

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-002817**Date Inspected:** 02-Jun-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:** C.H. Chen**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 Partial Mock-ups**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 77 Meter Partial Mock-Ups Welding Trials

The Quality Assurance Inspector identified that ZPMC has started the thermal cutting and welding of the agreed upon 77M partial mock-up weld trials.

WT-101, the Caltrans QA Inspector was informed that ABF has requested that ZPMC re-fit this assembly due to poor quality tack welds and also the mill scale present in the groove weld area of the partial joint penetration weld.

The Quality Assurance Inspector performed an inspection of the fit-up and observed what appeared to be poor penetration of the tack welds. In addition the Quality Assurance Inspector measured the bevel angle and the bevel depth of the partial joint penetration weld. Below is a digital photograph of the assembly and a close up photograph of the bevel depth being approximately 29 millimeters as detailed.

WT-32

The Quality Assurance Inspector observed that ZPMC completed welding of this mock-up weld trial on Sunday 06-01-2008. American Bridge/Fluor (ABF) representative Mike Williams stated ABF representative Jeff Cheng was present monitoring the welding. Caltrans QA Inspector's present on Sunday were not notified by ZPMC of the welding of this mock-up trial. The Quality Assurance Inspector observed that the weld tabs and non-destructive testing has not been completed to date. Below is a digital photograph illustrating the completed welding of the assembly.

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WT-125

The Quality Assurance Inspector observed the steel plate for this mock-up weld trial was completed during this past Saturday or Sunday (05-31-2008 and 06-01-2008). Fit-up and welding has not been performed.

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 (916) 227-5719, who represents the Office of Structural Materials for your project.

Inspected By: Bertlesman,Greg

Quality Assurance Inspector

Reviewed By: Cuellar,Robert

QA Reviewer