

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-013649**Date Inspected:** 29-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. Zhu Zhong Hai, Mr. Li Jia, Mr Li Zhi Jiang

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 2

This QA Inspector observed ZPMC welder Ms. Pi Lijuan, stencil 062438 is using flux cored welding procedure specification WPS-B-T-2132-3 to make weld FB3215-001-035. This QA Inspector observed ZPMC Quality Control Inspector Mr. Zhang Xaxu has recorded a welding current of 309 amps and 30.4 volts and Ms. Pi Li Juan appears to be certified to make this weld. Items observed by this QA Inspector appear to be progressing in compliance with project specifications.

This QA Inspector observed ZPMC welder Mr. Wang Caili, stencil 045203 is using flux cored welding procedure specification WPS-B-T-2132-3 to make weld FB3026-001-009. This QA Inspector observed ZPMC Quality Control Inspector Mr. Zhang Xaxu has recorded a welding current of 307 amps and 30.3 volts and Mr. Wang Caili appears to be certified to make this weld. Items observed by this QA Inspector appear to be progressing in compliance with project specifications.

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This QA Inspector observed ZPMC welder Ms. Wang Lanying, stencil 045265 is using submerged arc welding procedure WPS-B-T-2221-B-U3C-S-2 to make floor beam weld FB3192-001-001. This QA Inspector observed ZPMC Quality Control Inspector Mr. Zhang Xaxu has recorded a welding current of 587 amps and 31.3 volts and Ms. Wang Lanying appears to be certified to make this weld. Items observed by this QA Inspector appear to be progressing in compliance with project specifications.

This QA Inspector observed ZPMC welder Mr. Wang Bin, stencil 048696 is using flux cored welding procedure WPS-345-FCAW-1G(1F)-Repair-1 to make traveler rail repair weld 20TR1-006-001 in accordance with a weld repair document B-WR11955. The reason for this repair is due to ultrasonic rejections as listed on UT report #B787-UT-12188. This QA Inspector observed that Mr. Wang Bin appears to be certified to make this weld and ZPMC QC Inspector Mr. Zhang Yaxu has recorded a welding current of 291 amps and 30.1 volts. Items observed on this date appeared to generally comply with applicable contract documents.

OBG Bay 6

This QA Inspector observed ZPMC welder Mr. Li Yuan Zheng, stencil 217185 is using flux cored welding procedure WPS-B-T-2331-TC-U4C-F to make traveler rail bracket weld TR5B-PP049-003. This QA Inspector observed ZPMC QC is using a 110 degree Celsius Temp-Stik to verify the base material preheat prior to welding and measuring a welding current of approximately 290 amps and 31.0 volts. Mr. Li Yuan Zheng appears to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

OBG Bay 7

This QA Inspector observed ZPMC welder Mr. Wei Da Shuai stencil 051246 is using flux cored welding procedure WPS-345-FCAW-2G(2F)-Repair to make traveler rail repair weld 10TR2-021-005 in accordance with a weld repair document B-WR12057. The reason for this repair is due to ultrasonic rejections as listed on UT report #B787-UT-10797R. This QA Inspector observed ZPMC QC Inspector Mr. Xia Yong Zheng is monitoring this welding and that Mr. Wei Da Shuai appears to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

OBG Bay 14

This QA Inspector observed ZPMC welder Ms. Wang Min, stencil 044771 is using submerged arc welding procedure WPS-B-T-223(2)-T-2 to make OBG segment 12CE weld SEG3003*-004. This QA Inspector observed ZPMC QC has recorded a welding current of 610 amps and 32.5 volts. This QA Inspector confirmed that Ms. Wang Min 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
