

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020622**Date Inspected:** 10-Feb-2011**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:** Mr. Sha Zhi**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. Sha Zhi

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. Wu Wanyong stencil 050242 used flux cored welding procedure WPS-B-T-2233-ESAB to make OBG segment 13AE weld SEG3007AX-009. This QA Inspector observed a welding current of approximately 208 amps and 24.5 volts. This QA Inspector observed that the minimum welding current listed in the welding procedure specification is 222.8 amps and that Mr. Wu Wanyong had a welding current that was approximately 12 amps below this minimum limit. ZPMC QC Inspector Mr. Xie Ming Feng observed the current meter and he informed this QA Inspector he will adjust the welding machine to a higher setting. Following adjustment of the welding machine current, items observed on this date appeared to generally comply with applicable contract documents. Mr. Wu Wanyong appeared to be certified to make his weld. Items observed on this date appeared to generally comply with applicable contract documents. See the photograph below for additional information.

This QA Inspector observed ZPMC welder Mr. Wang Li, stencil 044772 used shielded metal arc welding

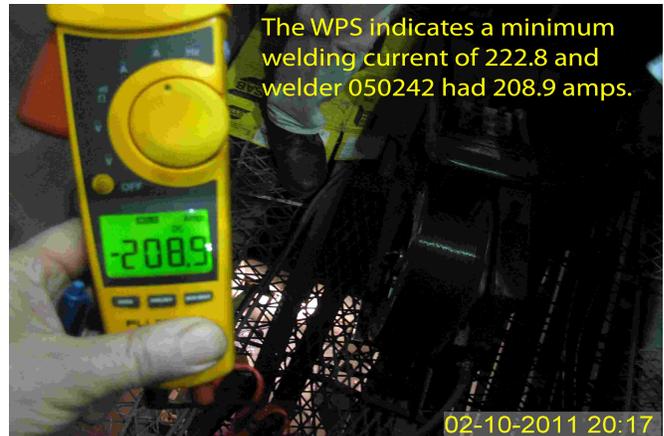
WELDING INSPECTION REPORT

(Continued Page 2 of 2)

procedure WPS-B-P-2114-FCM-1 to make OBG segment 13AE welds SEG3007V-459 and -447. This QA Inspector observed ZPMC QC Inspector Mr. Xie Ming Feng had recorded a welding current of 158 amps. This QA Inspector observed Mr. Wang Li appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents. See the photograph below for additional information.

This QA Inspector observed ZPMC welder stencil 215993 used submerged arc welding procedure specification WPS-B-T-2221-B-L2C-S-2 to complete OBG segment 14E groove weld SEG3019AP-004. This QA Inspector observed ZPMC QC Inspector Mr. Sha Zhi had recorded a welding current of 650 amps 33.4 volts and a welding travel speed of 628mm per minute. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder stencil 068924 used shielded metal arc welding procedure specification WPS-345-SMAW-1G(1F)-FCM-Repair to make OBG segment 13AE weld repair SEG3007E-192. This QA Inspector observed ZPMC QC Inspector Mr. Xie Ming Feng had recorded a welding current of 162 amps. This weld repair was the result of ultrasonic rejections and was documented on weld repair B-WR-19468. 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 James Devey +8615000026784, who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
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Reviewed By:	Riley,Ken	QA Reviewer
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