

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-000928**Date Inspected:** 17-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Lefang & Lee Chan Woo**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:** 89, 114 & OBG Mock-Ups**Summary of Items Observed:**

Mock-Up 89

This Quality Assurance Inspector observed ZPMC Magnetic Particle Technician Zhou Dong Yun performing magnetic particle testing on MUSB-MA38A/B Skin Plate Sub-Assembly (Face 'E'). Testing was performed on partial joint penetration longitudinal stiffener tack welds 1 through 4 and 11 through 14. All tack welds were found acceptable by Mr. Zhou. Quality Assurance performed 10% verification magnetic particle testing on these same welds upon completion by ZMPC. For details please see magnetic particle testing report TL-6028 dated November 17, 2007.

Mock-Up 114

This Quality Assurance Inspector observed welding by ZPMC welder Chang Chuancang, welder identification 053870 using the flux cored arc welding process in the flat position. Welding was being carried out on MUSC A67. Some of the essential welding variables were checked and found the voltage to be 31, the amperage 215, the travel speed was 295 millimeter per minute and the pre-heat 115 degrees Celsius.

OBG

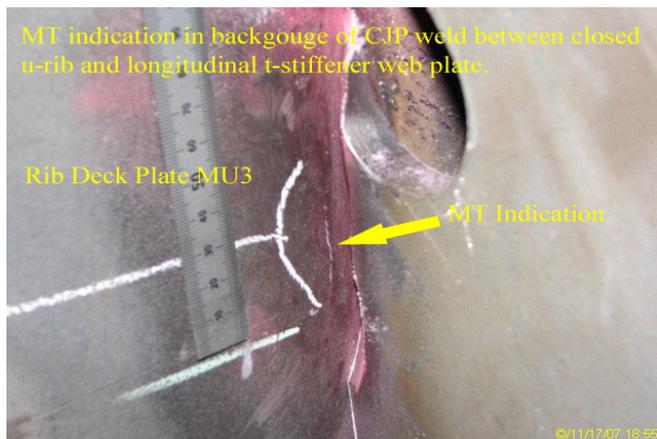
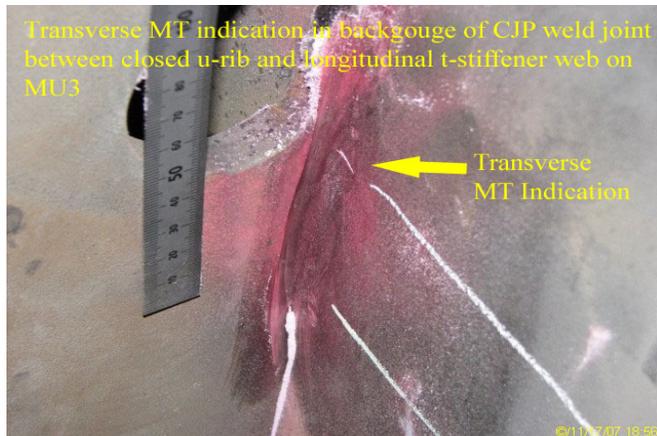
This Quality Assurance Inspector observed ZPMC Magnetic Particle Technician Zhou Dong Yun performing magnetic particle testing on MU3 Closed U-Rib Deck Plate. Testing was performed on the back gouge excavation of the complete joint penetration welds between the closed u-ribs and the longitudinal T-stiffeners. A number of

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welds had indications which were all removed and re-testing with the magnetic particle testing method. Quality Assurance performed 10% verification magnetic particle testing on these same welds upon completion by ZMPC. For details please see magnetic particle testing report TL-6028 dated November 17, 2007.

This Quality Assurance Inspector was shown a cracked tack weld in BP002-01-001 between plates 34B and 34A SPCM by ZPMC Quality Assurance Inspector Shen Xue Jun. The tack weld was removed and a new tack weld put in next to the old location.



Summary of Conversations:

No conversations held today.

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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Berger, Bruce

Quality Assurance Inspector

Reviewed By: Cochran, Jim

QA Reviewer
