

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-024215**Date Inspected:** 04-Jun-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. An Qing Xing

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 Trial Assembly

This QA Inspector observed ZPMC welder Mr. Wang Rucheng, stencil 066881 used shielded metal arc welding procedure WPS-B-P-2214-TC-U4B-FCM-1 to make OBG segment 14W welds SEG3020Q-112 and 117. This QA Inspector observed a welding current of approximately 175 amperes (amps), the base material had been preheated with a torch and Mr. Wang Rucheng 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. Wang Guijun, stencil 067275 used shielded metal arc welding procedure WPS-345-SMAW-3G(3F)-Repair-1 to make OBG segment 14W weld repair SEG3020AG-006. ZPMC QC informed this QA Inspector that weld repair document B-WR-20428 documents repairs of this weld. This QA Inspector observed a welding current of approximately 150 amps the base material had been preheated with a torch and Mr. Wang Guijun 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 Chang Ming, stencil 047864 used shielded metal arc procedure WPS-B-P-2211-TC-U4B-FCM-1 to make segment 13AW weld SEG3013AH-098. This QA Inspector observed a welding current of approximately 230 amps the base material had been preheated with a torch and 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 procedure WPS-345-SMAW-2G(2F)-Repair-1 to make OBG segment 13AW weld SEG3013AH-076. ZPMC QC informed this QA Inspector that weld repair document B-WR-20703 documents repairs of this weld. This QA Inspector observed a welding current of approximately 230 amps the base material had been preheated with a torch 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.

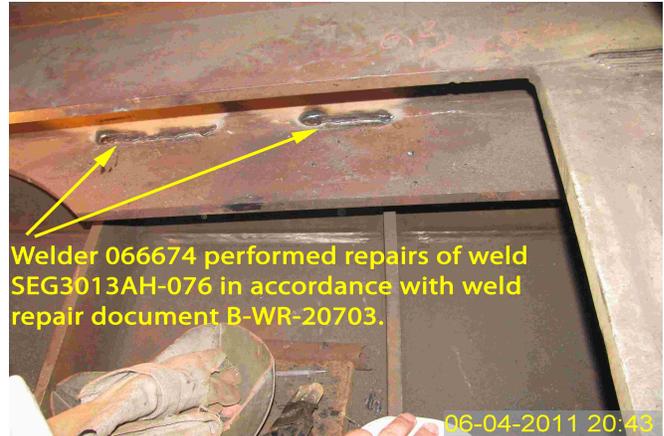
This QA Inspector observed ZPMC welder Mr. Jiang Junlin, stencil 067876 used flux cored welding procedure WPS-B-T-2232-ESAB to make OBG Segment 14W weld SEG3020L-015. This QA Inspector observed a welding current of approximately 275 amps, 26.0 volts, the base material had been preheated with a torch and Mr. Jiang Junlin 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. Huang Hongpei, stencil 037705 used flux cored welding procedure WPS-B-T-2232-ESAB to make OBG Segment 14W weld SEG3020L-015. This QA Inspector observed a welding current of approximately 320 amps, 26.5 volts, the base material had been preheated with a torch and Mr. Huang Hongpei 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. Xu Kesong, stencil 070009 used shielded metal arc welding procedure WPS-B-P-2214 to make segment 14W welds FB3329-001-095 and 096. This QA Inspector observed a welding current of approximately 160 amps the base material had been preheated with a torch and Mr. Xu Kesong appeared to be certified to make these welds. Items observed on this date appeared to generally comply with applicable contract documents.

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