

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-013479**Date Inspected:** 10-Apr-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. Yu 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 Segment 9EE located in the yard near the front of Bay 15

This QA Inspector observed ZPMC welder Mr. Wu Hai Jun, stencil 201087 is using shielded metal arc procedure WPS-485-SMAW-2F(2G)-FCM-Repair-1 to make repair weld CA070-004 as authorized by critical weld repair document B-CWR-1368. This weld repair is between OBG segment 9EE deck plate and the side plate. This QA Inspector measured a welding current of approximately 180 amps. This QA Inspector observed Mr. Wu Hai Jun is welding on the top of a scaffold that is approximately 6 meters above the ground and he appears to be certified to perform this welding. This QA Inspector observed the shielded metal arc welding electrodes are stored in an electrically heated electrode storage container and it appears to be connected to the welding power supply cable. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Wang Jinjin, stencil 043661 is using shielded metal arc procedure WPS-485-SMAW-2F(2G)-FCM-Repair-1 to make repair weld CA070-004 as authorized by critical weld repair document B-CWR-1368. This weld repair is between OBG segment 9EE deck plate and the side plate. This QA

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Inspector measured a welding current of approximately 180 amps. This QA Inspector observed Mr. Wang Jinjin is welding on the top of a scaffold that is approximately 6 meters above the ground and he appears to be certified to perform this welding. This QA Inspector observed the shielded metal arc welding electrodes are stored in an electrically heated electrode storage container and it appears to be connected to the welding power supply cable. Items observed on this date appeared to generally comply with applicable contract documents.

OBG 9CW located in the yard near the back of Bay 15

ZPMC has recently presented QA personnel with “Notification of Witness Inspection” document #005376 item 1 that states ZPMC has completed their inspections and ZPMC is requesting Caltrans to perform magnetic particle and ultrasonic inspections of OBG segment 9CW as listed on Tag #1, Tag #2, Tag # 3, Tag # 4 and Tag # 5. This QA Inspector performed random magnetic particle (MT) of the welds that are listed below and these welds appear to comply with AWS D1.5 MT requirements. For additional information on these inspections see this QA Inspector’s TL6028 Magnetic Particle Test Report.

Tag 3

SEG53C-27, 28

Tag 4

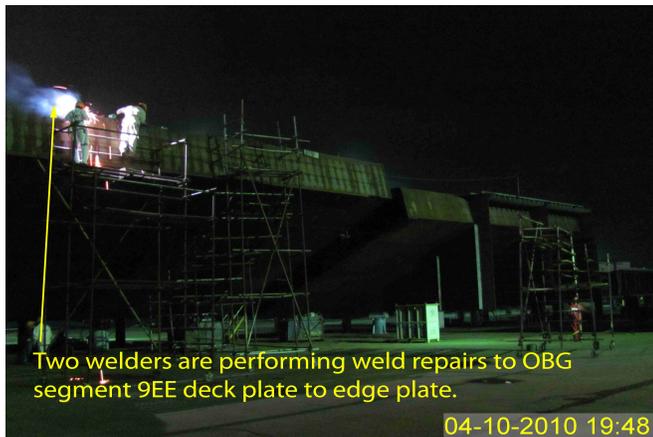
SSD14A-04, 05

CSD3-PP79-37, 38

Tag 5

CSD6-PP77-28, 30, 44, 52, 46, 54

CSD2-PP76.5-19, 21, 77, 75, 73, 71



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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Dawson,Paul	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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