

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-008814**Date Inspected:** 28-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 715**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 Fabrication**Summary of Items Observed:**

CWI Inspectors: Mr. Lv. Li Qing, Mr. Li Yang

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 5

The QA Inspector observed ZPMC welder Ms. Ban Qiuyon, stencil 250353 using submerged arc welding procedure specification WPS-B-T-2221-B-L2C-S-2 to make groove weld CB202F-016-001. The QA Inspector confirmed that Mr. Ban Qiuyon is certified to make this weld. This QA Inspector measured a welding current of 560 amps and 33.3 volts. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Wang Guangdong, stencil 215009 is using welding procedure specification WPS-B-T-2132-3 to make flux cored weld CB205B-015-050. The QA Inspector observed ZPMC Quality Control personnel monitoring the welding attributes. This QA Inspector measured a welding current of approximately 300 amps and 30.5 volts and Mr. Wang Guangdong is certified to make this weld. Items observed by this QA Inspector appear to be progressing in compliance with project specifications.

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OBG Bay 14

The QA Inspector observed ZPMC welder Mr. He Han Bi, stencil 202122 is using the flux cored process welding procedure WPS-B-P-2113 to make OBG corner assembly weld CA571-004. This QA Inspector observed a welding current of approximately 310 amps, 32.0 volts and Mr. He Han Bi is certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

The QA Inspector observed ZPMC welder Mr. Li Jiao, stencil 049861 is using the shielded metal arc welding procedure WPS-B-P-2113 to make OBG diaphragm to rib weld DP451-001. This QA Inspector observed a welding current of approximately 150 amps and Mr. Li Jiao is certified to make this weld. This QA Inspector observed the shielded metal arc welding electrodes are being stored in an electrically heated electrode storage container which is warm to the touch and it appears to be connected to the welding power supply cable. 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 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
