

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-007236**Date Inspected:** 27-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 Inspector: Mr. Liu Fu Wen

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

This QA Inspector observed ZPMC welder Ms. Wang Lanying, stencil 45265 is using welding procedure specification WPS-B-T-2221-B-3C-2-S to make submerged arc groove weld Segment 055-003. The QA Inspector observed ZPMC Quality Control personnel monitoring this welding and this QA Inspector measured a welding current of approximately 580 amps and 29.6 volts. The QA Inspector observed QC has recorded a travel speed of 470 mm per minute. Items observed by this QA Inspector appear to be progressing in compliance with project specifications.

The QA Inspector observed ZPMC welder Mr. Li Jun, stencil 051348 is using the shielded metal arc welding procedure WPSB-P-2214-C-U4b to make weld SEG027-048. The QA Inspector asked ZPMC QC Inspector Mr. Lin Rudan what welding current he has measured for Mr. Li Jun and Mr. Lin Rudan obtained his amperage measurement gauge and after he had measured Mr. Li Jun's welding current Mr. Li Rudan said he has measured Mr. Li Jun to have a welding current of 200 amps. The QA Inspector informed Mr. Li Rudan that this QA

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Inspector has measured Mr. Li Jun to have a welding current of 180 amps. Mr. Li Rudan measured Mr. Li Jun's welding current a second time and he agreed the welding current is approximately 180 amps. Items observed by this QA Inspector appear to be progressing in compliance with project specifications.

The QA Inspector observed ZPMC welder Mr. Wang Jinjiu, stencil 043661 is using the shielded metal arc welding procedure WPSB-P-2214-C-U4b to make a weld on deck plate DP657A. The QA Inspector measured a welding current of 180 amps. Items observed by this QA Inspector appear to be progressing in compliance with project specifications.

This QA Inspector observed ZPMC welder Ms. Zou Dianqin, stencil 250050 had recently used welding procedure specification WPS-B-T-2221-B-L2C-2-S to make submerged arc groove weld Segment 063A-003. The QA Inspector observed ZPMC Quality Control personnel had recorded a welding current of 672 amps, 31.2 volts and a welding travel speed of 568 mm per minute. Items observed by this QA Inspector appear to be progressing in compliance with project specifications.

Tower Bay 10

At around 0430 hours the QA Inspector observed a ZPMC worker performing heat straightening of north tower, lift 3, skin plate A. At that time no ZPMC QC personnel appear to be working in tower Bay 10 and as soon as the ZPMC worker observed this QA Inspector in the area, the ZPMC worker shut off his torch and walked away from where he had been performing the heat straightening of north tower, lift 3, skin plate A. The QA Inspector went to Tower bay 11 where ABF representative Mr. Wang Cheng Jun was monitoring welding activities. Mr. Wang Cheng Jun said he was not responsible for any work in Tower Bay 10 but he is will speak Chinese and inform the worker that ZPMC QC Inspectors must monitor all heat straightening, and that the worker should not perform any additional heat straightening this shift. This QA Inspector did not observe any ZPMC CWI in Bay 10.

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
Reviewed By:	Clifford,William	QA Reviewer
