

**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-007223**Date Inspected:** 24-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 and Tower Fabrication**Summary of Items Observed:**

CWI Inspectors: Mr. Shen Fu You, Mr. Li Ming

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 14**

The QA Inspector observed ZPMC welder Mr. Wu Zhengguo, stencil 044737 is using welding procedure specification WPS-B-T-2211-B-U2-FCM-1 to deposit shielded metal arc weld between side plate SP352A and SP379A (10CE). The QA Inspector observed that a ZPMC QC Inspector is monitoring this welding. The QA Inspector measured a welding current of approximately 170 amps and the welding electrodes are being stored in a heated container. Items observed by this QA Inspector appear to be progressing in compliance with project specifications.

The QA Inspector observed ZPMC welder Ms. Wang Chaili stencil 045203 had been using flux cored welding process WPS-B-T-2231-B-U2 to make groove weld SEG063A-001 between side plate SP112A and SP139. The QA Inspector observed Ms. Chaili is qualified to make this weld and CWI Mr. Sheng Fu you said Ms. Chaili is going on a break and will be welding later. Items observed by the QA Inspector appear to comply with project specifications.

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## WELDING INSPECTION REPORT

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The QA Inspector observed ZPMC welder Mr. Tian Zhaoquan, stencil 045246 is using the shielded metal arc welding process to make a groove weld between EP30B and DP513A. The QA Inspector observed a welding current of approximately 170 amps, the base material where the tack welding is being made had been preheated with a torch. Items observed on this date appeared to generally comply with applicable contract documents.

The QA Inspector observed ZPMC welder Mr. Zang Yanbo, stencil 045196 is using shielded metal arc welding procedure WPS-B-P-4213-TC-U4B to deposit shielded metal arc weld repair of longitudinal diaphragm weld 2AW4-PP41. The QA Inspector observed a welding current of approximately 160 amps, the base material where the tack welding is being made had been preheated with a torch. The QA Inspector observed the welding electrode storage container that is being used by Mr. Yanbo oven is not connected to an electrical power supply but that the welding electrodes inside the storage container appear to be warm. The QA Inspector informed ZPMC CWI Mr. Shen Fu You who instructed Mr. Yanbo to keep the electrodes hot by connecting the electrical wires to a power source. Items observed on this date do not appear to fully comply with applicable contract documents.

### **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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<b>Inspected By:</b>	Dawson,Paul	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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