

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-006096**Date Inspected:** 12-Mar-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:** 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:** Tower Fabrication**Summary of Items Observed:**

CWI Inspectors Mr. Wu Ming Kai, Mr. Chen Shou hua

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. The QA Inspector observed the following:

Tower Bay 10

This QA Inspector performed random ultrasonic inspections of approximately 10 percent length of North Tower Lift 1 Skin splice plate stiffener to skin plate D welds NSD1-SA105-1, NSD1-SA105-2, and NSD1-SA105-3. These welds had previously been ultrasonically inspected and accepted by ZPMC inspection personnel. The QA Inspector observed the welds that were ultrasonically inspected by this QA Inspector appear to comply with AWS D1.5 UT requirements. For additional information on this inspection see the TL6027 Ultrasonic Test Report.

The QA Inspector observed ZPMC welder Ms. Zhang Suqin stencil 209051 is using welding procedure specification WPS-B-T-2221-B-S2 to make submerged arc groove weld SSD1-FDSA-1A/D-5A. The QA Inspector observed ZPMC Quality Control personnel monitoring this welding and the QA Inspector observed ZPMC Quality Control personnel measuring a welding current of approximately 655 amps, 30.90 volts and a weldin traveling speed of 545 mm per minute. Items observed by the QA Inspector appear to comply with project specifications.

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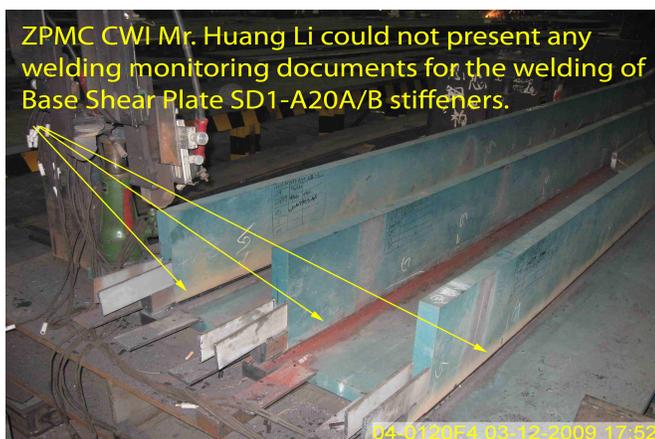
The QA Inspector observed ZPMC welder Ms. Xu Zhen stencil 051413 is using welding procedure specification WPS-B-T-2221-B-S2 to make submerged arc groove weld SSD1-FDSA-1A/D-8A. The QA Inspector observed ZPMC Quality Control personnel monitoring this welding and the QA Inspector observed ZPMC Quality Control personnel measuring Ms. Liu Xiaoyan having a welding current of approximately 652 amps and 30.7 volts. Items observed by the QA Inspector appear to comply with project specifications.

This QA Inspector observed ZPMC welder Mr. Bu Xuezheng, stencil 052075 is the using flux cored welding process to make complete joint penetration skin plate repairs to tower skin plate weld NSD1-FDSA3-1A/C-5A. The QA Inspector observed ZPMC Mr Chen Shou hua monitoring this welding and that the base material appears to have been preheated using an electrical heater element. Items observed by this QA Inspector appear to be progressing in compliance with project specifications.

This QA Inspector performed random ultrasonic inspections of approximately 10 percent length of South Tower Lift 3 Skin splice plate C butt weld SSD1-FCSA3-1B/C-4. This weld had previously been ultrasonically inspected and accepted by ZPMC inspection personnel. The QA Inspector observed the weld that was ultrasonically inspected by this QA Inspector appears to comply with AWS D1.5 UT requirements. For additional information on this inspection see the TL6027 Ultrasonic Test Report and the photograph below.

Tower Bay 11

This QA Inspector performed random ultrasonic inspections of approximately 10 percent length of West Tower Lift 2 Skin plate stiffener to skin plate C weld WSD1-SA388 A/D-10, WSD1-SA388 A/D-11, WSD1-SA388 A/D-12, WSD1-SA388 A/D-13 and WSD1-SA388 A/D-14. These welds had previously been ultrasonically inspected and accepted by ZPMC inspection personnel. The QA Inspector observed the welds that was ultrasonically inspected by this QA Inspector appear to comply with AWS D1.5 UT requirements. For additional information on this inspection see the TL6027 Ultrasonic Test Report.



Summary of Conversations:

See above.

Comments

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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 Serge Sinevod phone: 134-8257-0045 , who represents the Office of Structural Materials for your project.

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