

**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-014849**Date Inspected:** 15-May-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 and Tower**Summary of Items Observed:**

CWI Inspectors: Mr. Lv Li Qing, Mr. Zhu Zhong Hai

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. Zhao Jibo, stencil 055564 is using flux cored welding procedure WPS-B-T-2133 to make OBG weld SEG3001P-165 and -166 at OBG segment 12AE near panel point 109. This QA Inspector observed a welding current of approximately 220 amps and 25.0 volts. This QA Inspector observed that Mr. Zhao Jibo 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 has been using flux cored welding procedure WPS-B-T-2233-B-U2-F to make OBG weld SEG3001P-001 at OBG segment 12AE near panel point 109. This QA Inspector observed ZPMC QC has recorded a welding current of 210 amps and 25.5 volts. This QA Inspector 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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This QA Inspector observed ZPMC welder Ms. Xie Jin Xia, stencil 048038 has been using flux cored welding procedure WPS-B-T-2233-B-U2-F to make OBG weld SEG3001L-001 at OBG segment 12AE near panel point 110. This QA Inspector observed ZPMC QC has recorded a welding current of 213 amps and 25.7 volts. This QA Inspector 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. Gao Yuling, stencil 217805 has been using flux cored welding procedure WPS-B-T-2233-B-U2-F to make OBG weld SEG3001J-002 at OBG segment 12AE near panel point 111. This QA Inspector observed ZPMC QC has recorded a welding current of 215 amps and 25.5 volts. This QA Inspector that Ms. Gao Yuling 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. Zang Chang Ming, stencil 047864 has been using flux cored welding procedure WPS-B-T-2233-B-U2-F to make OBG weld SEG3006G-001 at OBG segment 12CW near panel point 117. This QA Inspector observed ZPMC QC has recorded a welding current of 212 amps and 26.3 volts. This QA Inspector that Mr. Zang Chang Ming 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 stencil 062438 has been using flux cored welding procedure WPS-B-T-2233-B-U2-F to make OBG weld SEG3006C-002 at OBG segment 12CW near panel point 117. This QA Inspector observed ZPMC QC has recorded a welding current of 206 amps and 25.4 volts. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder stencil 402730 has been using flux cored welding procedure WPS-B-T-2132 to make OBG weld SEG3005F-011 at OBG segment 12CW near panel point 115.5. This QA Inspector measured a welding current of 330 amps and 29.3 volts and that the base material is being preheated with electric heating elements. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Ms. Pi Lijuan, stencil 062438 has been using flux cored welding procedure WPS-B-T-2132 to make OBG weld SEG3005F-011 at OBG segment 12CW near panel point 115.5. This QA Inspector observed QC has recorded a welding current of 324 amps and 30.6 volts and that the base material is being preheated with electric heating elements. This QA Inspector that Ms. Pi Lijuan 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 workers using one of the overhead cranes to position a corner assembly in position on the counterweight side of OBG segment 12C at panel point 118. See the photographs below for additional information.

### Blast Shop #2

This QA Inspector observed ZPMC is moving West tower lift 1 into blast shop #2 to allow ZPMC to blast clean and paint the tower assembly. See the photograph below for additional information.

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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.

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**Inspected By:** Dawson,Paul

Quality Assurance Inspector

**Reviewed By:** Carreon,Albert

QA Reviewer

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