

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-003066**Date Inspected:** 05-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**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:** Chen Xi / Zhao Chen Sun**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 / OBG**Summary of Items Observed:**

Bay 1

This Quality Assurance (QA) inspector arrived at ZPMC in Shanghai China for observation of Orthotropic Bridge Girders (OBG) and Self Anchored Suspension (SAS) Bridge. During this QA inspector's general observation in bay 1 for OBG deck panels it was noted that ZPMC was welding on gantry 1 for DP609-001 with Gas Metal Arc Welding (GMAW) and Submerged Arc Welding (SAW) processes. This QA inspector spoke with ZPMC's CWI Cheng Xi pertaining to the new deck panel criteria for the PMT. It was relayed that his leaders informed him that out of the 800mm sections ZPMC could choose any 500mm inspection area which is in conflict with new criteria which stated that the last 500mm welded area of the PMT shall be used for the inspection area.

Bay 4

During the continued observation by this QA inspector it was noted in bay 4 that ZPMC was welding on diaphragm plate splice for component number NSD1-SA261-1&2A ZPMC CWI Zhao Chen Sun was present within this bay monitoring welding progression and parameters for the Submerged Arc Welding (SAW) process on the diaphragm plate splices under WPS-B-T-3221-B-U3c-S-1 and Flux Cored Arc Welding (FCAW) process for the internal flange rings for the diaphragm plates under WPS-B-T-2233-B-U3-F. Welder for these components were Xin Meng (SAW) and Shi Yan Hao (FCAW)

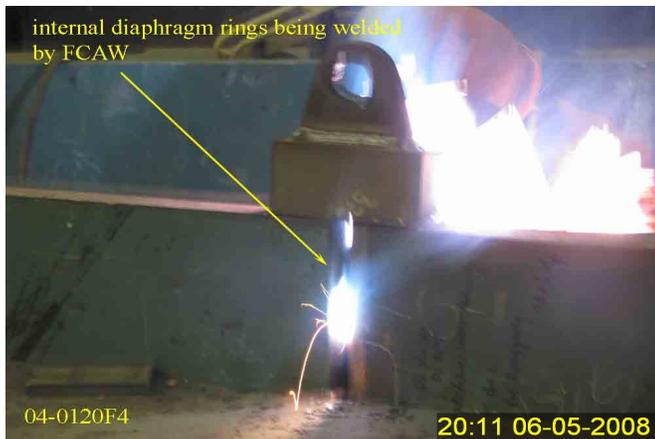
Bay 7

This QA inspector observed ZPMC in bay 7 performing Submerged Arc Welding (SAW) process on web plate for FB035-001-079 under WPS-B-T-2221-B-L2c-S-1 with welding operator Huang Xing Lan. It was noted in this bay that ZPMC was grinding back gouged CJP weldments on multiple web plates. Fit - up was in process on FB015-011 weld number 001 & 009 under WPS-B-T-2132-3 with welder Liu Long Xian. Also noted was ZPMC personnel was welding on built up I beams for FB006-034. ZPMC's CWI Hu Wei Qing was present during the

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welding operations in this bay and monitoring welding parameters and in process progression



Summary of Conversations:

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

Inspected By:	Riley, Ken	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
