

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-011741**Date Inspected:** 19-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:**

CWI Inspectors: Mr. Gong Liang Zhu, Mr. Wu Zhi Cheng

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:

Heavy Dock Towers

This QA Inspector observed ZPMC welder Mr. Bu Ciaqing, stencil 62092 is using shielded metal arc procedure WPS-B-P-2212-B-U2A-1 to install weld NSD1-A112H/H-21 inside the base of North Tower lift 1. This QA Inspector observed the welding electrodes are being stored in a portable rod oven that is connected to an electric power cable. This QA Inspector measured a welding current of approximately 230 amps and Mr. Bu Ciaqing appears to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

Segment Assembly

This QA Inspector observed ZPMC welder Mr. Hu Yanming, stencil 62092 has recently used shielded metal arc procedure WPS-345-SMAW-3G(3F) Repair-1 to make weld repairs to various fillet welds near panel point 44 in segment 6BE. This QA Inspector observed the welding electrodes are being stored in a portable rod oven that

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appears to be connected to an electric power cable. This QA Inspector observed ZPMC QC personnel have recorded a welding current of 115 amps and Mr. Hu Yanming appears to be certified to make this 4G(4F) (overhead) position weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Xue Xiang Liang, stencil 066478 has recently used flux cored welding procedure WPS-B-P-2112-FCM-1 to make weld SP338-001-012. This QA Inspector observed the welding parameters recorded by ZPMC QC personnel appear to comply with the WPS. This QA Inspector observed that Mr. Xue Xiang Liang appears to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Zhang Hanming, stencil 220066 has recently used flux cored welding procedure WPS-B-T-2331-B-U2A-F-3 to make weld OBE7-002 between segments 7AE and 7BE. This QA Inspector observed the welding parameters recorded by ZPMC QC personnel appear to comply with the WPS. This QA Inspector observed that Mr. Zhang Hanming 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
Reviewed By:	Carreon,Albert	QA Reviewer
