

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-006108**Date Inspected:** 27-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:** OBG Fabrication**Summary of Items Observed:**

CWI Inspector: Mr. Zhu Zhong Hai

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:

OBG Bay 19

This QA Inspector performed random ultrasonic inspections of approximately 10 percent length of Bikepath welds BK004A-003-009, BK004A-005-009 and BK004A-006-009. 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 Crossbeam welds CB205C-001-005, CB205C-001-006, CB205C-001-007, CB205C-001-008. 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 and the photograph below.

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The QA Inspector asked ZPMC CWI Mr. Zhu Zhong Hai if ZPMC QC has recorded the welding parameters for the workers that are welding Bikepath box panel components. Mr. Zhu Zhong Hai said his supervisor has instructed him to not show Caltrans QA Inspectors any QC welding documents. Mr. Zhu Zhong Hai later said he will show the QC Inspector his welding documents after lunch.

The QA Inspector observed ZPMC welder Mr. Xu Aihua, stencil 062816 is using submerged arc welding procedure specification WPS-B-F2221-B-L2C-S-2 to make bikepath groove butt weld BP025-005-002. The QA Inspector observed ZPMC Quality Control personnel measuring Mr. Xu Aihua having a welding current of approximately 610 amps and 32.5 volts. Items observed by the QA Inspector appear to comply with project specifications.

The QA Inspector observed ZPMC welder Mr. Chen Zhoushan, stencil 062750 is using flux cored welding procedure specification WPS-B-T-2132-3 to make bikepath stiffener to baseplate fillet weld BK004A3-003-043. The QA Inspector observed the base material had been preheated with a torch and the QA Inspector measured Mr. Chen Zhoushan having a welding current of approximately 290 amps and 27.4 volts. Items observed by the QA Inspector appear to comply with project specifications.

The QA Inspector observed ZPMC welder Mr. Wang Yong, stencil 062807 is using flux cored welding procedure specification WPS-B-T-2132-3 to make bikepath stiffener to baseplate fillet weld BK004A3-003-024. The QA Inspector observed the base material had been preheated with a torch and the QA Inspector measured Mr. Wang Yong having a welding current of approximately 310 amps and 30.3 volts. Items observed by the QA Inspector appear to comply with project specifications.

The QA Inspector observed ZPMC welder Mr. Li Xiangzheng, stencil 0259462 is using welding procedure WPS-B-T-2132-3 to make a shielded metal fillet tack weld on stiffener to bikepath weld BK004A3-002-045. The QA Inspector measured a welding current of approximately 145 amps. QA Inspector observed the base material had been preheated with a torch. Items observed by the QA Inspector appear to comply with project specifications.



Summary of Conversations:

See above.

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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 phone: 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
