

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-003168**Date Inspected:** 25-Jun-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:** Sun Wei**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**Summary of Items Observed:**

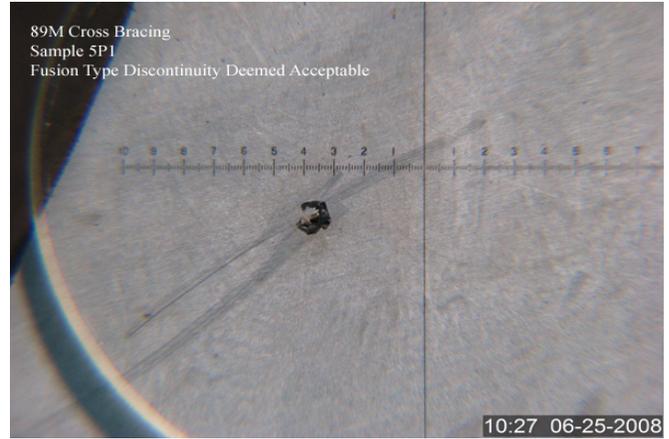
The Quality Assurance (QA) Inspector Gregory Bertlesman arrived on site at the Zhenhua Port Machinery Company facility on Changxing island, China to periodically monitor welding and Quality Control functions. While on site the Quality Assurance Inspector observed and/or discovered the following.

89M Tower Mock-up Cross Bracing Macro Etch Evaluation

The Quality Assurance Inspector performed a review of the 89M Tower Mock-up cross brace macro samples. There were three samples of fillet welds and three samples of partial joint penetration weld. ABF Quality Control Inspector Xie Ping and ABF Representative Mike Williams evaluated the samples and stated that all samples comply with the contract documents. The Quality Assurance Inspector observed an inclusion which according to the American Welding Society is fusion type discontinuity which is non-compliant. ABF and ZPMC did not agree with the Quality Assurance Inspectors findings. Assistant Structures Representative Josh Ishibashi was informed of the findings who in turn notified Mr. Jim Merrill. It was relayed that Mr. Merrill stated that as long as the inclusion was 3 millimeters or less in length it would be acceptable. Below are digital photographs illustrating some of the sample with the inclusion and a fillet weld sample.

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 Josh Ishibashi (707) 552 7715, who represents the Office of Structural Materials for your project.

Inspected By:	Bertlesman,Greg	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
