

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-025330**Date Inspected:** 21-Jul-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:**

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 using shielded metal arc welding procedure specification WPS-B-P-2213-TC-U4B-FCM-1 to make segment 13CE weld SEG3011Z-261. This QA Inspector observed Mr. Wang Changfa appeared to be certified to make these weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Zhou Bin, stencil 067947 used shielded metal arc welding procedure WPS-B-T-4214TC-U4B-1 to make OBG segment 13W weld DP3126-001-101. This QA Inspector observed Mr. Zhou Bin 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. Zang Yan Bu, stencil used shielded metal arc welding procedure WPS-B-T-4214TC-U4B-1 to make OBG segment 13W weld DP3126-001-102. This QA Inspector observed Mr. Zang Yan Bu 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. Lv Feng Bao, stencil 045175 used flux cored welding procedure

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WPS-B-T-2231T-ESAB to make welds SA3154-001~012-005 and 007. This QA Inspector observed Mr. Lv Feng Bao 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 stencil 204730 used flux cored welding procedure WPS-B-T-2231T-ESAB to make welds SA3154-001~012-005 and 007. This QA Inspector observed this welder appeared to be certified to make these welds. Items observed on this date appeared to generally comply with applicable contract documents.



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 Eric Tsang phone: 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
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Reviewed By:	Riley,Ken	QA Reviewer
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