

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-017791**Date Inspected:** 27-Oct-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 Inspector: ZPMC: 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:

OBG Bay 14

ZPMC issued "Inspection Notification Sheet" number 07134 informing Caltrans QA that ZPMC is requesting ultrasonic inspections (UT) of Segment 10AE complete joint penetration deck drainage plate welds OBE10D-008, OBE10D -017; Segment 10CE welds OBE10E-009, OBE10E -030 and segment 11BE floor beam to longitudinal diaphragm welds SEG068B-006, SEG068B-043, SEG068B-057, SEG068C-005, SEG068C-057 and SEG068C-042 in support of "Tagging in Process". This QA Inspector performed random visual and ultrasonic inspections of approximately 20% length of areas previously tested by ZPMC personnel and items observed by this QA Inspector appear to comply with AWS D1.5 UT requirements. For additional information on these inspections see this QA Inspector's TL6027 Ultrasonic Test Report and the photograph below.

ZPMC issued "Inspection Notification Sheet" number 07135 informing Caltrans QA that ZPMC is requesting ultrasonic inspections (UT) of Segment 10AE complete joint penetration deck drainage plate welds OBW10E-008, OBW10E -020; Segment 10CE welds OBW10E-018 and OBW10E-025 in support of "Tagging in Process". This

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QA Inspector performed random visual and ultrasonic inspections of approximately 20% length of areas previously tested by ZPMC personnel and items observed by this QA Inspector appear to comply with AWS D1.5 UT requirements. For additional information on these inspections see this QA Inspector's TL6027 Ultrasonic Test Report.

This QA Inspector observed ZPMC welder Mr. He Hanbi, stencil 202122 used flux cored welding procedure WPS-B-T-2232-TC-U4B-F to make OBG segment 13BW weld SEG3014L-193. This weld joins longitudinal diaphragm LD3035 to bottom plate BP3061A. This QA Inspector measured a welding current of approximately 305 amps. Mr. He Hanbi appeared to be certified to make this weld and the base materials appeared to have been preheated with electrical heaters prior to welding. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Li Xianyou, stencil 047866 used flux cored welding procedure WPS-B-T-2232-TC-U4B-F to make OBG segment 13BW weld SEG3014L-194. This weld joins longitudinal diaphragm LD3035 to bottom plate BP3061A. This QA Inspector measured a welding current of approximately 300 amps. Mr. Li Xianyou appeared to be certified to make this weld and the base materials appeared to have been preheated with electrical heaters prior to welding. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Ms. Hue Junrong, stencil 201215 used flux cored welding procedure WPS-B-T-2232-TC-U4B-F to make OBG segment 13BW weld SEG3014L-195. This weld joins longitudinal diaphragm LD3035 to bottom plate BP3061A. This QA Inspector measured a welding current of approximately 290 amps. Ms. Hue Junrong appeared to be certified to make this weld and the base materials appeared to have been preheated with electrical heaters prior to welding. Items observed on this date appeared to generally comply with applicable contract documents.

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
