

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-022695**Date Inspected:** 07-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. Yang Yunfeng, stencil 215553 used shielded metal arc welding procedure WPS-B-P-2212-TC-U4B-FCM-1 to make OBG segment 14E weld SEG3019AA-003. This QA Inspector observed a welding current of approximately 175 amperes (amps) the base materials were preheated with electrical heaters 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 Jinjiu stencil 043661 used shielded metal arc welding procedure WPS-B-P-2212-TC-U4B-FCM-1 to make OBG segment 14E weld SEG3019AA-008. This QA Inspector observed a welding current of approximately 170 amps the base materials were preheated with electrical heaters and Mr. Wang Jinjiu appeared to be certified to make this weld. Items observed on this date appeared to

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

generally comply with applicable contract documents.

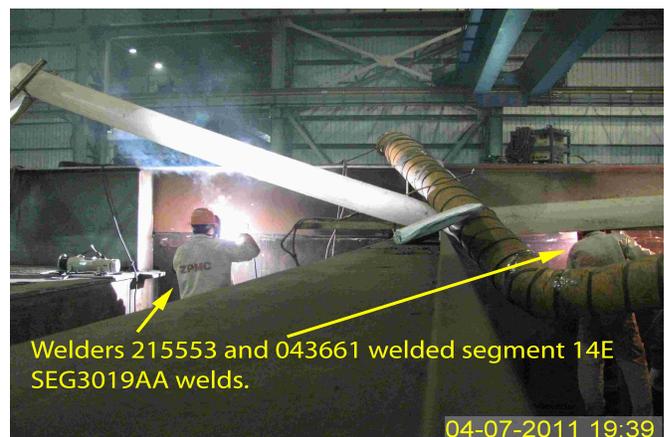
This QA Inspector observed ZPMC welder Mr. Wang Zhengbin, stencil 216086 used shielded metal arc welding procedure WPS-345-SMAW-4G(4F)-FCM-Repair -1 to make critical weld repairs to OBG segment 14E weld SEG3019BB-045. ZPMC QC informed this QA Inspector that weld repair document B-CWR-2917 documents this weld had been ultrasonically rejected. This QA Inspector observed a welding current of approximately 170 amps, the base materials were preheated with electrical heaters and Mr. Wang Zhengbin 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 welder Mr. Yang Juping, stencil 051946 used shielded metal arc welding procedure specification WPS-B-P-2212-TC-U4B-FCM-1 to make OBG segment 14E weld SEG3019Y-058. This QA Inspector observed a welding current of approximately 180 amps the base material had been preheated with electric heaters and Mr. Yang Juping 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 Linjiang stencil 051356 used flux cored welding procedure WPS-B-TC-2233-ESAB to make OBG segment 14E welds SEG3019F-015 and SEG3019G-015. This QA Inspector observed a welding current of approximately 310 amps and 27.0 volts and Mr. Wang Linjiang appeared to be certified to make his weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Wang Changfa, stencil 058102 used shielded metal arc welding procedure specification WPS-B-P-2212-TC-U4B-FCM-1 to make OBG segment 14E weld SEG3019BB-068. This QA Inspector observed a welding current of approximately 170 amps, the base material had been preheated with electric heaters and Mr. Wang Changfa 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 temporary bracing from the sides of OBG segment 13BW in preparation of moving this segment out of bay 14. See the photograph 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
