

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-011334**Date Inspected:** 27-Dec-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**Summary of Items Observed:**

CWI Inspector: Mr. Liu Xio Zhong

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 11

This 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 WSTL4-2B/L-58A between West Tower Lift 4 skin plate B to skin plate C. This QA Inspector observed Quality Control CWI Mr. Liu Xio Zhong monitoring the base material temperature and other welding attributes. This QA Inspector measured a welding current of 690 amps and 31.2 volts. Items observed on this date appear to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Ms. Cao Gui Mei stencil 047304 using submerged arc welding procedure specification WPS-B-T-2221-C-U2B-S to make groove weld WSTL4-2B/L-58A between West Tower Lift 4 skin plate B to skin plate C. This QA Inspector observed Quality Control CWI Mr. Liu Xio Zhong monitoring the base material temperature and other welding attributes. This QA Inspector measured a welding current of 685 amps and 32.5 volts. Items observed on this date appear to generally comply with applicable contract documents.

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This 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 WSTL4-2B/L-58A between West Tower Lift 4 skin plate B to skin plate C. This QA Inspector observed Quality Control CWI Mr. Liu Xio Zhong monitoring the base material temperature and other welding attributes. This QA Inspector measured a welding current of 670 amps and 29.5 volts. Items observed on this date appear to generally comply with applicable contract documents.

The QA Inspector observed ZPMC welder Mr. Yang Meizhen, stencil 042195 using submerged arc welding procedure specification WPS-B-T-2221-C-U2B-S to make groove weld WSTL4-2B/L-58A between West Tower Lift 4 skin plate B to skin plate C. This QA Inspector observed Quality Control CWI Mr. Liu Xio Zhong monitoring the base material temperature and other welding attributes. This QA Inspector measured a welding current of 660 amps and 30.25 volts. Items observed on this date appear to generally comply with applicable contract documents.

The QA Inspector observed ZPMC welder Ms. Wu Aixiang, stencil 040772 using submerged arc welding procedure specification WPS-B-T-2221-C-U2B-S to make groove weld WSTL4-2B/L-58A between West Tower Lift 4 skin plate B to skin plate C. This QA Inspector observed Quality Control CWI Mr. Liu Xio Zhong monitoring the base material temperature and other welding attributes. This QA Inspector measured a welding current of 680 amps and 31.9 volts. 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 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
