

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-023151**Date Inspected:** 28-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. Zhu Zhang Hai

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:

This QA Inspector observed ZPMC welder Mr. Wang Changfa, stencil 058102 had used shielded metal arc welding procedure specification WPS-345-SMAW-2G(2F)-FCM-Repair-1 to make repairs of OBG segment 13BE welds VP3007-001-05, 17, 30 & 43 SEG3019AH-003. ZPMC QC informed this QA Inspector that weld repair document B-WR-20767 documents these welds had been ultrasonically rejected. This QA Inspector observed 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 welder Mr. Wang Chang Ming, stencil 047864 used shielded metal arc procedure WPS-B-P-2211-TC-U4B-FCM-1 to make OBG segment 13BE weld SEG3019K-117. This QA Inspector observed Mr. Wang Chang 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 welder Mr. Li Shoufu, stencil 066674 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 segment 14W weld SEG3020AH-002. This QA Inspector observed 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. Wang Guijun, stencil 067275 used flux cored welding procedure WPS-B-T-2232-ESAB to make segment 14W weld SEG3020AH-002. This QA Inspector observed Mr. Wang Guijun appeared to be certified to make this weld and items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Liao Yanfei, stencil 066398 used shielded metal arc welding procedure specification WPS-B-P-2212-TC-U4B-FCM-1 to make segment 14W weld SEG3020AH-002. QA Inspector observed Mr. Liao Yanfei appeared to be certified to make this weld and items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Zhao Aifei, stencil 067942 SMAW had performed tack welding of a temporary alignment plate to the cross beam side of the joint between segments 13AE/13BE side plate/ bottom plate. ZPMC did not appear to have removed any of the paint where the tack welds had been made. This QA Inspector informed ZPMC CWI Mr. Zhu Zhong Hai about the lack of paint removal and he instructed the supervisor and workers to remove the paint where dayshift welders will deposit the rest of the weld. See the photographs below for additional information.

This QA Inspector observed ZPMC welder Mr. Wang Changfa, stencil 058102 had used shielded metal arc welding procedure specification WPS-345-SMAW-2G(2F)-FCM-Repair-1 to make repairs of OBG segment 13BE welds VP3007-001-05, 17, 30 & 43 SEG3019AH-003. ZPMC QC informed this QA Inspector that weld repair document B-WR-20767 documents these welds had been ultrasonically rejected. This QA Inspector observed 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 Quality Assurance Inspector performed documentation review of the NWIT system utilized by Caltrans METS. This QA Inspector has identified the Non-Destructive Testing (NDT) for each NWIT performed on the SFOBB in China at ZPMC facility. This includes UT, MT, and RT for each NDT Inspector. This information once it is compiled is sent to the corresponding Inspector and his/her Lead inspector for further documentation and review.

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