

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-021671**Date Inspected:** 06-Mar-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:** 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. Bao Qian

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

Segment 14E

This QA Inspector observed ZPMC welder Mr. Yang Yunfeng, stencil 215553 used shielded metal arc welding procedure specification WPS-B-P-2213-TC-U4B-FCM-1 to make OBG segment 14E weld SEG3019AW-100. This QA Inspector observed a welding current of approximately 185 amps, the base materials appear to have been preheated with electric heating elements and Mr. Yang Yunfeng appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Guo Taotao stencil 050969 used shielded metal arc welding procedure specification WPS-B-P-2213-TC-U4B-FCM-1 to make OBG segment 14E weld SEG3019AW-100. This QA Inspector observed a welding current of approximately 185 amps, the base materials appear to have been preheated with electric heating elements and Mr. Guo Taotao appeared to be certified to make this weld. Items

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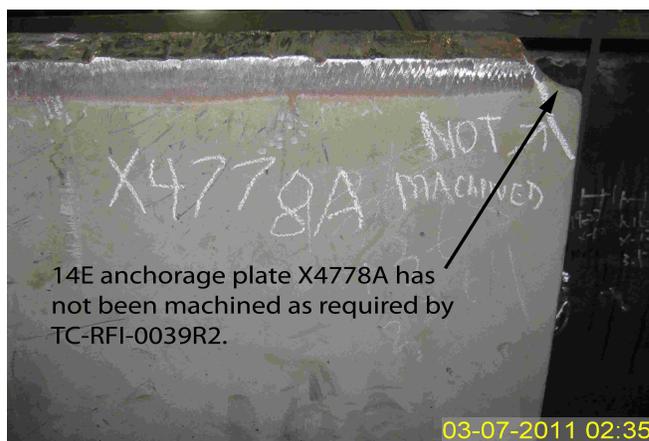
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observed on this date appeared to generally comply with applicable contract documents.

Segments 13 and 14 East and West

This QA Inspector performed random document review of “Team China request for information (TC-RFI)” document #TC-RFI-0039R0. This RFI addresses various cope holes in OBG 13E and near panel point 119. This QA Inspector performed random visual inspections of the cope holes listed in the RFI and the results of this inspection have been submitted for engineering evaluation. This QA Inspector took random photographs of these plates and copies of the photographs and other related information have been placed in “TC-RFI Documentation” folder located on Team China common Z drive.

This QA Inspector performed random document review of “Team China request for information (TC-RFI)” document #TC-RFI-0039R2. This RFI addresses OBG 14E and 14W anchorage vertical extension plates where ZPMC had cut copes at the wrong locations. This QA Inspector performed random visual inspections of segment 13E plates X4771A, X4774A, X4777A and X4778A and observed ZPMC appears to have not performed machining of these plates as specified by the RFI and the cope holes appear to comply with the RFI. This QA Inspector performed random visual inspections of segment 14W plates X5059A, X5056A and X5066A and observed ZPMC appears to have completed machining of these plates as specified by the RFI and the cope holes appear to comply with the RFI. This QA Inspector took random photographs of these plates and copies of the photographs have been placed in “TC-RFI Documentation” folder located on Team China common Z drive. See the photographs below for additional information.



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.

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