

**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-025647**Date Inspected:** 29-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:** Mr. Li Ping**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:

Caltrans and ABF have agreed to conduct visual and magnetic particle inspections (MT) of segment 13 West welds as part of a special inspection program reference NWIT number 9840. This QA Inspector observed ABF Inspectors had completed and accepted MT inspections of welds: SEG3013B-261, 262 and 263. ABF Inspectors rejected weld SEG3013B-260. This QA Inspector performed random visual and magnetic particle inspection of welds: SEG3013B-261, 262, 263 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 and the photograph below.

This QA Inspector observed ZPMC welder Mr. Yang Junping, stencil 501946 used shielded metal arc welding procedure WPS-B-P-2112-FCM-1 to make OBG segment 13AE welds SA3013-274 and 275. This QA Inspector observed Mr. Yang Junping 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 Jin Jiu stencil 043691 used shielded metal arc welding procedure WPS-B-P-2213-TC-U4B-FCM-1 to make OBG segment 13AE weld SA3013-436. This QA Inspector observed Mr. Wang Jin Jiu appeared to be certified to make this weld. Items observed on this date appeared to

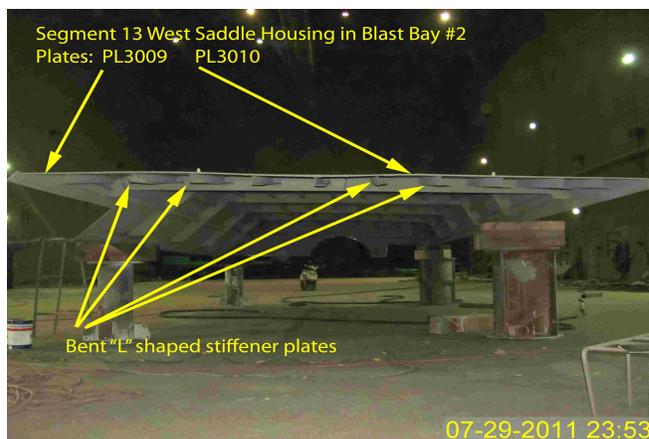
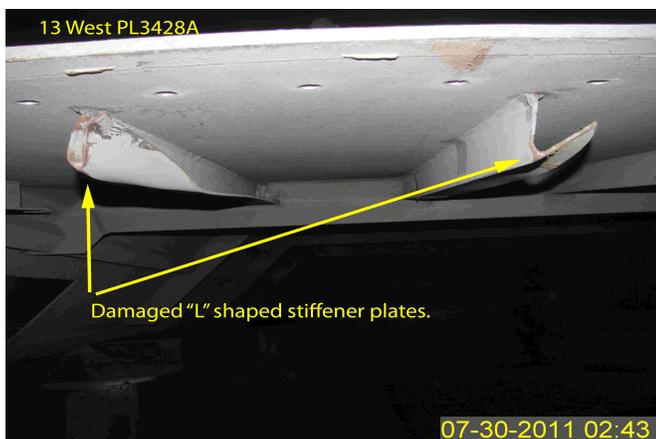
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generally comply with applicable contract documents.

Caltrans QA Inspector Mr. Kenneth Cason informed this QA Inspector that ZPMC has placed OBG segment 13 West Saddle Housing plates PL3427A and PL3428A in blast bay #2 and that several of the “L” shaped stiffener plates appear to have been damaged during handling of this assembly. This QA Inspector visually observed several stiffener plates on the saddle housing have been bent out of shape and this QA Inspector issued an incident report to document this problem. See the description and photographs below for additional information.

- The saddle housing plates are shown on drawings SH3009 and SH3010.
- The “L” shape stiffeners are identified as X7548E.
- Four different “L” shaped stiffener plates have been damaged, two on PL3427A and two on PL3428A.
- These stiffeners are welded to plates PL3427A (SH3009) and PL3428A (SH3010)
- These materials are identified as Non-Seismic Performance Critical Members (SPCM).
- These materials are located in blast bay #2.



## 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

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Materials for your project.

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<b>Inspected By:</b>	Dawson,Paul	Quality Assurance Inspector
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<b>Reviewed By:</b>	Riley,Ken	QA Reviewer
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