

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-013640**Date Inspected:** 20-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. Tian Lei, Mr. Geng Wei, 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 13

This QA Inspector observed ZPMC welder Mr. Wu Wanyong, stencil 050242 is using flux cored welding procedure WPS-345-FCAW-2G(2F)-Repair to make traveler rail repair weld 20TR2-009-015 in accordance with a weld repair document which has not had a tracking number assigned. The reason for this repair is due to ultrasonic rejections. This QA Inspector observed ZPMC QC Inspector Mr. Zhan Hai Feng is monitoring this welding and that Mr. Wu Wanyong appears to be certified to make this weld. This QA Inspector measured a welding current of approximately 300 amps and 30.0 volts. Items observed on this date appeared to generally comply with applicable contract documents.

OBG Bay 14

This QA Inspector observed ZPMC welder Mr. Chen Chuanzong, stencil 044824 is using flux cored welding procedure WPS-B-T-2132 to make OBG weld SEG3002C-009 at OBG segment 12BE between a diaphragm plate

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and floor beam. This QA Inspector observed QC Inspector Mr. Guo Pan has recorded a welding current of 310 amps and 30.7 volts. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Zhang Quin Quan, stencil 044774 is using flux cored welding procedure WPS-B-T-2132 to make OBG weld SEG3002F-011 at OBG segment 12BE between a diaphragm plate and floor beam. This QA Inspector observed QC Inspector Mr. Guo Pan has recorded a welding current of 307 amps and 30.2 volts and that Mr. Zhang Quin Quan 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. Xie Jin Xia, stencil 048038 is using flux cored welding procedure WPS-B-T-2132 to make OBG weld SEG3002E-010 at OBG segment 12BE between a diaphragm plate and floor beam. This QA Inspector observed QC Inspector Mr. Guo Pan has recorded a welding current of 312 amps and 30.0 volts and that 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 Ms. Chen Fenglian, stencil 206623 is using flux cored welding procedure WPS-B-T-2132 to make OBG weld SEG3002F-005 at OBG segment 12BE between a diaphragm plate and floor beam. This QA Inspector observed QC Inspector Mr. Guo Pan has recorded a welding current of 304 amps and 30.9 volts and 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.

This QA Inspector observed ZPMC welder Mr. Jin Chen Mao, stencil 058551 is using flux cored welding procedure WPS-B-T-2132 to make OBG weld SEG3002G-011 at OBG segment 12BE between a diaphragm plate and floor beam. This QA Inspector observed QC Inspector Mr. Guo Pan has recorded a welding current of 309 amps and 30.7 volts and that Mr. Jin Chen Mao 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. Dan Deyin, stencil 044795 is using flux cored welding procedure WPS-B-T-2132 to make OBG weld SEG3002H-013 at OBG segment 12BE between a diaphragm plate and floor beam. This QA Inspector observed QC Inspector Mr. Guo Pan has recorded a welding current of 312 amps and 31.0 volts and that Mr. Dan Deyin 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. Li Jun, stencil 051348 is using shielded metal arc welding procedure specification WPS-B-P-2214-TC-U4b-FCM-1 to complete weld SSD110A-PP104-241 in the 4G (overhead) position. This QA Inspector measured a welding current of approximately 165 amps and that Mr. Li Jun appears to be certified to perform this welding. Items observed on this date appeared to generally comply with applicable contract documents.

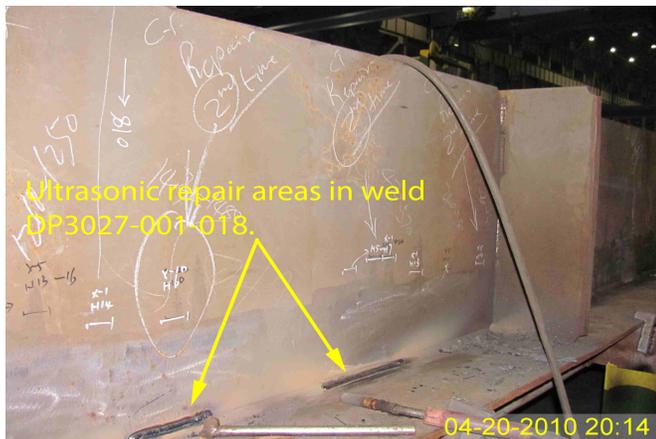
This QA Inspector observed ZPMC welder Mr. Wang Chang Ming, stencil 047864 is using shielded metal arc welding procedure specification WPS-B-P-2214-TC-U4b-FCM-1 to complete weld SSD110-PP104-241 in the 4G (overhead) position. This QA Inspector measured a welding current of approximately 170 amps and that Mr. Wang Chang Ming appears to be certified to perform this welding. Items observed on this date appeared to

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generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Yuan Wensong, stencil 055491 is using welding procedure WPS-345-FCAW-2G(2F)-Repair to make a repair to deck panel weld DP3027-001-018. The weld repair document indicates this repair is due to ultrasonic rejections and this document does not have a tracking number assigned. This QA Inspector observed a welding current of approximately 280 amps and 28.0 volts. This QA Inspector observed that Mr. Yuan Wensong appears to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents. See the photograph below for additional information.



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
