

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-003069**Date Inspected:** 09-Jun-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:	Huang Wen-Pang / Li Zhi Jing	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 / OBG		

Summary of Items Observed:**Bay 3**

This Quality Assurance (QA) inspector arrived at ZPMC in Shanghai China for observation of Orthotropic Bridge Girders (OBG) and Self Anchored Suspension (SAS) Bridge. During this QA inspector's observation in bay 3 it was noted that ZPMC was in process for fit-up at multiple stages on side and bottom plates. ZPMC Certified Welding Inspector Huang Wen-Pen was present at the time of observation and this QA inspector spoke with Mr. Wen-pang on the work in process for bay 3. It was stated that tack welds for WT and straight stiffener plates for side, bottom and edge plates were in process for component numbers SP182-001 and SP178-001 under WPS-B-P-2112-FCM using Shielded Metal Arc Welding (SMAW) welders observed for these location were Zhang Feng and Du Henghua. At gantry 1 it was observed that ZPMC was welding SP198-001 under WPS-B-T-2132-3 for 8mm multi pass fillet welds. DP012-001 for plate splice was being performed using the Flux Cored Arc welding (FCAW) process for the root pass under WPS-B-P-2231-B-U2-F with welder Wang Chuanbin. The CWI was monitoring the welding parameters and in process welding throughout this bay assisted by ZPMC Quality Control personnel.

Bay 4

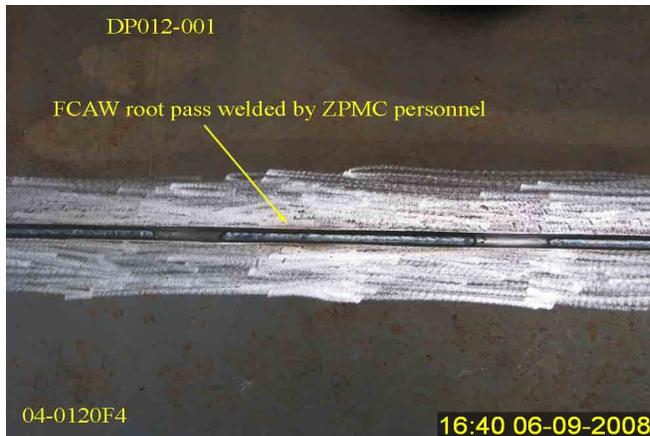
During the continued observation by this QA inspector it was noted in bay 4 that ZPMC was welding in the vertical position for interior ring flanges for diaphragm plates. Component number that was observed being welded was ESD1-SA37-7B under WPS-B-T-2233-B-U3-F by welder Li Shuqiang. Also observed on ESD1-SA287 was grinding of the finished weldment for the internal diaphragm rings. CWI Zhao chen sun was present within this bay monitoring welding progression and parameters for the Submerged Arc Welding (SAW) process for diaphragm plate splices and FCAW process for the internal flange rings. Also present to assist Mr. Sun was ZPMC QC personnel for monitoring.

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Bay 7

This QA inspector observed ZPMC in bay 7 performing fit up operations in multiple stages for floor beam components. The following floor beams were observed by this QA inspector FB001-005, FB010-007, and FB012-010 these areas were in process. Submerged Arc Welding (SAW) process was being performed by welding operator Huang Xing Lan under WPS-B-T-2221-B-L2c-S-1. This QA inspector also observed ZPMC grinding on CJP back gouged areas for web plate splices prior to continuing with the SAW welding process. It was noted that ZPMC's CWI Li Zhi Jing was present during the welding operations in this bay and monitoring welding parameters and in process progression. Also present to assist Mr. Jing was ZPMC QC personnel for monitoring.



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
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Reviewed By:	Carreon, Albert	QA Reviewer
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