

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-023144**Date Inspected:** 26-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. Wang Jun

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 Mr. Pu Junhua, stencil 067611 used shielded metal arc welding procedure specification WPS-345-SMAW-2G(2F)-FCM-Repair-1 to make repairs to traveler rail weld TR3027-TR2-001-011. ZPMC QC informed this QA Inspector that critical weld repair document B-CWR-2941 documents this weld had been ultrasonically rejected. The CWR document indicates this is the third time that ZPMC has repaired this weld. This QA Inspector observed a welding current of approximately 220 amperes (amps), the base material had been preheated with electric heaters and Mr. Pu Junhua 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. Pan Ming, stencil 066673 used shielded metal arc welding procedure specification WPS-345-SMAW-2G(2F)-FCM-Repair-1 to make repairs to traveler rail weld TR3007-TR1-001-012. ZPMC QC informed this QA Inspector that weld repair document B-WR-20786

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

documents this weld had been ultrasonically rejected.

This QA Inspector observed a welding current of approximately 225 amps, the base material had been preheated with electric heaters and Mr. Pan Ming 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 Mr. Li Shoufu, stencil 066674 used shielded metal arc welding procedure specification WPS-345-SMAW-2G(2F)-FCM-Repair-1 to make repairs to traveler rail weld TR3007-TR1-001-012. ZPMC QC informed this QA Inspector that weld repair document B-WR-20786 documents this weld had been ultrasonically rejected. This QA Inspector observed a welding current of approximately 225 amps, the base material had been preheated with electric heaters and Mr. Li Shoufu 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. Jiang Yang Sheng, stencil 045240 used flux cored welding procedure WPS-B-T-2233-ESAB to make splice plate welds X3305K-050-001 and 002. This QA Inspector observed a welding current of approximately 260 amps and 24.0 volts the base material had been preheated with electric heaters and Mr. Jiang Yang Sheng 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. Jian Junlin, stencil 067876 used flux cored welding procedure WPS-B-T-2233-ESAB to make splice plate welds X3305K-049-001 and 002. This QA Inspector observed a welding current of approximately 240 amps and 27.0 volts the base material had been preheated with electric heaters and Mr. Jian Junlin 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 workers dismantling scaffolding adjacent to OBG segment 14 East. ZPMC positioned five multi wheeled heavy hauling rigs underneath segment 14 East and it appears ZPMC will wait until dayshift to move the segment from Bay 14 to the trial assembly area. 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
