

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-001747**Date Inspected:** 06-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le Feng, Ye Yong 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 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.

Deck Panel Visual Inspection

The Quality Assurance Inspector performed visual inspection to Deck Panels DP-040-001. Typical discontinuities marked include but are not limited to, were overlap, undercut, under fill, and incomplete fusion. The Quality Assurance Inspector recorded all the indications lengths and y axis locations in an on site log and forwarded to Assistant Structures Material Representative Ady Valasco for review. Upon completion of the examination ABF several ABF representatives performed visual inspection. The Quality Assurance Inspector witnessed numerous indications marked by the Quality Assurance that were discounted by the ABF representatives. In addition the Quality Assurance Inspector observed ABF marking the lengths of other indications without using any suitable gauges.

The Quality Assurance Inspector observed the production welding of Deck Panel DP-066-001 and DP-041-001, partial joint penetration welds located in Bay #1. ZPMC was observed performing gas metal arc welding (GMAW) for the root pass and submerged arc welding (SAW) for the cover pass, on gantry machine number 2. The Quality Assurance Inspector measured the welding parameters at the welder's station and found the parameters to meet the minimum requirements of the welding procedure specification Dual process WPS-B-T-2342-U1 (U-rib)-3. Below is a digital photograph illustrating the use of a transit to measure the amount of camber in the Deck Panel prior to welding. The Parameters and welders were recorded in an on site for future review.

WELDING INSPECTION REPORT

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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
