

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-009885**Date Inspected:** 09-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:** OBG Fabrication**Summary of Items Observed:**

CWI Inspectors: Mr. Guy Yan Fei, Mr. Li Yang, Mr. Lu Li Qin

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

This QA Inspector observed ZPMC welder Mr. Li Yuanzheng, stencil 217185, is using flux cored welding procedure WPS-B-T-2231-TC-U4c-F to make bikepath cantilever beam weld BK001-038-001. This QA Inspector observed a welding current of approximately 340 amps and 28.0 volts. This QA Inspector observed Mr. Li Yuanzheng is certified to make this weld and that ZPMC QC Inspector Mr. Wang Liang has recorded a welding current of 323 amps and 31.2 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 flux cored welding procedure WPS-B-T-2231-TC-U4b-F to make bikepath cantilever beam weld BK001-040-001. This QA Inspector observed a welding current of approximately 300 amps and 31.0 volts. This QA Inspector observed Mr. Wang Guangdong is certified to make this weld and that ZPMC QC Inspector Mr. Wang Liang has recorded a welding current of 309 amps and 30.5 volts. Items observed on this date appeared to generally comply with applicable

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

contract documents.

This QA Inspector observed ZPMC welder Ms. Song Aiyong, stencil 215689 is using flux cored welding process WPS-B-T-2131-B-U2-F to make traveler rail groove welds TR15-008-001 and 11RT1-028-001. The QA Inspector observed a welding current of approximately 308 amps and 30.8 volts. This QA Inspector observed Ms. Song Aiyong is certified to make this weld and that ZPMC QC personnel are monitoring this welding. Items observed on this date appeared to generally comply with applicable contract documents.

OBG BAY 9

This QA Inspector observed ZPMC welder Mr. Tang Ke, stencil 062305 is using Gas Metal Arc Welding (GMAW) procedure WPS-B-T-2342-U5(U-rib) to tack closed ribs to deck plate DP3025-001. This QA Inspector measured a welding current of approximately 345 amps and 24.0 volts. This QA Inspector observed Mr. Tang Ke is certified to make this weld and that ZPMC QC/CWI Mr. Guy Yan Fei is monitoring this welding. Items observed on this date appeared to generally comply with applicable contract documents.

OBG Bay 13

The QA Inspector observed ZPMC welder Ms. Huang Xinlan, stencil 044780 is using submerged arc welding procedure specification WPS-B-F-2221-B-L2C-S-2 to make OBG groove butt weld SEG065A-004 between side plate SP380A and baseplate BP132A. This QA Inspector observed ZPMC Quality Control personnel monitoring this welding and this QA Inspector measured a welding current of approximately 630 amps and 33.0 volts. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Zhao Jibo, stencil 055564 is using flux cored welding procedure WPS-B-T-2233-B-U2-F to make weld SEG066A-007. The QA Inspector observed a welding current of approximately 280 amps and 27.0 volts. This QA Inspector observed that Mr. Zhao Jibo 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. Wang Zhenbing, stencil 216086 has recently used shielded metal arc welding procedure WPS-B-P-4213-TC-U4B-2 to deposit shielded metal arc weld SEG052E-070. The QA Inspector observed ZPMC QC representative Mr. Tang Ya Jun has recorded a welding current of 173 amps. 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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Dawson,Paul	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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