

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-017030**Date Inspected:** 26-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:**

CWI Inspectors: ZPMC: Mr. Liu Hua Jie, Mr. Xu Tao

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 Segment Trial Assembly

A light rain fell most of the day and ZPMC CWI Mr. Liu Hua Jie informed this QA Inspector that no ZPMC welders were working in the trial assembly due to the steel being wet.

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This QA Inspector observed ZPMC welder Mr. Yu Hui Ye, stencil 045143 used flux cored welding procedure specification WPS-B-T-2233-TC-U5-F to perform OBG segment 13AW longitudinal diaphragm welds LD3031-001-064. This QA Inspector observed a welding current of approximately 220 amps and 24.0 volts. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Bi Laishu, stencil 045280 used flux cored welding procedure specification WPS-B-T-2232-TC-U5-F to perform OBG segment 13CW longitudinal diaphragm weld

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LD3033-001-023. This QA Inspector observed a welding current of approximately 300 amps and 30.0 volts. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Yu Li, stencil 040344 used flux cored welding procedure specification WPS-B-T-2233-TC-U5-F to perform OBG segment 13BW longitudinal diaphragm weld LD3032-001-056. This QA Inspector observed a welding current of approximately 220 amps and 25.0 volts and a torch was used to preheat the base material prior to welding. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Ge Hao, stencil 201583 used flux cored welding procedure WPS-B-T-2133 to make OBG segment 13BW longitudinal diaphragm tack weld LD3035-001-027. This QA Inspector measured a welding current of approximately 270 amps and 30.0 volts. This QA Inspector observed that Mr. Ge Hao appeared to be certified to make this weld and the base material was preheated with a torch prior to welding. Items observed on this date appeared to generally comply with applicable contract documents.

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This QA Inspector observed ZPMC welder Mr. Han Ze Jiao, stencil 062808 used flux cored welding procedure WPS-B-T-2132 to make to make suspender bracket weld SB018-094-019. This QA Inspector observed a welding current of approximately 290 amps, 31.0 volts and Mr. Han Ze Jiao appeared 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. Ji Xiao Qiang, stencil 062783 used flux cored welding procedure WPS-B-T-2132 to make to make bikepath weld BK004A8-013-029 and -030. This QA Inspector observed a welding current of approximately 300 amps, 31.0 volts and Mr. Ji Xiao Qiang appeared 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. Zhang Heishan, stencil 040458 used flux cored welding procedure WPS-B-T-2132 to make to make bikepath weld BK004A6-013-041. This QA Inspector observed a welding current of approximately 300 amps, 33.0 volts and Mr. Zhang Heishan appeared 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
