

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-004333**Date Inspected:** 30-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:	Zhi Neng Zhang, Sun 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:** tower skin assemblies and deck plates & panels**Summary of Items Observed:**

Tower shop - Bay 1

QA Inspector randomly observed approximately 80 ZPMC workers performing the following: SAW of a plate butt welds; grinding of butt weld cover pass on skin plates; FCAW-G of bracing holes in skin plate on SSD1 – skin E assembly. The buttering was being performed per WPS-345-FCAW-3G(3F)-repair per ABF QC Kim Xiao. Also present in this bay were ZPMC CWI's Zhi Neng Zhang and Jicheng Zou as well as ABF QC's Li Nan and Kim Xiao. Items observed appeared to comply with project specifications.

Tower shop - Bay 2

QA Inspector randomly observed approximately 60 ZPMC workers performing the following: flame cutting of beveled edges; SAW butt welds of skin plates; grinding and ZPMC MT of repairs of indications on stiffeners on ESD1-skin E assembly; electric preheating of stiffener/skin area on ESD1-A lap assembly. Also present in this bay was ABF QC Li Hong Fei as well as ABF QC Luo Lai Quan. Items observed appeared to comply with project specifications.

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 DP546-001 and DP581-001. There were 15 full size panels and several unidentified deck plates in various stages of butt welding present in the bay. Also present in this bay were ZPMC CWI's Sun Yan Fei and Li Yan Hua as well as ABF QC's Kevin Chen and Wang Zhong Yuan. Items observed appeared to comply with project specification.

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
