

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-007119**Date Inspected:** 12-May-2009**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 Fabrication**Summary of Items Observed:**

CWI Inspectors: Mr. Wu Zhichen

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:

Prior to Caltrans QA Inspectors' concurring with issuance of OBG deck plate closed rib green tag releases a review of the ultrasonic inspection database is performed to verify all closed rib tack weld repair locations have been ultrasonically accepted. Today this QA Inspector, Mr. Paul Dawson, performed data entry of ultrasonic inspection information from the field generated Ultrasonic inspection data sheets onto the common drive computer database for the following OBG deck panels: DP366-001, DP538-001, DP447-001, DP097-001, DP098-001, DP123-001, DP124-002, DP126-001, DP126-002, DP150-001, DP153-001, DP178-001, DP180-001, DP232-001, DP123-002, DP234-001 and DP287-001.

OBG Assembly Area

ZPMC issued an "Inspection Notification Sheet" #3041 requesting QA to perform ultrasonic inspections and to green tag OBG 3AE and 3BD welds SEG014-044, SEG014A-027, CA002-001, CA002-002, CA006-001, CA006-002, CA004-005 and CA004-006. These welds had previously been ultrasonically inspected and accepted by ZPMC inspection personnel. This QA Inspector performed random ultrasonic inspections of these welds and

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

items observed by this QA Inspector appear to comply with AWS D1.5 UT requirements. For additional information on these inspections see the TL6027 Ultrasonic Test Report.

The QA Inspector observed ZPMC welder Mr. Li Guimin, stencil 220069 is using flux cored welding process WPS-B-T-2233-T to make groove weld CB2A-3 between OBG segment 2AE and 2BE. The QA Inspector observed a welding current of approximately 280 amps, 30 volts and a ZPMC QC Inspector is monitoring the welding and preheating of the base material. Items observed by the QA Inspector appear to comply with project specifications.

The QA Inspector observed ZPMC welder Mr. Li Shuliang, stencil 202841 is using flux cored welding process WPS-B-T-2233-T to make groove weld CB2A-2 between OBG segment 2AE and 2BE. The QA Inspector observed a welding current of approximately 255 amps, 31 volts and a ZPMC QC Inspector is monitoring the welding and preheating of the base material. Items observed by the QA Inspector appear to comply with project specifications.

The QA Inspector observed ZPMC welder Mr. Lu Yung Yuan, stencil 202811 is using flux cored welding process WPS-B-T-2233-T to make groove weld CB2A-2 between OBG segment 2AE and 2BE. The QA Inspector observed a welding current of approximately 230 amps, 26.5 volts and a ZPMC QC Inspector is monitoring the welding and preheating of the base material. Items observed by the QA Inspector appear to comply 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 phone: 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By: Dawson,Paul

Quality Assurance Inspector

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Reviewed By: Clifford, William

QA Reviewer