

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-003325**Date Inspected:** 21-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Keng Chan**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:**

On this date, Caltrans Office of Structure Materials (OSM) Quality Assurance Inspector (QA) Raymond Lara was present at jobsite in Zhenhua Port Machinery Company facility on Changxing Island, China for the purpose of observing and monitoring the fabrication of the OBG/Tower.

Bay 1

The Quality Assurance Inspector observed ZPMC utilizing a milling machine in the beveling process on skin plate SA33/P267/P1063.

The Quality Assurance Inspector observed ZPMC utilizing chalk layout lines in an effort to aid in the fit up on longitudinal stiffener to skin plate C South Tower Assembly.

The Quality Assurance Inspector observed ZPMC performing grinding and air carbon arc operations on various longitudinal stiffeners weld runoff tabs.

Skin A South Tower Assembly

The Quality Assurance Inspector observed ZPMC has positioned Skin A South Tower Assembly onto a semi automated flux core welding gantry. ABF Quality Assurance Inspector CK Chan informed the Quality Assurance Inspector, ZPMC still needs to perform a survey in the longitudinal stiffeners and perform magnetic particle testing on the tack welds prior to welding. See digital photograph below.

Bay 2

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The Quality Assurance Inspector observed ZPMC utilizing a milling machine in the beveling process on longitudinal stiffener plate P222B.

The Quality Assurance Inspector observed ZPMC performing heat straightening operations on longitudinal stiffeners.

The Quality Assurance Inspector observed ZPMC personnel perform magnetic particle testing on various longitudinal stiffener plates.

Skin A East Tower Assembly

The Quality Assurance Inspector observed ZPMC Caltrans approved welders 040500, utilizing shielded metal arc welding process on temporary lifting lugs to skin plate A East Tower Assembly. The Quality Assurance Inspector observed ZPMC Quality Control Personnel record parameters and verify preheat temperatures. The welding parameters observed by the Quality Assurance Inspector appeared to be within welding procedure specification WPS-B-P-2312-TC-PS. See digital photograph below.



Summary of Conversations:

No relevant conversations on this date.

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, (707) 649-5453, who represents the Office of Structural Materials for your project.

Inspected By: Lara, Raymond

Quality Assurance Inspector

Reviewed By: Lanz, Joe

QA Reviewer