

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-004017**Date Inspected:** 11-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:** Li Yang, Guo Yan Fei**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:** 89M mockup, tower skin assemblies, deck panels**Summary of Items Observed:**

89M Tower Mockup

Caltrans Quality Assurance Inspector George Goulet (QA Inspector) observed red iron powder remaining from MT showing cracks in a fit lug to tower diaphragm weld on the 89M Tower Mockup. ABF Engineer Gene Rosamillia (ABFE) informed QA Inspector that ABFE would notify QA Inspector when ZPMC was ready to proceed on this issue.

Tower shop - Bay 1

QA Inspector randomly observed approximately 55 ZPMC workers performing the following: flame heat straightening of plates; shaping by grinding of 75mm radius area in corner of two stiffener plates filled in with weld metal; FCAW-G of stiffener to SSD1 – B lap assembly (approximately 2400mm square) fill pass in the tilted up position; FCAW-G automatic, with four welders on each of two gantries, of stiffener to SSD1 – skin C assembly; SAW of welds NSD1-SA76G/H-5 (PJP) and NSD1-SA76F/H-7A (CJP); preparation for FCAW-G of stiffener to SSD1–D assembly by installing electric heating pads. Also present in this bay were ZPMC QC's Fu Yuhong and Wang Lu, and ZPMC CWI Li Yang as well as ABF QC's Yang Yi Heng and Zhang Qin Jian. Items observed appeared to comply with project specifications.

Tower shop - Bay 2

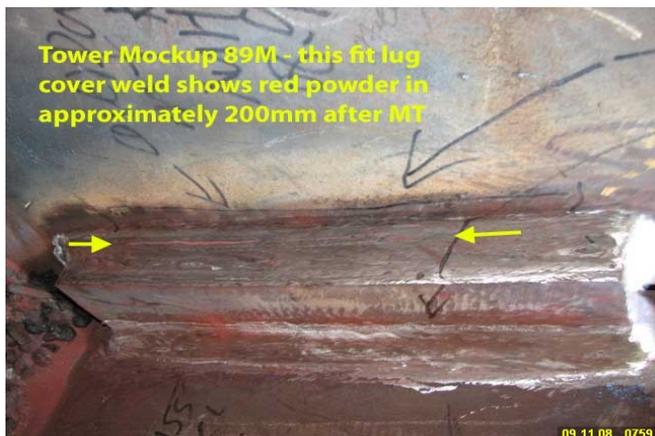
QA Inspector randomly observed approximately 30 ZPMC workers performing the following: application of electric heating pads in preparation for a critical repair of stiffeners to ESD1 skin A assembly as well as restraining jacks in place between stiffeners. Also present in this bay were ZPMC CWI Guo Yan Fei and ABF QC Zhang Da Ming. Items observed appeared to comply with project specifications.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Heavy Duty Machine Shop – Bay 3

QA Inspector randomly observed 6 ZPMC workers performing the following: grinding of U-rib to deck panel welds on DP553-001, DP567-001, DP542-001, and DP543-001. There were 20 full size panels, 2 half size panels, and several unidentified deck plates in various stages of butt welding present in the bay. QA Inspector observed no welding being performed. Also present in this bay were ABF QC's Ding Bao Hua and Wang Zhong Yuan. Items observed appeared to comply with project specification.



Summary of Conversations:

ABF QC Zhang Da Ming informed QA Inspector that ZPMC was preparing to perform the repair of stiffeners to ESD1-skin A assembly welds, that he was aware of the preheat and interpass temperature requirements, and he was prepared to monitor the welding for those and other requirements.

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