

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-012835**Date Inspected:** 23-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 Inspectors: Mr. Liu Hua Jie and Mr. Lv Li Qing

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 Mr. Hue Junrong, stencil 201215 has been using flux cored welding procedure WPS-B-T-2231-T to make OBG weld SEG3005G-138. This weld is located in OBG segment 12CW. This QA Inspector observed ZPMC QC Inspector Mr. Tao Wei has recorded a welding current of 305 amps and 30.0 volts. This QA Inspector observed Mr. 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 has been using flux cored welding procedure WPS-B-T-2133 to make OBG weld SEG3006N-017 and SEG3006N-018. These welds are located in OBG segment 12CW. This QA Inspector measured a welding current of approximately 230 amps and 25.0 volts. This QA Inspector observed Mr. He Hanbi appears to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

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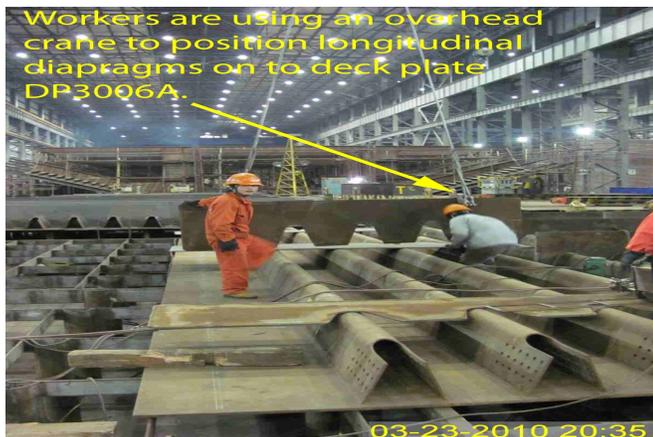
This QA Inspector observed ZPMC welder Mr. Sun Gusong, stencil 058592 is using shielded metal arc welding procedure specification WPS-B-P-2213-FCM to tack weld longitudinal diaphragm LD3007-001 to floor beam FB3039-001. This QA Inspector observed a welding current of approximately 150 amps. This QA Inspector observed Mr. Sun Gusong appears to be certified to make this weld and the welding electrodes are being stored in a heated portable electrode storage oven which is hot to the touch and the base material was preheated with a torch prior to tack welding. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Ms. Li Jiao, stencil 049861 is using shielded metal arc welding procedure specification WPS-B-P-2112-FCM-1 to make tack welds between longitudinal diaphragms and deck plates DP3006A, DP3017A and DP3018A. These deck plates will be installed in OBG segment 12BE. 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 and the base material was preheated with a torch prior to tack welding. Items observed on this date appeared to generally comply with applicable contract documents.

OBG Bay 13

This QA Inspector observed ZPMC welder Ms. Wang Min, stencil 044771 is using submerged arc welding procedure WPS-B-T-2221-B-U3C-S-2 to make groove weld BP3032-005. This material is to be used as a temporary structure and is not going to be installed as a permanent bridge component. This QA Inspector observed a welding current of approximately 700 amps and 33 volts. This QA Inspector confirmed that Ms. Wang Min appears to be certified to make this weld and the base material has been preheated prior to welding. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Sun Guzuo, stencil 058100 is using submerged arc welding procedure WPS-B-T-2221-B-U3C-S-2 to make groove weld BP3032-004. This material is to be used as a temporary structure and is not going to be installed as a permanent bridge component. This QA Inspector observed a welding current of approximately 700 amps and 34 volts. This QA Inspector confirmed that Mr. Sun Guzuo appears to be certified to make this weld and the base material has been preheated prior to welding. Items observed on this date appeared to generally comply with applicable contract documents.



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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	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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