

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-012684**Date Inspected:** 16-Mar-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**Summary of Items Observed:**

CWI Inspector: Mr. Liu Hua Jie

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 14

This QA Inspector observed ZPMC welder Ms. Hue Junrong, stencil 201215 is using flux cored welding procedure WPS-B-T-2133 to make OBG welds SEG3005C-016 and SEG3005C-017. These welds are located near PP113 at OBG segment 12BW. This QA Inspector measured a welding current of approximately 225 amps and 24.8 volts. This QA Inspector observed ZPMC QC Inspector Mr. Li Ming Ping is monitoring this welding and Ms. Hue Junrong 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. He Hanbi, stencil 202122 is using flux cored welding procedure WPS-B-T-2133 to make OBG gusset to floor beam weld SEG3005E-021 near segment 12BE panel point 113. This QA Inspector measured a welding current of approximately 225 amps and 24.5 volts. This QA Inspector observed ZPMC QC Inspector Mr. Li Ming Ping is monitoring this welding and Mr. He Hanbi appears to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract

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documents.

This QA Inspector observed ZPMC welder Mr. Wang Changming, stencil 047864 is using shielded metal arc welding procedure specification WPS-B-T-2133 to complete weld SEG071B-025. ZPMC QC Inspector Mr. Li Ming Ping informed this QA Inspector that this weld is being repaired as a result of an ultrasonic rejection report dated 3-12-2010. This QA Inspector observed a welding current of approximately 155 amps, the welding electrodes are being stored in a heated portable electrode storage oven. This QA Inspector observed the base material was preheated with a torch prior to commencement of the welding and Mr. Wang Changming appears to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents. See the photograph for additional information.

This QA Inspector observed ZPMC welder Mr. Tian Zhaoquan, stencil 045246 is using shielded metal arc welding procedure WPS-B-P-2214-C-U4b-FCM-1 to make 4G (overhead) position shielded metal arc weld SEG005J-007 and SEG3005J-008 at OBG segment 12BW panel point 113. This QA Inspector observed Mr. Tian Zhaoquan has a welding current of approximately 150 amps and Mr. Tian Zhaoquan 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. Jiang Shizhen, stencil 48694 is using shielded metal arc welding procedure WPS-B-P-2112 to tack weld various longitudinal diaphragms to deck plate DP3066-001. This QA Inspector measured a welding current of approximately 150 amps and Mr. Jiang Shizhen appears to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

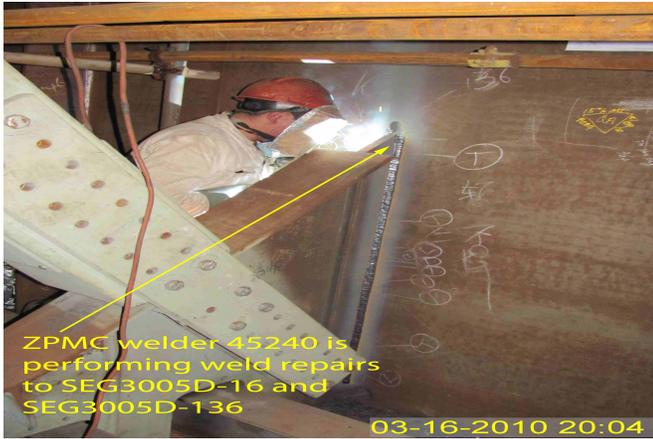
This QA Inspector observed ZPMC welder Mr. Jiang Yong Sheng, stencil 045240 had partially completed using flux cored welding procedure WPS-B-T-2233-TC-U4b-F to make repairs to OBG weld SEG3005D-016 and weld SEG3005D-021. Earlier in the day Caltrans QA Inspector Mr. Subhasis Bera had performed magnetic particle inspections of these welds earlier today and he had identified these welds to have crack like indications. These welds are located near panel point PP114 at OBG segment 12BW. This QA Inspector measured a welding current of approximately 215 amps and 25.0 volts. This QA Inspector observed ZPMC QC Inspector Mr. Li Ming Ping is monitoring this welding and Mr. Jiang Yong Sheng appears to be certified to make these welds. Items observed on this date appeared to generally comply with applicable contract documents. See the photograph below for additional information.

OBG Bay 19

This QA Inspector observed no ZPMC workers appeared to be working on Caltrans materials and support bracket SB010-042 was staged in the area where several other support brackets had previously been located. Most of the overhead lights in bay 19 are turned off.

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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
Reviewed By: Carreon,Albert

Quality Assurance Inspector
QA Reviewer
