

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-007627**Date Inspected:** 23-Jun-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. Chen Yongxin, Mr. Xu Xian Ping

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. This 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: DP102-001, DP128-001, DP128-002, DP156-001, DP181-001, DP182-001, DP262-001, DP264-001, DP290-001, DP318-001, DP371-001, DP397-001 and DP425-001.

OBG Bay 14

This QA Inspector observed ZPMC welder Ms. Lu Shi Qin, stencil 044755 using submerged arc welding procedure specification WPS-B-T-2221-C-U2B-S to make groove weld SEG047*-006. This QA Inspector observed Quality Control personnel monitoring the base material temperature and other welding attributes. This QA Inspector measured a welding current of approximately 600 amps, 30.0 volts and a welding travel speed of 490 mm per minute. Items observed on this date appear to generally comply with applicable contract documents.

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This QA Inspector observed ZPMC welder Ms. He Jun Rong, stencil 201215 is using flux cored welding procedure WPS-B-T-2233-TC-U4b-F to make OBG weld SEG031-027. This QA Inspector observed that the welding is taking place on an elevated scaffold and that ZPMC QC Inspector Mr. Liu Wan Ning has recorded a welding current of 212 amps and 25.6 volts. Items observed on this date appear to generally comply with applicable contract documents.

OBG Bay 7

This QA Inspector observed ZPMC welder Ms. Jiang Jingteng, stencil 046830 had just used submerged arc welding procedure specification WPS-B-T-2221-B-L2C-S-2 to complete groove weld BP3029A-001-056. This QA Inspector observed Quality Control personnel had recorded a welding current of 586 amps, and 31.0 volts. Items observed on this date appear to generally comply with applicable contract documents.

OBG Bay 10

This QA Inspector observed ZPMC welder Ms. Liu Xiaoyan, stencil 207745 is using welding procedure specification WPS-B-T-2221-B-3C-2-S to make submerged arc groove weld NSD1-FDSA4-3A/C-12B. This QA Inspector observed ZPMC Quality Control personnel monitoring this welding and this QA Inspector measured a welding current of approximately 580 amps and 29.5 volts. This QA Inspector observed QC has recorded a travel speed of 450 mm per minute. Items observed on this date appear to generally 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 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:	Carreon,Albert	QA Reviewer
