

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-000949**Date Inspected:** 22-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:** See Below**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:** OBG, 89 & 114 Meter Mock-Up**Summary of Items Observed:**

CWI Names: Lee Chan Woo, Lu Jian Ping, Fu Guo Gang, Xu Lefeng

PQR's

This Quality Assurance Inspector viewed the macro etch test pieces from procedure qualification test HP2007259. Lot number B72-085-07 as assigned to the paper work for this inspection.

Mock-Up 77

This Quality Assurance Inspector witnessed Li Li Ming and E Shui Qing performing ultrasonic testing on repairs made to the 77 Meter Mock-Up MUSA-MA2 Face A Plate Sub-Assembly, complete joint penetrations, weld numbers 1 & 2. Weld joints were found unacceptable by the two ultrasonic technicians due to two separate defects.

Mock-Up 89

This Quality Assurance Inspector witnessed Zhuo Dong Yin, ZPMC Magnetic Particle Technician performing testing on MUSB MA23 Face C Skin Plate Sub-Assembly tack welds.

Mock-Up 114

This Quality Assurance Inspector witnessed Li Li Ming and E Shui Qing performing ultrasonic testing on repairs

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made to the 114 Meter Mock-Up MUSC-MA109 Face E Skin Plate Sub-Assembly, complete joint penetration, weld numbers 3. This weld joint were found acceptable by the two ultrasonic technicians. Testing was also carried out on MUSC-MA113 Face D Skin Plate Sub-Assembly on complete joint penetration welds for the longitudinal stiffener plates, weld joint numbers 5, 8, 11 & 14. Several of these weld were found unacceptable due to weld defects found from face 'C' of the joints.



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