

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-008365**Date Inspected:** 26-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**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. Du Zhiqun, Mr. Liu Zhong An

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:

OBG Bay 10

This QA Inspector observed ZPMC welder Mr. Dong Chang Xi, stencil 070046 is using flux cored welding procedure WPS-B-T-2332-TC-P5-F to make North Tower Lift 4 Skin E stiffener to skin plate weld NSD1-FESA4-3F/F-019. The QA Inspector observed a welding current of approximately 320 amps and 31.0 volts and the base material appears to be between 110°C and 230°C. The QA Inspector observed Quality Control Certified Welding Inspector Mr. LiU Zhong An monitoring this welding. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Zhao Shanlun, stencil 066683 is using flux cored welding procedure WPS-B-T-2332-TC-P5-F to make North Tower Lift 4 Skin E stiffener to skin plate weld NSD1-FESA4-3F/F-018. The QA Inspector observed a welding current of approximately 315 amps and 32.0 volts and the base material appears to be between 110°C and 230°C. The QA Inspector observed Quality Control Certified Welding Inspector Mr. Liu Zhong An monitoring this welding. Items observed on this date appeared to

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Ms. Yu Jun, stencil 201825 is using flux cored welding procedure WPSB-T-4333-TC-P5-F to make tower weld NSD1-TL8H/L-147. The QA Inspector observed a welding current of approximately 340 amps and 30.0 volts and the base material appears to be between 110°C and 230°C. The QA Inspector observed Quality Control Certified Welding Inspector Mr. Du Zhiqun monitoring this welding. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Ms. Yu Jun, stencil 201825 is using flux cored welding procedure WPSB-T-2331-TC-P4-F-2 to make tower weld NSD1-TL8J/L-57. The QA Inspector observed a welding current of approximately 340 amps and 30.0 volts and the base material appears to be between 110°C and 230°C. The QA Inspector observed Quality Control Certified Welding Inspector Mr. Du Zhiqun monitoring this welding. Items observed on this date appeared 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 Serge Sinevod phone: 134-8257-0045 , who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
