

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-004020**Date Inspected:** 15-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, Jiang Jian 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:** tower skin assemblies, deck panels**Summary of Items Observed:**

Tower shop - Bay 1

QA Inspector randomly observed approximately 45 ZPMC workers performing the following: flame heat straightening and grinding of skin plate butt weld; electric preheat and FCAW-G fill pass of stiffener to SSD1-E lap assembly in the tilted up position; heat straightening of stiffener on SSD1-A assembly using two 10 ton dead weights and four oxy-fuel torches; grinding cover welds and oxy-fuel cutting of approximate 120mm x 70mm holes in stiffeners and FCAW-G of stiffeners to SSD1-C; FCAW-G manual (2) and automatic fill passes with four welders on northwest gantry on stiffener to SSD1-skin D assembly; moving of SSD1-B assembly from a tilted up position to a flat position on the weld table. Also present in this bay were ZPMC CWI's Zhu Zhong and 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 45 ZPMC workers performing the following: manual and automatic fill passes with four welders each on both southeast and southwest gentries on stiffener to ESD1-skin C assembly; electric heat straightening, per ABF QC Xing Xiao Fei, on skin plate ESD1-A assembly; grinding of cover pass on stiffener to ESD1-B assembly; grinding of tack welds on stiffener to ESD1-B lap assembly. Also present in this bay were ZPMC CWI Jiang Jian Fei as well as ABF QC's Zhong Da Ming, and Luo Lai Quan. Items observed appeared to comply with project specifications.

Heavy Duty Machine Shop – Bay 3

QA Inspector randomly observed no ZPMC workers in this bay. 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. Items observed appeared to comply with project specifications.

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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
