

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-010525**Date Inspected:** 17-Nov-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 Inspector: Guo Peng

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 11

This QA Inspector observed ZPMC welder Ms. Li Xiaoqing, stencil 044560 using submerged arc welding procedure specification WPS-B-T-2221-C-U2B-S to make groove weld ESTL4-2B/L-61A between East Tower Lift 4 skin plate D to skin plate E. This QA Inspector observed Quality Control CWI Mr. Guo Peng monitoring the base material temperature and other welding attributes. This QA Inspector measured a welding current of 660 amps and 32.5 volts. Items observed on this date appear to generally comply with applicable contract documents.

The QA Inspector observed ZPMC welder Ms. Shen Mei, stencil 041716 using submerged arc welding procedure specification WPS-B-T-2221-C-U2B-S to make groove weld ESTL4-2B/L-61A between East Tower Lift 4 skin plate D to skin plate E. This QA Inspector observed Quality Control CWI Mr. Guo Peng monitoring the base material temperature and other welding attributes. This QA Inspector measured a welding current of 660 amps and 32.1 volts. Items observed on this date appear to generally comply with applicable contract documents.

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The QA Inspector observed ZPMC welder Ms. Shi Fenhua, stencil 040699 using submerged arc welding procedure specification WPS-B-T-2221-C-U2B-S to make groove weld ESTL4-2B/L-61A between East Tower Lift 4 skin plate D to skin plate E. This QA Inspector observed Quality Control CWI Mr. Guo Peng monitoring the base material temperature and other welding attributes. This QA Inspector measured a welding current of 600 amps and 32.0 volts. Items observed on this date appear to generally comply with applicable contract documents.

The QA Inspector observed ZPMC welder Ms. Cao Xiauhua, stencil 056975 using submerged arc welding procedure specification WPS-B-T-2221-C-U2B-S to make groove weld ESTL4-2B/L-61A between East Tower Lift 4 skin plate D to skin plate E. This QA Inspector observed Quality Control CWI Mr. Guo Peng monitoring the base material temperature and other welding attributes. This QA Inspector measured a welding current of 680 amps and 31.7 volts. Items observed on this date appear to generally comply with applicable contract documents.

Assembly Yard

This Inspector Performed random conventional Ultrasonic inspections (UT) in conjunction with ABF UT Department for detection of planar transverse indications utilizing scanning pattern A, B, C and D (AWS D1.5 Fig 6.7) of the following: NDE request 11172009-2 item 1: OBG weld repair OBE2A-004, segment 1AE to 2BE critical weld repair B-CWR859 and NDE request 11172009-2 item 4: OBG weld repair SEG009-008 segment 2W, WP W4. Items observed on this date appear 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
