

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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001418**Date Inspected:** 11-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Xu Jun**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:** Tower mock-ups/OBG**Summary of Items Observed:**

This Quality Assurance (QA) Inspector arrived at ZMPC for observation and orientation of the Self Anchored Suspension Tower (SAS) fabrication. Task Leader Jimmy Cochran spoke with the QA Inspector in regards to the general construction and fabrication sequence being performed at ZMPC along with any outstanding issues that are associated with the fabrication process as of this date. Mr. Cochran provided a tour of tower shop and bays 1, 2, 3, 4 and 7 at the ZMPC facility with a general overview of each location that included stage of fabrication, mock ups and issues associated with these locations. This QA inspector was given information as to safety concerns and safe practices with the fabrication process and what to watch for during observations of the SAS fabrication for safety. The special provisions were discussed for the project at ZMPC and Welding Procedure Specifications WPS as to their locations on the shop floors. During the QA Inspectors observation in bay 2 (tower bay) the QA Inspector observed high strength plates identified as A709-HPS-485-WT2 staged next to the burn tables (no welding was taking place at this location) it was observed that ZMPC was using die stamps for identification of the material and according to AWS D1.5 section 12.4.6 Base Metal Identification – When heat numbers and other identification markings are applied by die stamping, low-stressing dies shall be used. On high strength material this is to help with reducing stress risers in the part. At this time it is unclear if the stamps used are low stress dies and further information shall be needed for determination. The QA inspector was introduced to METS personnel onsite and there subsequent roles to the project.

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Summary of Conversations:

orientation with Task Leader Jimmy Cochran conversations were in regards to the SAS fabrication process.

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:	Riley, Ken	Quality Assurance Inspector
Reviewed By:	Cochran, Jim	QA Reviewer
