

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-001029**Date Inspected:** 18-Dec-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

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|------------------------------------|---------------------------------|----------------------------------|-----------------------------------|----------------------|
| CWI Name: | Fu Guo Gang and Lu Jian Ping | 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: | 114m Mock-ups, 89m Skin's E and D | |

Summary of Items Observed:

Bay 1 operations: The Caltrans Quality Assurance (QA) Inspector, John P. Tracy, had the following list of activities to report:

No activity noted for this day.

Bay 2 operations: The Caltrans Quality Assurance (QA) Inspector, John P. Tracy, had the following list of activities to report:

114m upper and lower section were again rotated. The 114m lower section - Plate B to C for weld joint# MUC-MA107 B/C-3A had ongoing SAW operations. Welder Yun Chuanjin (050306) was observed operating under WPS-B-T-2221-C-U2b-S-1. All parameters appeared to be in compliance with the criteria set forth within contractual documents.

89m- Skin A- MA21 to SA214 for joint # MUB-MA21-C/J for weld joint#'s 5, 6, 7 and 8. Preheat was witnessed via oxy/fuel torch. ZPMC welder's Dai Lu (048659) and Gua Dengyun (037997) were both operating under WPS-B-T-4312-Tc-P4-2. The following parameters were taken by the Caltrans representative: Avg amps-175, volts-24, travel speed- 121 mm/min., minimum preheat was verified by the Caltrans representative's own Tempilstik Brand Temperature Indicator.

89m- Skin's B and C- No activities observed.

89m- Skin D have stiffeners are being fitted into position and tacked along the center line of the longitudinal axis.

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89m- Skin E- MA38 to SA215 welds 1,2,3 and 4 were still in process for weld joint #MUB-MA21 B/J.

89m-Shear Link-MA25 has welding operations ongoing for the lower flange to web connection. ZPMC Certified Welding Inspector (CWI)- Ye Yong Jun is at the component and is observing thermal operations. Parameters appear to conform to the criteria set forth within the contractual documents.

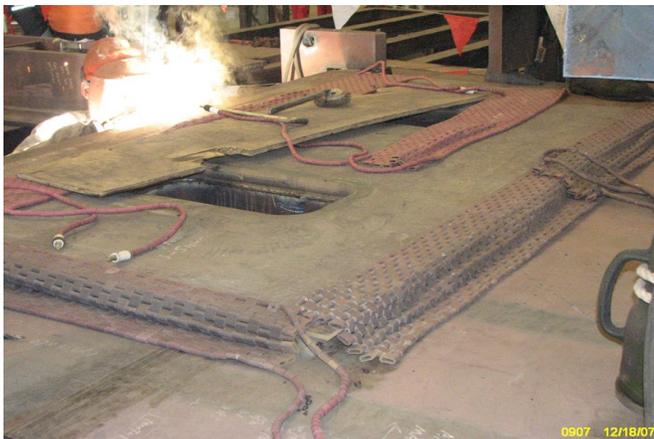
77m-Diaphragm has ongoing Oxy/fuel beveling operations.

Electrode Storage Room- The weld issue logs are still written in Chinese characters after several attempts to rectify them. Temperatures appear to be within parameters for electrode and flux storage only. No drying temperatures have been observed.



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Summary of Conversations:

In regards to the conversation with Mr. Kevin Dye of ABF, (note report for 12-17-2007) concerning the welding operations for the 114m mock-ups, the Caltrans representative and Mr. Kevin Dye spoke again in length about this issue. It was revealed that the 114m mock-up was fabricated in this manner to accommodate the removal of the 50mm of material for bevel preparations to adjoin the upper and lower sections together. The area of concern is to be removed thus making the issue irrelevant and should be disregarded.

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.

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| Inspected By: | Tracy,John | Quality Assurance Inspector |
| Reviewed By: | Carreon,Albert | QA Reviewer |
