

**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-025660**Date Inspected:** 14-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:**

CWI Inspector: Mr. Sun Tian Liang

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:

**Trial Assembly**

This QA Inspector observed ZPMC welder Mr. Feng Hua Jun, stencil 066258 used shielded metal arc welding procedure WPS-345-SMAW-3G(3F)-FCM-Repair-1 to make a weld repair of ultrasonic rejections to OBG segment 13CW weld SEG3015B-207. ZPMC CWI Mr. Sun Tian Liang informed this QA Inspector that he did not know what weld repair document had been issued for the repair of this weld. This QA Inspector observed ZPMC QC measuring a welding current of approximately 150 amps and the base materials had been preheated with a torch. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Jiang Jingong, stencil 066361 used shielded metal arc welding procedure WPS-345-SMAW-3G(3F)-FCM-Repair-1 to make a weld repair of ultrasonic rejections to OBG segment 13CW weld SEG3015B-195. ZPMC CWI Mr. Sun Tian Liang informed this QA Inspector that he did not know what weld repair document had been issued for the repair of this weld. This QA Inspector observed ZPMC QC measuring a welding current of approximately 140 amps and the base materials had been preheated

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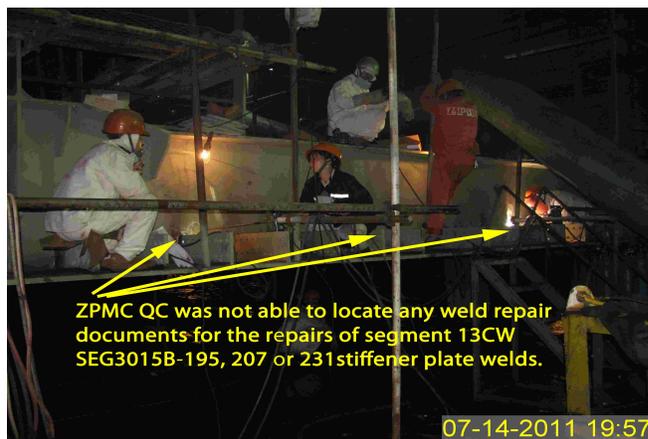
with a torch. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Liao Yanfei, stencil 066398 used shielded metal arc welding procedure WPS-345-SMAW-3G(3F)-FCM-Repair-1 to make a weld repair of ultrasonic rejections to OBG segment 13CW weld SEG3015B-231. ZPMC CWI Mr. Sun Tian Liang informed this QA Inspector that he did not know what weld repair document had been issued for the repair of this weld. This QA Inspector observed ZPMC QC measuring a welding current of approximately 150 amps and the base materials had been preheated with a torch. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Du Hengyou, stencil 067571 used shielded metal arc welding procedure WPS-B-P-2214-FCM-1 to make OBG segment 13E weld VP3015U-001-010. This QA Inspector observed the base materials were preheated with a torch and Mr. Du Hengyou 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 stencil 066326 used shielded metal arc welding procedure WPS-B-P-2214-FCM-1 to make OBG segment 13E weld VP3015U-001-032. This QA Inspector observed the base materials were preheated with a torch. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Niu Duojun, stencil 037932 used shielded metal arc welding procedure WPS-B-P-2213-C-U4B-FCM-1 to make OBG segment 13E weld SA3231D-001-020. This QA Inspector observed the base materials were preheated with a torch and Mr. Niu Duojun appeared to be certified to make this weld. 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.

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

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