

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-018781**Date Inspected:** 07-Dec-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: Mr. Bao Qian

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.

OBG Bay 14

This QA Inspector observed ZPMC welder Mr. Yang Yunfeng, stencil 215553 used shielded metal arc welding procedure WPS-345-SMAW-2G(2F)-FCM-Repair to make a weld repair of ultrasonic rejections to OBG segment 13AE weld SEG3007F-035. ZPMC QC Inspector Mr. Zhong Guo Hui presented this QA Inspector with weld repair document B-WR-17555 that documents the repair of this weld. This QA Inspector observed ZPMC QC has recorded a welding current of 160 amps, 25.3 volts and a travel speed of 112mm per minute. This QA Inspector observed Mr. Yang Yunfeng 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. Zhu Jibo, stencil 055564 used flux cored welding procedure WPS-B-T-2233-ESAB to make OBG segment 13AE weld SA3007AV-069. ZPMC QC had recorded a welding current of 251 amps, 25.4 volts and a welding travel speed of 136mm per minute. This QA Inspector measured a welding current of approximately 240 amps, 26.0 volts and a welding travel speed of 140mm per minute. This QA Inspector observed Mr. Zhu Jibo appeared to be certified to make this weld. Items observed on this date appeared

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to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Hong Liang stencil 050242 used flux cored welding procedure WPS-B-T-2233-ESAB to make OBG segment 13AE weld SA3007AY-038. ZPMC QC had recorded a welding current of 240 amps, 26.0 volts and a welding travel speed of 158mm per minute. This QA Inspector measured a welding current of approximately 240 amps, 26.0 volts and a welding travel speed of 150mm per minute. Mr. Hong Liang 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. Ye Bing stencil 066733 used flux cored welding procedure specification WPS-B-T-2233-ESAB to make OBG segment 13AE weld SEG3007AZ-056. ZPMC QC had recorded a welding current of 248 amps, 25.3 volts and a welding travel speed of 130mm per minute. This QA Inspector measured a welding current of approximately 230 amps, 25.0 volts and a welding travel speed of 140mm per minute. Mr. Ye Bing 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. Chen Chuanzong, stencil 044824 used flux cored welding procedure specification WPS-B-T-2231-ESAB to make OBG segment 14E weld SEG3019A-010. This QA Inspector observed ZPMC QC recorded a welding of 290 amps, 26.1 volts and 247mm per minute. This QA Inspector observed Mr. Chen Chuanzong 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. Wang Hai Yang, stencil 068994 used flux cored welding procedure WPS-B-T-2232-ESAB to make repairs to make OBG segment 13AE weld SA3007AT-043. ZPMC QC had recorded a welding current of 295amps, 25.7 volts and a welding travel speed of 293mm per minute. This QA Inspector measured a welding current of approximately 310 amps, 26.0 volts and a welding travel speed of 250mm per minute. Mr. Wang Hai Yang 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 Quin Quan, stencil 044774 used flux cored welding procedure WPS-B-T-2233-ESAB to make OBG segment 13AE weld SEG3007K-036. This QA Inspector observed ZPMC QC has recorded a welding current of 257 amps, 25.6 volts and a travel speed of 146mm per minute. This QA Inspector observed that Mr. Zhang Quin Quan appeared to be certified to make these welds. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welders Mr. Chen Ren Zhi, stencil 058087 used shielded metal arc welding procedure specification WPS-B-P-2112 to make OBG segment 13AE tack weld SEG3007AD-011. This weld joins sub assembly SA3093 to side plate SP3059E. This QA Inspector observed a welding current of approximately 150 amps and Mr. Chen Ren Zhi 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 James Devey +8615000026784, who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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