

**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-001496  
**Date Inspected:** 30-Jan-2008

**Project Name:** SAS Superstructure **OSM Arrival Time:** 700  
**Prime Contractor:** American Bridge/Fluor Enterprises, a JV **OSM Departure Time:** 1430  
**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Xu Le Feng, Ye Yong Jun, Sha Zi			<b>CWI Presenting</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Bridge No:</b>	34-0006			<b>Component:</b>	Tower Mock-ups 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.

Tower Fabrication Facility  
89M Mock-up Assembly

The Quality Assurance Inspector witnessed a ZPMC technician performing Ultrasonic testing to skin plates D to E. 100% of the skin welding has been completed to date.

The Quality Assurance Inspector observed no material being cut in the tower fabrication facility today.

Bay 1

The Quality Assurance Inspector observed ZPMC squaring the length of closed ribs on the milling machine. Eight ribs were stacked and being milled simultaneously. The Quality Assurance Inspector measured the ribs to be approximately five meters in length, 12 millimeters in thickness and 790 millimeters in width.

The Quality Assurance Inspector witnessed ZPMC applying heat to closed ribs in preparation for fitting up and tack welding the diaphragm plates. Below is a digital photograph illustrating the preheating in progress.

The Quality Assurance Inspector observed ZPMC welding operator, Zhao Cheng Shuang, welder identification number, 059400 performing in process tack welding of diaphragm plate to rib plate connections. Quality Control

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# WELDING INSPECTION REPORT

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Inspector Xu Le Feng was monitoring the welder. The welder was using the flux cored arc welding process to produce the fillet weld in the vertical position. The Quality Assurance Inspector measured the welding parameters at Mr. Zhao's station and found the parameters to meet the minimum requirements of the welding procedure specification.



## Summary of Conversations:

As stated in the contents of the above report.

## 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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<b>Inspected By:</b>	Bertlesman,Greg	Quality Assurance Inspector
<b>Reviewed By:</b>	Cuellar,Robert	QA Reviewer

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