

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-019863**Date Inspected:** 30-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 Inspectors: Mr. Geng Wei, 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 13AW

This QA Inspector observed ZPMC welder Mr. Yuan Wensong, stencil 055491 used flux cored welding procedure WPS-B-T-2233-ESAB to make OBG segment 13AE welds SEG3007N-127,147,152 and 187. This QA Inspector measured a welding current of approximately 230 amps and 24 volts. The base materials had been preheated with an electric heater and Mr. Yuan Wensong 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. Hu Den Jiang, stencil 067877 used flux cored welding procedure WPS-B-T-2231-ESAB to make OBG segment 13AE weld SEG3007Y-346. This QA Inspector measured a welding current of approximately 320 amps and 27.5 volts. The base materials had been preheated with an electric heater and Mr. Hu Den Jiang 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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This QA Inspector observed ZPMC welder Mr. Wang Zhengbin, stencil 216086 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 SEG3007AT-030. ZPMC had issued weld repair document B-WR-19218 that documents the repair of this weld. This QA Inspector measured a welding current of approximately 220 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. 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 SEG3007Y-359. ZPMC had issued weld repair document B-WR-19262 that documents the repair of this weld. This QA Inspector measured a welding current of approximately 240 amps. The base materials 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.

This QA Inspector observed ZPMC personnel preparing to perform radiography (RT) inspections of various segment 13E deck plates in the front of bay 14. See the photographs below for additional information.



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: Riley,Ken

QA Reviewer