DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-003194
Date Inspected: 29-Jun-2008

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 1400
OSM Departure Time: 2300
Location: Shanghai China

CWI Name: N/A

Inspected CWI report:	☐ Yes	☐ No	☑ N/A	**CWI Present:**	☐ Yes	☑ No	
Electrode to specification:	☐ Yes	☐ No	☑ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A
Qualified Welders:	☐ Yes	☐ No	☑ N/A	**Weld Procedures Followed:**	☐ Yes	☐ No	☑ N/A
Approved Drawings:	☐ Yes	☐ No	☑ N/A	**Verified Joint Fit-up:**	☐ 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:

UT

This Quality Assurance (QA) inspector arrived at ZPMC in Shanghai China for observation of Orthotropic Bridge Girders (OBG) and Self Anchored Suspension (SAS) Bridge. This QA inspector received notification of witness inspection for non destructive testing after ZPMC personnel had completes their testing. In tower shop bay 1 this QA inspector performed Ultrasonic Testing (UT) verifications for 10 % of the complete weld lengths listed. Skin plate A final UT weld numbers NSD1-SA159 D/J 3A and 4A on 90 mm thick plates with a total weld length of 2710 mm. Upon completion of the verification it was noted the weldments were within compliance as per AWS D1.5. Also tested was skin plate C UT after repairs weld numbers SSD1-SA179 D/E 30 A/B, SSD1-SA179 D/E 27 A/B, SSD1-SA179 D/E 28 A/B and SSD1-SA179 E/E 4 A/B average weld length for these locations was approximately 600 mm with a material thickness transmission of 60 mm to 90 mm. . Upon completion of the verification it was noted the weldments were within compliance as per AWS D1.5. Bay 7, UT verification was performed by this QA inspector on component number FB009-006-043 for CJP weldment of web plate to flange complete V path was not achievable due to material height . Scanning from both A and B side was performed. Testing was performed in the first leg this QA inspector found no rejectable indications for the 10% verified. A TL-6028 will be generated for these locations.

WELDING INSPECTION REPORT

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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 JOSHUA ISHIBASHI , China- 1-376-471-0411, who represents the Office of Structural Materials for your project.

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