

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-019438**Date Inspected:** 31-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. Sheng Qing Quan

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

Segment 13East

This QA Inspector observed ZPMC welder Mr. Zhu Mingsong, stencil 204339 used shielded metal arc welding procedure WPS-345-SMAW-2G(2F)-FCM-Repair to make a weld repair of visual rejections to OBG segment 13CE plate X3767E at panel point PP123. ZPMC QC was not able to identify the specific weld numbers of the areas that were being welded. This QA Inspector measured a welding current of approximately 175 amps. The base materials had been preheated with a torch and Mr. Zhu Mingsong 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. Yang Yunfeng, stencil 215553 used shielded metal arc welding procedure WPS-345-SMAW-2G(2F)-FCM-Repair-1 to make a weld repair of ultrasonic rejections to OBG segment 13AE weld SEG3007AT-082. ZPMC had issued weld repair document B-WR-19145 that documents the repair of this weld. This QA Inspector measured a welding current of approximately 240 amps. The base materials

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had been preheated with an electric heater and Mr. Yang Yunfeng appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents. See the photograph below for additional information.

This QA Inspector observed ZPMC welder Mr. Wang Zhengbin, stencil 216086 used shielded metal arc welding procedure WPS-345-SMAW-2G(2F)-FCM-Repair-1 to make a weld repair of ultrasonic rejections to OBG segment 13AE weld SEG3007AT-069. ZPMC had issued weld repair document B-WR-19220 that documents the repair of this weld. This QA Inspector observed ZPMC QC recorded the depth of the repair was 9mm. This QA Inspector measured a welding current of approximately 230 amps. The base materials had been preheated with an electric heater and Mr. Wang Zhengbin 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 Mingwu, stencil 066283 used flux cored welding procedure WPS-B-T-2232-ESAB to make OBG segment 13AE weld SEG3007AV-080. This QA Inspector observed a welding current of approximately 265 amps and 26.5 volts. The base materials had been preheated with an electric heater and Mr. Zhang Mingwu appeared to be certified to make this weld. 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 James Devey +8615000026784, who represents the Office of Structural Materials for your project.

Inspected By: Dawson,Paul

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer