

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017007**Date Inspected:** 10-Sep-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:**

ZPMC CWI Inspector: Mr. Lv Li Qing

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:

This QA Inspector observed ZPMC welder Mr. Yun Qiang, stencil 044504 used shielded metal arc welding procedure WPS-345-SMAW-3G(3F)-FCM-Repair-1 to make repair weld OBE10-001. This weld joins the cross beam edge plates between OBG segments 10AE and 10BE. ZPMC had issued weld repair document B-WR14892 to correct misalignment of these plates. This QA Inspector observed a welding current of approximately 160 amps and the welding electrodes were stored in a heated portable electrode storage container. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Cheng Yun, stencil 040320 used shielded metal arc welding procedure WPS-345-SMAW-4G(4F)-FCM-Repair-1 to make "I" stiffener plate hold back repair welds SP695-001-046 through SP695-001-050. These welds join the cross beam corner assembly side plates between OBG segments 10AE and 10BE. ZPMC had issued weld repair document B-WR14892 to correct misalignment of these plates. This QA Inspector observed a welding current of approximately 150 amps and the welding electrodes were stored in a heated portable electrode storage container. Items observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA Inspector observed ZPMC welder Mr. Hua Linming, stencil 044515 used shielded metal arc welding procedure WPS-345-SMAW-24(24)-FCM-Repair-1 to make OBG segment 10AE to 10BE bikepath side plate repair weld OBE10B-004. ZPMC had issued weld repair document B-CWR1893 due to ultrasonic rejections. This QA Inspector measured a welding current of approximately 130 amps. , Mr. Hua Linming appeared to be certified to make this weld and the base materials had been preheated with electric heating elements on the interior surface of this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Dai Yunbo, stencil 040262 used shielded metal arc process to tack weld a weld temporary alignment plate to the underside of OGB segments 10BE and 10CE near the counterweight side of the bottom plates. This QA Inspector measured a welding current of approximately 160 amps, the base material adjacent to this weld appeared to have been preheated with a torch and Mr. Dai Yunbo appeared 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 Ms. Lv Tong Xia, stencil 040484 used shielded metal arc process to tack weld a weld temporary alignment plate to bikepath side plate of OGB segments 10BE and 10CE. This QA Inspector measured a welding current of approximately 150 amps, the base material adjacent to this weld appeared to have been preheated with torch and Ms. Lv Tong Xia appeared 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. Li Hongren, stencil 062200 used shielded metal arc process to tack weld a weld temporary alignment plate to OBG segment 10AW and cross beam CB14 top deck plates. This QA Inspector measured a welding current of approximately 170 amps, the base material adjacent to this weld appeared to have been preheated with torch and Mr. Li Hongren appeared to be certified to perform this welding. Items observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

See Above.

Comments

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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
