

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-009038**Date Inspected:** 15-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. Li Yang, Mr. Li Zhi Jiang, Mr. Shen Fu You, Mr. Lv. 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 Mr. Li Yuanzheng, stencil 217185, is using welding procedure WPS-B-T-2231-B-U2-F to make OBG groove weld 11TR-028-1. This QA Inspector observed a welding current of approximately 320 amps 30.6 volts and Mr. Li Yuanzheng 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. Gao Yulin, stencil 217805 is using flux cored welding process WPS-B-T-2133-B-U2-F to make flux cored groove weld TR10C-004-003. The QA Inspector measured a welding current of approximately 300 amps and 27 volts. QA Inspector observed the weld groove appears to be clean and the root gap and groove angles appear to comply with the welding procedure. This QA Inspector observed Ms. Gao Yulin is certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

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OBG Bay 5

This QA Inspector observed ZPMC welder Mr. Si Gao Feng, stencil 204342, is using welding procedure WPS-B-T-2231-TC-U4B-F-1 to make cantilever beam groove weld BK001-029-008. This QA Inspector observed a welding current of approximately 290 amps 30.0 volts and Mr. Si Gao Feng is certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

OBG Bay 13 (Front)

This QA Inspector observed ZPMC welder Mr. Li Shuliang, stencil 048801 is using welding procedure WPS-345-FCAW-2G(2F)Repair-1 to make flux cored fillet weld repair SSD10-PP62-003 in accordance with critical weld repair B-WR7460. This QA Inspector observed a welding current of approximately 290 amps and 29.0 volts. This QA Inspector observed ZPMC QC inspector Mr. Zhang Xian Ji monitoring this welding. Items observed on this date appeared to generally comply with applicable contract documents.

OBG Bay 14

This QA Inspector observed ZPMC welder Mr. Dan Deyin, stencil 044795 has used welding procedure WPS-B-P-2231-TC-U4C-F to make flux cored weld SSD16-PP80. This QA Inspector observed that ZPMC QC Inspector Mr. Zhang Xian Ji has recorded a welding current of 312 amps and 30.8 volts. This QA Inspector observed that Mr. Dan Deyin 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. Xu Liguang, stencil 200114 has used welding procedure WPS-B-P-2213-B-U2 to make shielded metal arc weld SEG052*-022. This QA Inspector observed that ZPMC QC Inspector Mr. Zhang Xian Ji has recorded a welding current of 150 amps. This QA Inspector observed that Mr. Xu Liguang 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. Wang Lanying, stencil 045265 has used submerged arc welding procedure specification WPS-B-T-2221-B-L2C-S-2 to make groove weld SEG016*-002. This QA Inspector observed Quality Control Inspector Mr. Zhang Xian Ji has recorded a welding current of 587 amps and 31.2 volts. 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

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Reviewed By: Carreon,Albert

QA Reviewer