

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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001507**Date Inspected:** 06-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Xu Le Feng, Ye Yong Jun, Sha Zi Cui, Wu Jie, Qian			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 and OBG**Summary of Items Observed:**

The Quality Assurance (QA) Inspector Gregory Bertlesman arrived on site at the Zhenhua Port Machinery Company facility on Changxing island, China to periodically monitor welding and Quality Control functions. While on site the Quality Assurance Inspector observed and/or discovered the following.

Tower Fabrication Facility

The Quality Assurance Inspector observed no ZPMC personnel working in the Tower Fabrication Facility.

Bay 2

The Quality Assurance Inspector observed ZPMC performing cutting operations on their cutting table. ZPMC Quality Control relayed they were utilizing a natural gas and oxygen mix. ZPMC was cutting diaphragm plate Sa126 for the 13M elevation.

Bay 3

The Quality Assurance Inspector observed ZPMC welding operators with welder identification numbers, 48801, 049775, and 053724 performing in process welding of stiffeners to side plate SP63. Quality Control Inspector Ye Yong Jun was monitoring the welders. The welder was using the flux cored arc welding process to produce the fillet weld in the horizontal position. The part was fixed while the multiple welding gantry system is on tracks to facilitate welding along the length of the part. The Quality Assurance Inspector measured the welding parameters at the welders station and found the parameters to meet the minimum requirements of welding procedure specification WPS-B-T-2132-3. The Quality Assurance Inspector measured the amperage at approximately 300, the voltage at approximately 30, and the travel speed at approximately 445 millimeters per minute. The Quality

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Assurance Inspector witnessed Quality Control measuring the interpass temperature using a calibrated infra-red temperature measuring device.

Bay 7 and 8

The Quality Assurance Inspector observed no ZPMC personnel working in bays 7 and 8.

Summary of Conversations:

As stated in the contents of the above report.

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:	Bertlesman,Greg	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
