

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-003124**Date Inspected:** 19-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lui Hua jie**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:**

Caltrans Quality Assurance (QA) Inspector, Ken Jobes, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, to randomly monitor welding and Quality Control (QC) functions. While on site, the QA Inspector observed and/or discovered the following:

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The Caltrans QA Inspector randomly observed the machine Submerged Arc Welding (SAW) of the root pass on Weld Nos. NSD1-SA33A/F-25B, Skin Plate Face "A". This is a complete joint penetration (CJP) groove weld. The welding was performed in the flat groove (1G) welding position by welding operator; Xu Yan (I. D. No. 052917). Welding Procedure Specification (WPS) WPS-B-T-2221-B-U3c-S-1 was used. Certified Welding Inspector (CWI), Liu Hua jie (CWI No. 07120741), was present during the welding, as was ABF QA Inspectors, Wei Jian Bo and Li Han jie. The Caltrans QA Inspector verified the qualifications of the welding operators, and that the electrode/flux classification, diameter of electrode, amperage, voltage, travel speed, and preheat/interpass temperatures were within the specified ranges on the applicable WPS.

The Caltrans QA also observed porosity in the above completed root pass. ZPMC personnel used a grinder to remove the porosity. The porosity was not completely removed and no more welding was performed on this weld during the shift.

The Caltrans QA Inspector also randomly observed that no milling or flame cutting was done during this shift.

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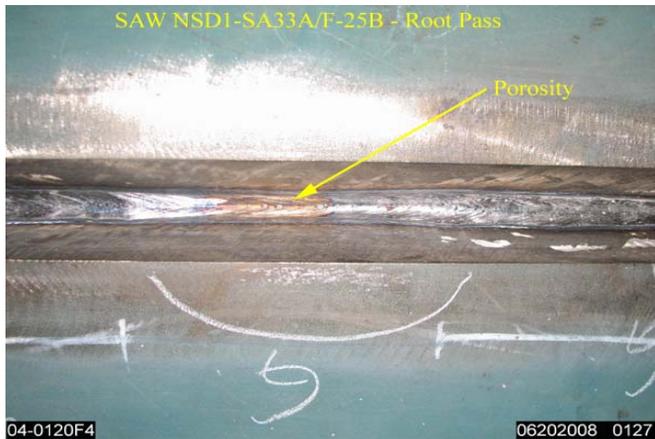
New Tower Bay 2

The Caltrans QA Inspector randomly observed the milling of the weld bevel on Skin "D" Member I. D's. SA296 welded to p1408.

The Caltrans QA Inspector also randomly observed two men grinding flush selected areas of Weld Nos. ESD1-SA107A/F-2B and ESD1-SA107A/J-16, Skin Plate Face "A". The grinding pattern appeared to indicate that the grinding was in preparation for nondestructive examination.

The Caltrans QA Inspector also randomly observed that no flame cutting was done during this shift.

All above observations appeared to meet the requirements of the job specifications.



Summary of Conversations:

As identified within the contents of this 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:	Jobs, Kenneth	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
