

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: 13.9/14.3,0.0/1.6File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000808**Date Inspected:** 07-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sha Zhi**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:** Mock Up**Summary of Items Observed:**

Elevation 89M:

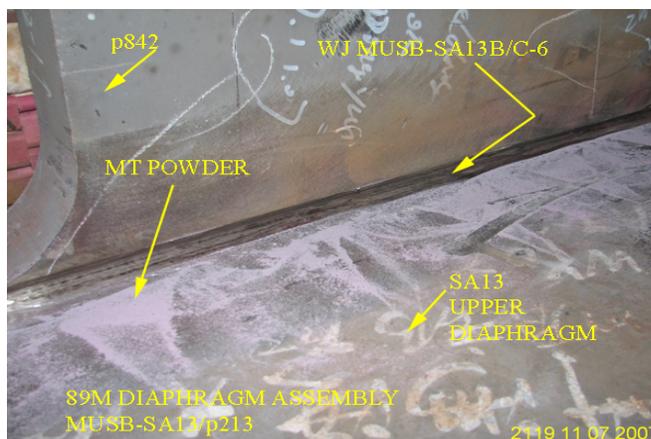
The QA Inspector was present at the time requested to randomly observe welding and associated operations for the fabrication of the Tower Mock Up.

The QA Inspector randomly observed ZPMC helpers utilizing grinders to blend the root passes in Weld Joint (WJ) Numbers MUSB-SA13B/C-1, 2, 5, 6, 13, 14, 17 and 18, on 89M Diaphragm Assembly MUSB-SA13/p213. The following photographs provide additional detail.

The QA Inspector randomly observed ZPMC Non Destructive Technicians Cai Xin Xin and Zhou Dongyun, performing Magnetic Particle Testing (MT), to examine 100% of the full lengths of the root passes in WJ's MUSB-SA13B/C-1, 2, 5, 6, 13, 14, 17 and 18, on 89M Diaphragm Assembly MUSB-SA13/p213. The QA Inspector performed a 20% random MT examination of the above welds. There appeared to be no indications and ZPMC QC accepted the MT of WJ's MUSB-SA13B/C-1, 2, 5, 6, 13, 14, 17 and 18. The following photographs provide additional detail.

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Summary of Conversations:

There were no relevant conversations.

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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Franco,Charlie

Quality Assurance Inspector

Reviewed By: Cochran,Jim

QA Reviewer