

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-021481**Date Inspected:** 04-Mar-2011**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 of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

OBG Bay 14

QA performed UT inspection of segment 14E deck plate welds DP3167-001-021~024, 036~041, 242, 243, 245 and 246, NWIT 8451 item #3.

ZPMC issued "Inspection Notification Sheet" number 08451 item #3 informing Caltrans QA that ZPMC is requesting ultrasonic inspections (UT) of OBG segment 14E complete joint penetration deck plate welds DP3167-001-021~024, 036~041, 242, 243, 245 and 246. This QA Inspector visually observed one of the ends of weld DP3167-001-242 appears to have been flame cut with a torch and this area has not been ground to a smooth surface. No ZPMC QC Inspectors were near this location and this QA informed dayshift Caltrans QA personnel to follow up on this visual rejection. This QA Inspector performed random visual and ultrasonic inspections of approximately 15% length of the welds listed above which had been 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 photographs

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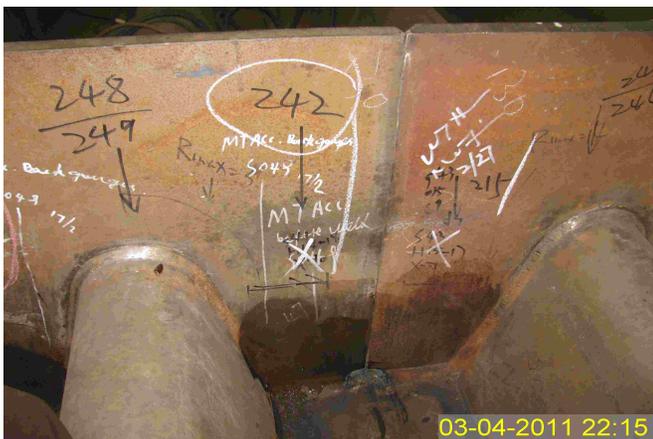
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below.

ZPMC issued "Inspection Notification Sheet" number 08456 item #1 informing Caltrans QA that ZPMC is requesting ultrasonic inspections (UT) of OBG segment 13CE complete joint penetration weld SA3214A-001-004.

This weld joins deck plate DP3109A to DP3108A. This QA Inspector performed random visual and ultrasonic inspections of approximately 15% 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.

This QA Inspector observed ZPMC welder Mr. Yang Yunfeng, stencil 215553 used shielded metal arc welding procedure specification WPS-345-SMAW-2G(2F)-FCM-Repair-1 to make repairs of OBG segment 14E weld DP3161-001-006. ZPMC QC informed this QA Inspector that weld repair document B-WR-20269 documents this weld repair. This QA Inspector observed a welding current of approximately 190 amps, the base materials appear to have been preheated with electric heating elements 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.



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

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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
