

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-004015**Date Inspected:** 09-Sep-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 / 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 plate assembly	

Summary of Items Observed:

Tower shop - Bay 1

QA Inspector randomly observed approximately 65 ZPMC workers performing the following: flame heat straightening and flame cutting of beveled edge on plates; SAW of SSD1-SA17A/D-4B; FCAW-G, manual and automatic using gantry, of fill pass of stiffener to SSD1 – skin C assembly; flame heat straightening of welded stiffeners and grinding of cover pass on stiffener to SSD1 – skin A assembly; grinding of cover pass on stiffener to SSD1 – skin E assembly. Also present in this bay were ZPMC CAWI Liu Dao Feng and ZPMC CWI Xu Le Feng as well as ABF QC's Yang Yi Heng, Li Nan, C. K. Chan, and Zhang Qian Jian. Items observed appeared to comply with project specifications.

Tower shop - Bay 2

QA Inspector randomly observed approximately 50 ZPMC workers performing the following: grinding of cover pass of stiffeners on ESD1 – skin D; ZPMC UT of stiffeners to ESD1 – skin E cover passes; air-arcing of approximately 70mm x 120mm half-round holes in stiffeners at the skin plate on ESD1 – skin E assembly; grinding of tacks of stiffener to ESD1 – skin C; SMAW tacks of stiffeners to approximate 2400mm x 2400mm ESD1 – skin plate D; heat straightening of skin plate; grinding of SAW weld in skin plates. Also present in this bay were ZPMC CWI Zhu Zhong Hai and ABF QC Zhang Da Ming and C.K. Chan. Items observed appeared to comply with project specifications.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

No significant conversations 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