

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-003630**Date Inspected:** 14-Aug-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:** Zhu Zhong Hai**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:** skin plates and stiffeners**Summary of Items Observed:**

Tower Shop – Bay 1

QA Inspector observed approximately 110 ZPMC workers performing the following: SAW of weld NSD1-SA176A/H-74A skin plate butt joint; fit-up and tack welding of stiffeners to skin plate SSD1-B; fit-up and tack welding of stiffeners to skin plate SSD1-E; preheating and tack welding of stiffeners to skin plates; UT on other stiffener to skin plate welds; heat straightening; paint removal and layout marking for fit-up of stiffeners on skin plate; and FCAW-G of skin stiffener butt welds. ZPMC CWI Xu Le Feng and ABF QC C.K. Chan were also present.

Tower Shop – Bay 2

QA Inspector observed approximately 55 ZPMC workers performing the following: preheating and tacking of skin stiffeners to skin plate B using FCAW-G; D-3 stiffener butt weld using SAW; heat straightening of stiffener plates; UT on stiffener to skin plate A welds. Also present were ZPMC CWI An Qing Xiang and ABF QC Xing Xiao Guang.

WELDING INSPECTION REPORT

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Summary of Conversations:

No significant conversations on this date.

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 Joshua Ishibashi, 136-6471-0411, who represents the Office of Structural Materials for your project.

Inspected By: Goulet, George

Quality Assurance Inspector

Reviewed By: Carreon, Albert

QA Reviewer