

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-005268**Date Inspected:** 08-Jan-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Fuyou Shen**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 Fabrication**Summary of Items Observed:**

Caltrans 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. The QA Inspector observed the following:

OBG Bay 14, North End (outside)

This QA Inspector observed ZPMC welder Mr. Lu Fenbao, stencil 045175, and Ms. He Jun Rong, stencil 201215, performing Flux Core Arc Buttering Welds on steel plate bevel faces that had been previously been welded as part of OBG segment 5AW lifting attachment. The QA Inspector asked ZPMC QC Representative Mr. Lay Tau how much thickness of steel is being added to the weld bevels by these buttering welds. Mr. Tau said ZPMC is intending to add a thickness of approximately 10 mm to the weld bevel faces. The QA Inspector asked Mr. Tau if ZPMC has obtained engineering approval to perform buttering welds on these pieces of steel. Mr. Tau said ZPMC has not submitted or received Engineering approval but ZPMC intends to submit a request to Caltrans Engineering later today. A short time later American Bridge/Flour (ABF) representative Mr. Peter Shaw arrived and after he evaluated these buttering welds Mr. Shaw informed Mr. Tau and ZPMC supervision that due to the importance of these lifting points that ZPMC needs to use new plates for the replacement of the lifting attachment points. Mr. Shaw said these plates had been removed from the OBG segment due to these plates having been originally welded using an incorrect weld bevel.

This QA Inspector observed ZPMC welder Mr. Chen Hongjun, stencil 067609 is using shielded metal arc welding

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procedure WPS-345-SMAW-4G(4F)-FCM-Repair to make weld repairs on OBG segment 5AW weld 021A-001. Prior to welding the QA Inspector observed the base material was preheated using a torch. Items observed by this QA Inspector appear to be progressing in compliance with project specifications.

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, 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
