

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-022694**Date Inspected:** 08-Apr-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. 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

This QA Inspector observed ZPMC welder Mr. Wang Changfa, stencil 058102 used shielded metal arc welding procedure specification WPS-345-SMAW-4G(4F)-FCM-Repair-1 to make repairs to OBG segment 14E weld SEG3019AQ-025. ZPMC QC informed this QA Inspector that weld repair document B-WR-20559 documents this weld had been ultrasonically rejected. This QA Inspector observed a welding current of approximately 170 amperes (amps), the base material had been preheated with a torch and Mr. Wang Changfa appeared to be certified to make this weld. Later in the shift this QA Inspector observed Mr. Wang Changfa performing repairs of weld SEG3019Q-1-105 in accordance with weld repair document B-WR-20602 and weld EP3027-001-095 in accordance with weld repair document B-WR-20603. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Wang Li, stencil 044772 used shielded metal arc welding

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

procedure specification WPS-B-P-2212-TC-U4B-FCM-1 to make OBG segment 14E weld SEG3019BB-112 and later in the shift Mr. Wang Li performed critical weld repair to SEG3019BB-045 in accordance with B-CWR-2917.

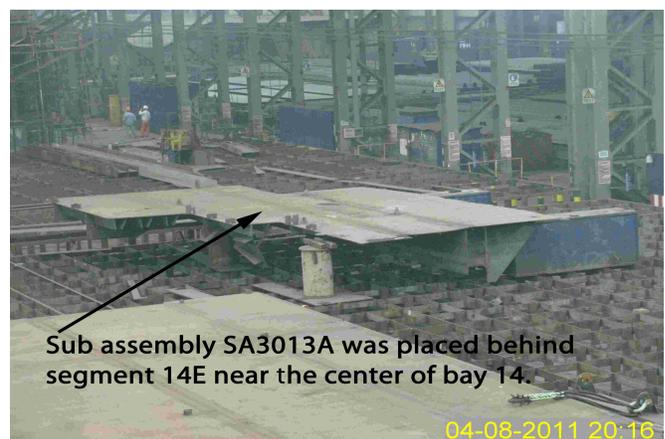
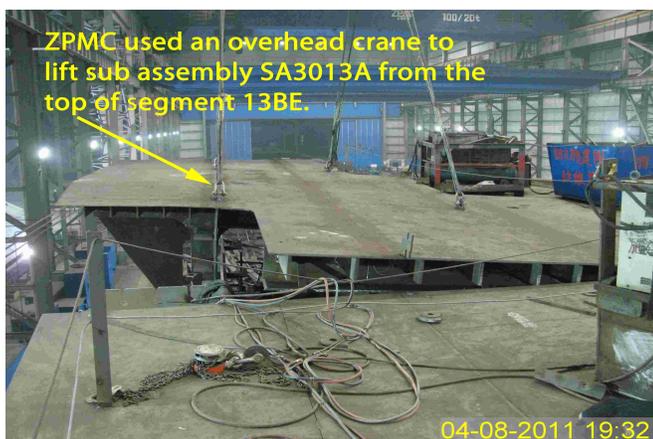
This QA Inspector observed a welding current of approximately 180 amps, the base material had been preheated with electric heaters and Mr. Wang Li appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder stencil 068091 used shielded metal arc welding procedure specification WPS-B-P-2213-TC-U4B-FCM-1 to make OBG segment 14E weld SEG3019D-1-008. This QA Inspector measured a welding current of approximately 170 amps and the base material had been preheated with electric heaters. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Yang Junping, stencil 501946 used shielded metal arc welding procedure WPS-B-P-2213-TC-U4B-FCM-1 to make OBG segment 14E weld DP3060-001-381. This QA Inspector observed a welding current of approximately 180 amps, the base material had been preheated with a torch and Mr. Yang Junping appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

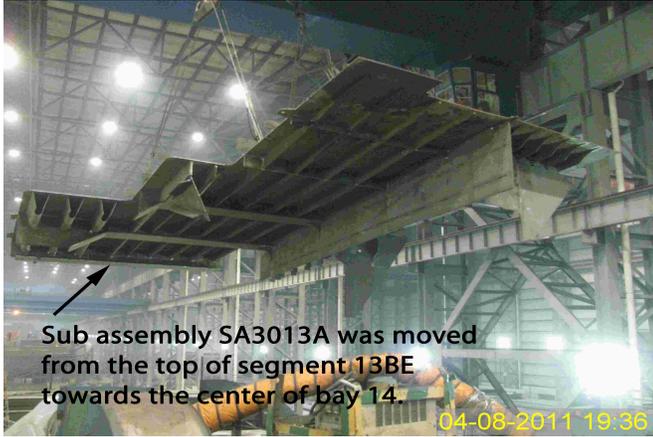
This QA Inspector observed ZPMC welder Mr. Zhu Jibo, stencil 055564 used flux cored welding procedure WPS-B-T-2233-ESAB to make OBG segment 14E weld DP3067-001-322. This QA Inspector measured a welding current of approximately 240 amps, 25.0 volts, the base materials were preheated with electrical heaters and Mr. Zhu Jibo 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 using an overhead crane to remove sub assembly SA3013A from the top of OBG segment 13BW and it was placed on temporary structural steel near the center of bay 14. See the photographs below for additional information.



WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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
