

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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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-022697**Date Inspected:** 05-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 Li, stencil 044772 used shielded metal arc welding procedure specification WPS-B-P-2212-T-U4B-FCM-1 to make OBG segment 14E weld SEG3019BB-156. This QA Inspector observed a welding current of approximately 180 amperes (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. See the photograph below for additional information.

This QA Inspector observed ZPMC welder Mr. Wang Changfa, stencil 058102 used shielded metal arc welding procedure specification WPS-B-P-2212-T-U4B-FCM-1 to make OBG segment 14E weld SEG3019BB-124. 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

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appeared to generally comply with applicable contract documents. See the photograph below for additional information.

This QA Inspector observed ZPMC welder Mr. Kuai Wenshan, stencil 054013 used shielded metal arc welding procedure WPS-B-P-2212-TC-U4B-FCM-1 to make OBG segment 14E weld SEG3019AB-008. This QA Inspector observed a welding current of approximately 190 amps the base materials were preheated with electrical heaters and Mr. Kuai Wenshan 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-2232-ESAB to make OBG segment 14E welds SEG3019E-1-009. This QA Inspector measured a welding current of approximately 300 amps, 27.0 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 welder Mr. Yang Junping, stencil 501946 used shielded metal arc welding procedure WPS-B-P-2112-FCM-1 to make OBG segment 14E weld SEG3019AA-003. 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. Wu Wanyong stencil 050242 used flux cored welding procedure WPS-B-T-2232-ESAB to make OBG segment 14E weld SEG3019D-1-009. This QA Inspector measured a welding current of approximately 250 amps, 24.0 volts, the base materials were preheated with electrical heaters and Mr. Wu Wanyong 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

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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.

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<b>Inspected By:</b>	Dawson,Paul	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley,Ken	QA Reviewer

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