

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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006099**Date Inspected:** 15-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 Inspector Mr. Yin Yong Liang

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 Lift 3 West tower skin plate B complete joint penetration butt welds NSD1-FCSA3-1B/C-5 and NSD1-FCSA3-1B/C-8. 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.

This QA Inspector performed random ultrasonic inspections of approximately 10 percent length of Lift 3 West tower skin plate B complete joint penetration butt welds NSD1-FCSA3-1B/C-5 and NSD1-FCSA3-1B/C-8. 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.

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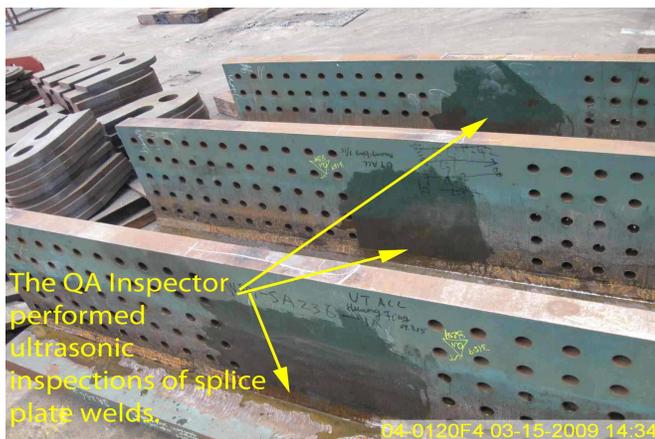
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The QA Inspector observed ZPMC welder Ms. Zhang Lingling stencil 207746 is using welding procedure specification WPS-B-T-2221-B-U3-C-S-2 to make submerged arc groove weld NSDA-FCSA3-1B/C-9A. The QA Inspector observed ZPMC Quality Control CWI M. Yin Yaon Liang measuring a welding current of 616 amps, 30.7 volts and a weldin speed of 492 millimeters per minute. The QA Inspector observed that the base material appears to be between 110°C and 230°C. Items observed by the QA Inspector appear to comply with project specifications.

This QA Inspector performed random ultrasonic inspections of approximately 10 percent length of South Tower Lift 3 Skin B stiffener to skin plate weld SSD1-FBSA3-1A/C-21. Thid weld had previously been ultrasonically inspected and accepted by ZPMC inspection personnel. The QA Inspector observed the weld that wase 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.

Tower Bay 11

This QA Inspector performed random ultrasonic inspections of approximately 10 percent length of Lift 1 South Skin Interior Splice Plate welds WSD1-SA097-1, WSD1-SA218-1, WSD1-SA218-2, WSD1-SA218-3, WSD1-SA218-4, WSD1-SA236-1, WSD1-SA236-2, WSD1-SA236-3, WSD1-SA103-4 and WSD1-SA103-5. These welds had previously been ultrasonically inspected and accepted by ZPMC inspection personnel. ZPMC ultrasonic inspectors have rejected the remaining welds on these Lift 1 South Skin Interior Connection Splice plates. 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 and the photograph below.



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

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