

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-013636**Date Inspected:** 15-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 Inspectors: Mr. Liu Hua Jie, Mr. Geng Wei

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 9DE located in yard near the front of Bay 16

ZPMC has recently presented QA personnel with "Notification of Witness Inspection" document #005523 item 2 that states ZPMC is requesting Caltrans to perform magnetic particle and ultrasonic inspections of OBG segment 9CE as listed on Tag #1 through Tag #7. This QA Inspector performed random magnetic particle (MT) and ultrasonic (UT) inspections 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 and TL6027 Ultrasonic Test Report for additional information.

Tag 4 UT: Segment 9DE welds

SSD17A-PP081-01, 08

SSD17-PP081-04

SSD16A-PP080-01, 08

SSD16-PP080-04

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Tag 7 MT: Segment 9DE welds

SEG587-13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24

SEG586-42, 43, 44, 45, 46, 47, 48, 49, 50, 51, 52, 53, 54

OBG Bay 14

This QA Inspector observed ZPMC welder Ms. Xie Jin Xia, stencil 048038 is using flux cored welding procedure WPS-B-T-4132 to make weld DP3027-001-247 between OBG 12CE deck plate DP3027-001 and a diaphragm plate. This QA Inspector observed ZPMC QC Inspector Mr. Guo Pan has recorded a welding current of 310 amps and 31.1 volts. This QA Inspector observed Ms. Xie Jin Xia 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. Tu Zhi Wu, stencil 214945 is using flux cored welding procedure WPS-B-T-4132 to make weld DP3027-001-216 between OBG 12CE deck plate DP3027-001 and a diaphragm plate. This QA Inspector observed ZPMC QC Inspector Mr. Guo Pan has recorded a welding current of 307 amps and 30.9 volts. This QA Inspector observed Mr. Tu Zhi Wu 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. Cheng Yueying, stencil 050977 is using flux cored welding procedure WPS-B-T-4132 to make OBG segment 12CE, deck plate weld DP3029-246 between a diaphragm plate and deck plate DP3029-001. This QA Inspector observed ZPMC QC Inspector Mr. Guo Pan has recorded a welding current of 309 amps and 24.6 volts. This QA Inspector observed that Mr. Cheng Yueying 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 Ms. Chen Fenglian, stencil 206623 is using flux cored welding procedure WPS-B-T-2232-TC-U4b-F to make OBG segment 12CE, deck plate weld DP3027-024 between a diaphragm plate and deck plate DP3027-001. This QA Inspector observed ZPMC QC Inspector Mr. Guo Pan has recorded a welding current of 312 amps and 30.9 volts. This QA Inspector observed that Ms. Chen Fenglian 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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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
