

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-001745**Date Inspected:** 08-Mar-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:** Xu Le Feng, Ye Yong Jun**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 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.

Diaphragm Flange Plates

The Quality Assurance Inspector observed ZPMC's process of performing heat bending operations to Tower Diaphragm Flange Plates. ZPMC Quality Control Inspector Tang Ya Jun informed the Quality Assurance Inspector of the process. First the plates are placed in a furnace with temperature settings set at 620 degrees Celsius for approximately 1.5 hours. Then a forklift picks the plate up and places it in the press. The press bends the 60 millimeter plate and the process takes approximately 30 minutes. Once the plate was bent the plate was removed from the press with a forklift and placed on the floor. ZPMC was observed using a template to measure the radius. The Quality Assurance measured the gap between the template and the part to be approximately 5 millimeters. The Quality Assurance Inspector observed base metal damage that occurred during the bending process. The Quality Assurance Inspector discovered material in the press that caused the damage. Quality Control Inspector Wang Lu stated the material would be ground off prior to bending any more plates. Below are digital photographs illustrating the furnace, the bending process and the foreign material in the press.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



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.

Inspected By:	Bertlesman,Greg	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
