

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-003127**Date Inspected:** 21-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 / Zhao Chen Sun			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 Wu Ming Kai was present at the time of observation and this QA inspector spoke with Mr. Kai on the work in process for bay 3. It was stated that tack welding for side, bottom and edge plates were in different stages of fit up. Component numbers DP012-001, DP011-001 and EP042-001, Shielded Metal Arc Welding (SMAW) was observed for the above location being utilized by ZPMC welders Zhang Feng and Yang Gencheng. The gantry for this bay being utilized was number 2 with 3 ZPMC welder for the 9.6 mm fillet welds on DP-045-001 for straight stiffener plates. The CWI was monitoring the welding parameters and in process welding throughout this bay assisted by ZPMC Quality Control personnel.

Bay 4

During observations by this QA inspector it was noted in bay 4 that ZPMC was performing the Flux Cored Arc Welding (FCAW) process for the internal diaphragm rings in the vertical position (3G). Component numbers observed were ESD1-SA268 weld numbers 8A and 5A. ZPMC welding personnel at this location was; 5A- Li Shuqiang and 8A- Li Mengqian under WPS-B-T-2233-B-U3-F. This QA inspector observed multiple rings in different stages of fabrication for this location. ZPMC Certified Welding Inspector Zhao Chen Sun was observed as being present during these operations and monitoring the progress and welding parameters, along with the CWI it was also noted that ZPMC had QC personnel to assist the CWI with the monitoring.

Bay 7

This QA inspector observed ZPMC in bay 7 performing fit up operations in multiple stages for floor beam

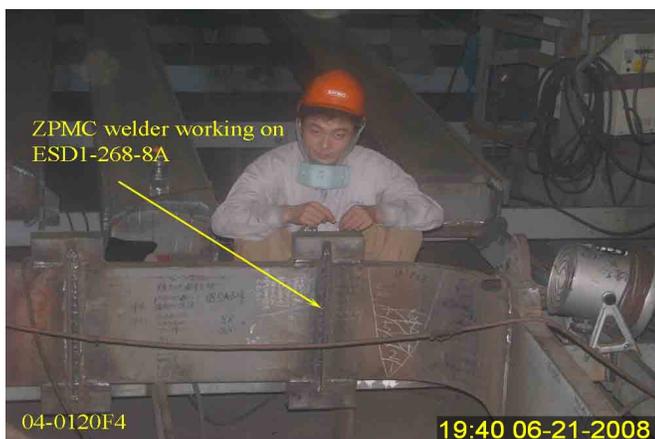
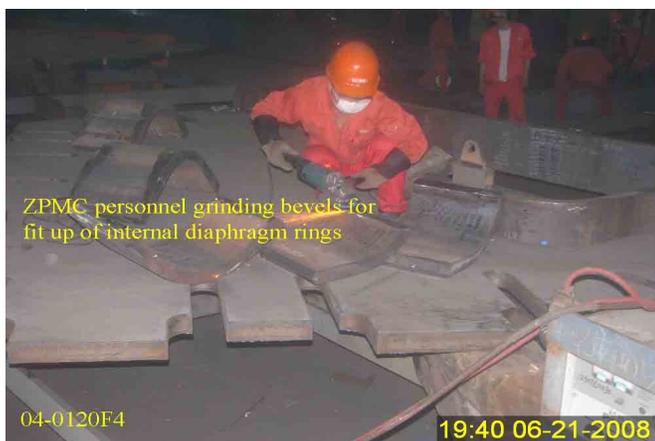
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components. The following components were observed by this QA inspector longitudinal diaphragm LD-020-001 were ZPMC was performing heat straightening under procedure HSR1 B-1241 with a 650°C maximum heat input. The FCAW process was also being used within this bay for production welding of vertical weld joint CSDS-PP025-03 being performed by ZPMC welder Chen Chuanzong under WPS-B-T-2132-3. It was noted that ZPMC's CWI Huang Wen-Pang was present during the welding operations in this bay and monitoring welding parameters and in process progression. Also present to assist Mr. Wen-Pang was ZPMC QC personnel for monitoring.

Bay 8

This QA inspector observed ZPMC in bay 8 was in the process of grinding diaphragm plate splice for component number ESD1-SA301-11/12B in preparations for the SAW welding process for the CJP weldment. This QA inspector noted that no other work was being performed in this bay for the SFOBB project this date on his shift.



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 Ady Velasco , 1-381-694-2685 China , who represents the Office of Structural Materials for your project.

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