

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-011738**Date Inspected:** 10-Jan-2010**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:**

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:

CWI Inspectors: Mr. Lu Fa Wen, Mr. Lv Li Qing, Mr. Li Lin

OBG BAY 5

This QA Inspector observed ZPMC workers were performing heat straightening of traveler rail 11TR1-018 as listed on flame straightening document HSR1(B)-7750. This activity is being monitored by ZPMC QC Inspector Mr. Wang Liang and ZPMC CWI Mr. Liu Fa Wen. This QA Inspector observed ZPMC personnel have a laser heat measurement device. Items observed on this date appeared to generally comply with applicable contract documents.

Tower Bay 11

This QA Inspector observed ZPMC welder Mr. Zhai Qing Shan, stencil 058026 is using shielded metal arc welding procedure WPS-345-SMAW-2G(2F)-Repair to perform a weld repair of WSTL4-2B/L-57A/B on West tower lift 4. This QA Inspector observed this weld repair is at the location that had previously been ultrasonically rejected. This QA Inspector measured a welding current of approximately 200 amps and Mr. Zhai Qing Shan

WELDING INSPECTION REPORT

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appears to be certified to make this weld. This QA Inspector observed ZPMC appears to be using electric heating elements to maintain the base material temperature and QC personnel are monitoring the base material preheat. Items observed on this date appeared to generally comply with applicable contract documents.

OBG Bay 14

This QA Inspector observed ZPMC welder Mr. Du Zhong Qiang, stencil 051043 has recently used shielded metal arc welding procedure WPS-B-P-2112 to make OBG tack weld SSD25-PP050-186. This QA Inspector observed Mr. Du Zhong Qiang appears to be certified to make this weld. 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
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Reviewed By:	Carreon,Albert	QA Reviewer
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