

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-014860**Date Inspected:** 26-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**Summary of Items Observed:**

CWI Inspectors: Mr. Li Yan Hua, Mr. Wu Zhi Cheng

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 Ms. Wang Min, stencil 044771 is using submerged arc welding procedure specification WPS-B-T-2221-U3C-S-2 to make OBG segment 13AE bottom plate groove butt weld BP3031-001-003. This QA Inspector observed Ms. Wang Min appears to be certified to make this weld and measured a welding current of approximately 600 amps and 30.0 volts. ZPMC has used electric heating elements to maintain the temperature of the steel plates that are being welded. Items observed on this date appeared to generally comply with applicable contract documents. See the photograph below for additional information.

OBG Segment Assembly

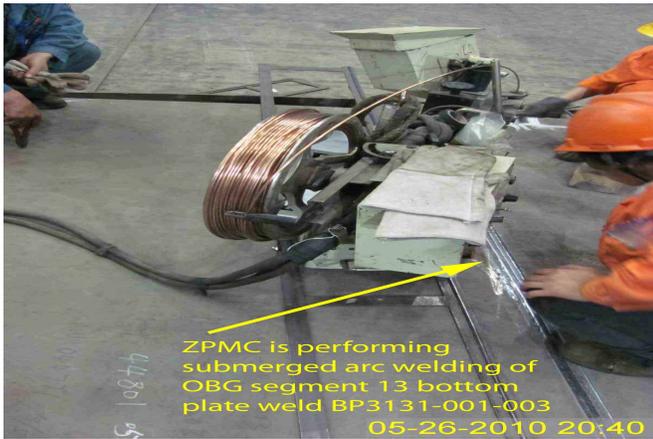
This QA Inspector observed ZPMC welder Mr. Wang Bin, stencil 048696 is using flux cored welding procedure WPS-B-T-2231-B-U2-F to make OBG segment weld BP063-001-013 and -014. These welds join OBG segments 8BW and 8CW near panel point 76. This QA Inspector observed that Mr. Wang Bin appears to be certified to

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make this weld and ZPMC QC Inspector Mr. Wong Zhu has recorded a welding current of 300 amps and 29.0 volts. Items observed on this date appeared to generally comply with applicable contract documents.

ABF issued "Inspection Notification Sheet" number 05262010-1 item #1 informing QA that on 05-26-2010 at 1930 hours ABF Inspectors will be performing ultrasonic (UT) inspections of repaired hold back weld SEG044A-021 which joins the bottom plate to side plate E4 weld at OBG segment 8AE. This weld is located in the trial assembly area. ABF/Sense UT Inspectors informed this QA Inspector that they were unable to perform ultrasonic inspections of the weld repairs because the weld surface was hot as a result of welding on an adjacent weld. This QA Inspector did not perform ultrasonic inspections of this weld, pending completion of the inspections by ABF/Sense UT Inspectors.



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
