

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-008373**Date Inspected:** 05-Aug-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. Chen Xi and Mr. Lu Li Qing

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 2

This QA Inspector observed ZPMC welder Ms. Zou Dianqin, stencil 250050 using welding procedure specification WPS-B-T-2221-B-L2C-2-S to make floor beam submerged arc groove weld FB3096-001-019. The QA Inspector observed a welding current of approximately 590 amps and 30.0 volts. This QA Inspector observed Ms. Zou Dianqin is qualified to make this weld. Items observed by this QA Inspector appear to be progressing in compliance with project specifications.

OBG Bay 3

This QA Inspector observed ZPMC welder Mr. Wang Changfa, stencil 058102 has recently used shielded metal arc process WPS-B-T-2133 to make shielded metal arc welds in the 3G (vertical) position on floor beam FB205-028-042. The QA Inspector observed ZPMC QC Inspector Mr. Zhang Yaxu has recorded a welding current of 150 amps. This QA Inspector observed Mr. Wang Changfa is qualified to make this weld and that the

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welding electrodes are being stored in a portable heated electrode storage container. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Yang Xhue, stencil 057795 has recently used shielded metal arc process WPS-B-T-2133 to make shielded metal arc welds on floor beam FB019-009-065. The QA Inspector observed ZPMC QC Inspector Mr. Zhang Yaxu has recorded a welding current of 150 amps. This QA Inspector observed Mr. Yang Xhue is qualified to make this weld and that the welding electrodes are being stored in a portable heated electrode storage container. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Ms. Zhang Caimei stencil 207237, is using submerged arc welding procedure WPS-B-T-2231-L2C-S-2 to make Floor Beam groove weld FB3013-003-017. This QA Inspector observed that Ms. Caimei is qualified to make this weld. This QA Inspector measured a welding current of approximately 500 amps and 30.5 volts. Items observed on this date appeared to generally comply with applicable contract documents.

Tower Bay 10

This QA Inspector observed ZPMC welder Mr. Wang Rujia, stencil 066882 is using flux cored process WPS-B-T-4332-1 to make flux cored welds on east tower lift 4 weld ESD1-FDSA4-2C/D-55. The QA Inspector measured a welding current of approximately 310 amps and 31.2 volts. This QA Inspector observed the base material has been preheated with an electric heating element prior to welding. This QA Inspector observed Mr. Wang Rujia is qualified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Yang Hungian, stencil 070254 is using flux cored process WPS-B-T-4332-1 to make flux cored welds on east tower lift 4 weld ESD1-FDSA4-2C/D-48. The QA Inspector measured a welding current of approximately 300 amps and 31.0 volts. This QA Inspector observed the base material has been preheated with an electric heating element prior to welding. This QA Inspector observed Mr. Yang Hungian is qualified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Li Liang, stencil 070212 is using flux cored process WPS-B-T-4332-1 to make flux cored welds on east tower lift 4 weld ESD1-FDSA4-2C/D-48. The QA Inspector measured a welding current of approximately 300 amps and 31.8 volts. This QA Inspector observed the base material has been preheated with an electric heating element prior to welding. This QA Inspector observed Mr. Li Liang is qualified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Liu Fuquan, stencil 070140 is using flux cored process WPS-B-T-4332-1 to make flux cored welds on east tower lift 4 weld ESD1-FDSA4-2C/D-07. The QA Inspector observed ZPMC Quality Control CWI Mr. Du Zhi Qun measured a welding current of approximately 310 amps and 30.5 volts. This QA Inspector observed the base material has been preheated with an electric heating element prior to welding. This QA Inspector observed Mr. Liu Fuquan is qualified to make this weld. Items observed on

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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
