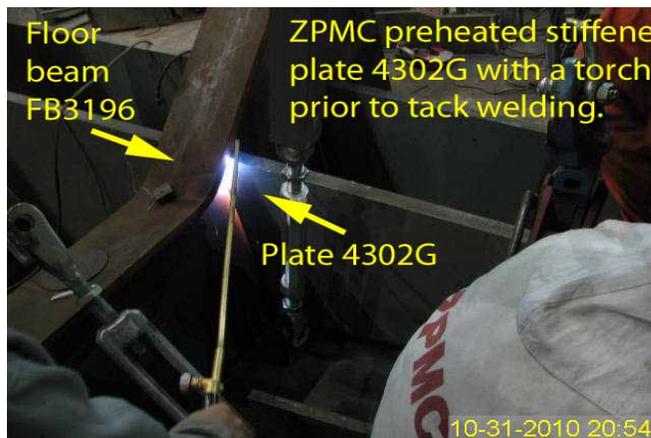
This QA Inspector observed ZPMC welder Mr. Zhuang Hua stencil 068206 used flux cored welding procedure WPS-B-P-2133 to make OBG segment 13CE weld SEG3011C-018. This weld joins stiffener plates to a floor beam. This QA Inspector observed ZPMC has recorded a welding current of 216 amps and 25 volts. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Ms. Wang Min, stencil 044771 used submerged arc welding procedure specification WPS-B-T-2221-B-L2C-S-2 to make OBG segment 14E weld SEG3019AQ-028. This weld joins anchorage plates AP3010 to AP3011. This QA Inspector measured a welding current of approximately 620 amps, 30.0 volts and Ms. Wang Min appeared to be certified to make this weld. This QA Inspector observed the base materials were preheated with electric heaters prior to welding. 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. Li Jun, stencil 051348 used shielded metal arc welding procedure WPS-B-P-2113-FCM-1 to tack weld OBG segment 13AW stiffener plate 4302G to floor beam FB3201 and FB3196 near panel point PP120. This QA Inspector observed ZPMC QC a welding current of approximately 165 amps. Mr. Li Jun appeared to be certified to make this weld and the base materials were preheated with an acetylene torch prior to welding. 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
