

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-002668**Date Inspected:** 04-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Jiang Jian Hui**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**Summary of Items Observed:**

New Tower Shop

This Quality Assurance (QA) inspector arrived at ZPMC for observation of the SAS super structure fabrication. During his observation ZPMC was performing Ultrasonic Testing (UT) on skin plate splice ESD1-SA233 A/F weld 20a, during this observation it was noted that ZPMC UT technician Ma Jing Long was scanning beyond the required scanning pattern for complete coverage and speed that did not ensure proper sound coverage. This was brought to the attention of ZPMC CWI Jiang Jian Hui and ABF representative Yang Yi Heng. Mr. Heng spoke with ZPMC about this issue and had ZPMC re-scan the weldment with a proper scanning patterns and speed according to AWS D1.5. It was noted that ABF did inform ZPMC prior to the arrival of this QA inspector that they were not performing a proper scan and did not change their process until this QA inspector arrived and brought it to their attention. ZPMC UT technician Xue Hai Rong performed the re-examination of the above noted weldment and was observed by this QA inspector and the ABF representative noted above.

During the continued observations in the new tower shop it was noted that ZPMC was performing in process welding on several components using the Submerged Arc Welding (SAW) process for skin plate splices. The following are the components being welded; SSD1-SA159 D/J-2A welding operator Liu Zhen Hong and SSD1-SA17 A/G-17B welding operator Yun Chuan Jin. These areas were performed under WPS-B-T-2221-B-U3c-S with ZPMC's CWI Xu Le Fong monitoring welding parameters and welding progression along with 3 additional Quality Control personnel.

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Summary of Conversations:

As Noted Above.

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:	Riley, Ken	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
