

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-024740**Date Inspected:** 15-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: Li Ping

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:

Bay 14, OBG segment 14 West

Caltrans and ABF have agreed to conduct visual and magnetic particle inspections (MT) of segment 13AW welds as part of a special reinspection program reference NWIT# 9479. This QA Inspector observed ABF Inspectors completed and accepted MT inspections of welds: SEG3020V-021, 109, 110, 111, 114, 115, 116, 117, 118, 119, 120, 062, 064 and 066. This QA Inspector performed random magnetic particle inspection of welds SEG3020V-021, 109, 110, 111, 114, 115, 116, 117, 118, 119, 120, 062, 064 and 066 and these welds appear to comply with AWS D1.5 MT and visual requirements. For additional information on these inspections see this QA Inspector's TL6028 Magnetic Particle Test Report.

This QA Inspector observed ZPMC welder Mr. Yang Xing Long, stencil 068859 used shielded metal arc welding procedure WPS-B-P-2112-FCM-1 make weld repairs of magnetic particle rejections of various OBG segment 14W "L" shape splice plates SA3603B. This QA Inspector observed a welding current of approximately 180 amps, the base material had been preheated with a torch. Items observed on this date appeared to generally

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comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Wang Quanlin stencil 066746 used shielded metal arc welding procedure WPS-B-P-2112-FCM-1 make weld repairs of magnetic particle rejections of various OBG segment 14W "L" shape splice plates SA3603B. This QA Inspector observed a welding current of approximately 170 amps, the base material had been preheated with a torch. Items observed on this date appeared to generally comply with applicable contract documents.

SPMC blast shop, OBG segment 13 West

Visual Inspections of segment 13CE

ZPMC requested Caltrans personnel to perform visual inspections of OBG segment 13CE between PP123~124.5 on the cross beam side upper surfaces between longitudinal diaphragm LD3025A and the edge plate at around 22:00 hours following the initial pre-blast cleaning of the steel surfaces. This QA Inspector along with one other QA Inspector performed random visual inspections of these areas and observed approximately fifty areas that require grinding and no areas that require weld repairs. Several ZPMC workers used electric grinders to blend the areas that had been marked by ABF and QA Inspectors

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
