

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-010531**Date Inspected:** 22-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 and Tower**Summary of Items Observed:**

CWI Inspector: Mr. Du Zhiqun

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:

Tower Bay 10

This QA Inspector observed ZPMC welder Mr. Li Panpan, stencil 057239 is using shielded metal welding process to tack weld temporary brackets to the lower exterior skin plates on north tower lift 1. This QA Inspector observed a welding current of approximately 150 amps and Mr. Li Panpan appears to be certified to make this weld. This QA Inspector observed a second person is using a torch to preheat the base material where each of these tack welds are going to be installed. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder stencil 040491 is using shielded metal welding process to tack weld temporary alignment plates to the top of north tower lift 1. It appears these plates are to be used as a guide during the joining of lift 1 with lift 2. This QA Inspector observed a welding current of approximately 155 amps. This QA Inspector observed a second person is using a torch to preheating the base material where these tack welds are going to be installed. Items observed on this date appeared to generally comply with applicable contract

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documents.

This QA Inspector observed Mr. Chang Chuan Gang, stencil 053870 is using welding WPS-B-T-4333-TC-P4-F to make weld NSTL4-33K/L-64 between a north tower lift 4 fit lug and diaphragm plate. This QA Inspector observed a welding current of approximately 300 amps and 29.6 volts and the base material is being heated with electric heating elements. Mr. Chang Chuan Gang appears to be 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 Ms. Li Jiao, stencil 049861 is using shielded metal arc welding procedure specification WPS-B-P-2211 to make tack welds between deck plate DP294-001 and a diaphragm plate. This QA Inspector observed a welding current of approximately 190 amps and Ms. Li Jiao appears to be certified to make this weld. This QA Inspector observed the shielded metal arc welding electrodes are being stored in an electrically heated electrode storage container which is hot to the touch. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Ms. Gao Min, stencil 050988 is using shielded metal arc welding procedure specification WPS-B-P-2211 to make fillet welds between deck plate DP104-001 and a diaphragm plate.

This QA Inspector observed a welding current of approximately 220 amps and Ms. Gao Min appears to be certified to make this weld. This QA Inspector observed the shielded metal arc welding electrodes are being stored in an electrically heated electrode storage container which is hot to the touch. 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
Reviewed By:	Carreon,Albert	QA Reviewer
