

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-004647**Date Inspected:** 19-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Wei**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 and OBG**Summary of Items Observed:**

The Quality Assurance (QA) Inspector Gregory Bertlesman arrived on site at the Zhenhua Port Machinery Company facility on Changxing island, China to periodically monitor welding and Quality Control functions. While on site the Quality Assurance Inspector observed and/or discovered the following.

Confined Space Safety Training

The Quality Assurance Inspector attended a confined space safety training session. The Quality Assurance Inspectors are still not approved to enter the confined spaces until further notice.

Deck Panel Visual Inspection

The Quality Assurance Inspector was informed that ZPMC and ABF have completed visual inspection of three deck panels identified as DP-494-001, DP-144-001, and DP-112-001. The Quality Assurance Inspector performed a random visual verification of the three deck panels and it was observed ZPMC was continuing to grind the base metal of the rib at the vertical toe of the weld in an effort to blend undercut and underfill with the base metal. Quality Assurance Inspectors have been instructed to not find the repair non compliant if the depth of the grinding does not exceed 1mm even though AWS D1.5 states undercut shall be repaired by welding. The Quality Assurance Inspector did not observe and grinding exceeding 1mm and signed the three party ABF yellow tracking tag.

Summary of Conversations:

As stated in the contents of the above report.

Comments

WELDING INSPECTION REPORT

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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 Josh Ishibashi 1.376.647.10411, who represents the Office of Structural Materials for your project.

Inspected By:	Bertlesman,Greg	Quality Assurance Inspector
Reviewed By:	Wright,Mark	QA Reviewer
