

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-009864**Date Inspected:** 02-Oct-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:** Tower / OBG Fabrication**Summary of Items Observed:**

CWI Inspectors: Mr. Li Ming, Mr. Fu Jun

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

ZPMC issued "Inspection Notification Sheet" number 4337 informing QA that ZPMC has completed ultrasonic inspections of OBG bikeway cantilever beam welds BK001-019-001~004, -046; BK001-020-001~004, -046; BK001-021-001~004, -046; BK001-022-001~004, -046; BK001-023-001~004, -046 and BK001-024-001~004, -046. This QA Inspector observed ZPMC QC personnel had previously marked these welds as being ultrasonically accepted. This QA Inspector performed ultrasonic inspections of approximately 15 percent length of the areas that ZPMC has ultrasonically inspected and items observed by this QA Inspector appear to comply with AWS D1.5 UT requirements. For additional information on these inspections see the TL6027 Ultrasonic Test Report.

OBG BAY 9

This QA Inspector performed random magnetic particle inspections of approximately 20 percent of the tack welds

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that attach closed ribs to deck panels DP3057-001 and DP3027-001. These two deck panels are clamped to the convex shaped welding platforms that are adjacent to overhead welding gantry #2. Earlier in this shift ZPMC conducted a "Production Monitoring Test" using gantry #2 and if the testing results are satisfactory these two closed ribs are scheduled to be welded during the dayshift. These deck panel tack welds appear to have been previously MT inspected by ZPMC personnel and several of the welds appear to have been ground to eliminate MT indications which had been marked by ZPMC MT Inspectors. This QA Inspector did not observe any locations where the deck panel tack welds had been marked by the ZPMC Inspectors as being MT acceptable. The tack welds that were MT inspected by this QA Inspector appear to comply with AWS D1.5 magnetic particle inspection requirements. This inspection was performed on an informational basis and no TL6028 Magnetic Particle Test Report is being generated.

Tower Bay 10

This QA Inspector observed ZPMC welder Mr. Ni Xiuba, stencil 040533 is using flux cored welding process WPS-B-T-2231-TC-U5-F to complete tower splice plate weld NSD1-SPSA3-56-3B. This QA Inspector observed ZPMC CWI Mr. Li Ming monitoring this welding and he has previously recorded Mr. Ni Xiuba to have a welding current of 318 amps and 32.0 volts. This QA Inspector observed Mr. Ni Xiuba has a welding current of approximately 300 amps, 32.0 volts and the base material appears to have been preheated using electric heating elements. 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
