

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-026072**Date Inspected:** 18-Aug-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Zhang Qi Li**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 Quality Assurance Inspector (QA) reviewed contract documents, including Caltrans Special Provisions, project plans, contract change orders, nondestructive testing (NDE) calibration data and performed NDE equipment maintenance.

Bay 16

This QA Inspector observed ZPMC personnel had recently completed heat straightening of various OBG segment handrails. Items observed on this date appeared to generally comply with applicable contract documents. See the photograph below for additional information.

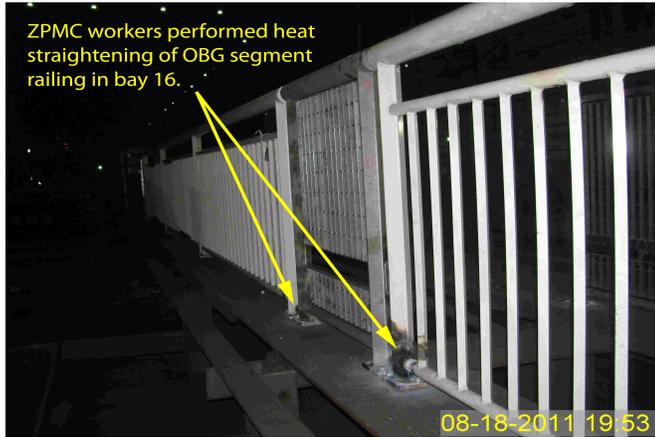
Bay 19

This QA Inspector observed ZPMC welder Mr. Shao Wen Lin, stencil 259629 had recently used shielded metal arc welding process to make bikepath BK9003 tack weld BK3009AA-021 between plate BKPL9035A and the edge plate. This QA Inspector observed Mr. Shao Wen Lin appeared to be certified to make this weld, the welding electrodes were stored in a portable electrode storage container that was connected to an electrical power supply

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and the electrodes were warm to the touch. Items observed on this date appeared to generally comply with applicable contract documents. See the photograph below for additional information.



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

Reviewed By: Riley,Ken

QA Reviewer
