

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-009030**Date Inspected:** 05-Sep-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 Fabrication**Summary of Items Observed:**

CWI Inspectors: Mr. Zhu Zhong Hai, Mr. Sun Bo

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 Mr. Guo Lujun, stencil 207540 is using the shielded metal tack weld specification WPS-B-P-2112 to make OBG tack weld SEG053*-003. This QA Inspector observed Mr. Guo Lujun is certified to make this weld and this QA Inspector measured a welding current of approximately 160 amps. 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. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Xu Zichuan, stencil 205090 is using the shielded metal tack weld specification WPS-B-P-2112 to make OBG tack weld SEG055*-004. This QA Inspector observed Mr. Xu Zichuan is certified to make this weld and this QA Inspector measured a welding current of approximately 160 amps. 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. Items observed on this date appeared to generally

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comply with applicable contract documents.

This QA Inspector observed ZPMC welder Ms. Ma Ying stencil 045270, is using welding procedure specification WPS-B-T-2221-B-L2C-S-2 to make submerged arc groove weld SEG053*-006. This QA Inspector observed ZPMC Quality Control personnel monitoring this welding and this QA Inspector observed a welding current of approximately 530 amps and 33.0 volts and Ms. Ma Ying is certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

OBG Bay 14

This QA Inspector observed ZPMC welder Mr. Zhi Wu, stencil 214945 is using flux cored welding procedure WPS-B-T-2233-TC-U4b-F to make weld SEG060C-012 at panel point 86 between floor beam FB012-031 and a longitudinal diaphragm. The QA Inspector observed a welding current of approximately 210 amps and 29.0 volts and ZPMC QC Inspector Mr. Zhong Guo Hui is monitoring this welding. This QA Inspector observed that Mr. Zhi Wu is certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Zhang Quin Quan, stencil 044774 is using flux cored welding procedure WPS-B-T-2233-TC-U4b-F to make weld SEG052a-015 at panel point 75. The QA Inspector observed a welding current of approximately 250 amps and 26.0 volts and ZPMC QC Inspector Mr. Zhong Guo Hui is monitoring this welding. This QA Inspector observed that Mr. Zhang Quin Quan is certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Ms. Zou Dianqin, stencil 250050 using welding procedure specification WPS-B-T-2211-B-L2C-S-2 to make floor beam submerged arc groove weld SEG057*-009. The QA Inspector observed a welding current of approximately 630 amps and 30.0 volts. This QA Inspector confirmed that Ms. Zou Dianqin is certified to make this weld. Items observed by this QA Inspector appear to be progressing in compliance with project specifications.

This QA Inspector observed ZPMC welder Ms. Gao Min, stencil 050988 is using welding procedure specification WPS-B-T-2233-B-U2-F to make flux cored welds between deck plate DP343-001 closed ribs and a diaphragm plate in the 3F position. This QA Inspector observed Ms. Gao Min is certified to make this weld. This QA Inspector observed a welding current of approximately 220 amps and 24.8 volts. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Yan Shitan, stencil 062708 is using flux cored welding procedure WPS-B-T-2232-TC-U4b-F to make corner assembly weld CA74-001. This QA Inspector observed a welding current of approximately 285 amps and 30.8 volts. This QA Inspector observed Mr. Yan Shitan is certified to make this weld. 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

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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
