

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-003458**Date Inspected:** 11-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2200**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhu Zhong Hai**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:** Mock-up 89 and tower skin plate**Summary of Items Observed:**

Mock-up 89

Caltrans Quality Assurance Inspector George Goulet (QA Inspector) observed ZPMC MT operator Bot In Vui perform MT on weld MU89/MUSB-MA21A/J-26 after the root pass had been ground out. No apparent indications were observed. Six workers were present in addition to ABF QC Chung Keung Chan and ZPMC CWI Zhu Zhong Hai. No welding was performed.

Tower Shop – Bay 1

QA Inspector observed performance of SAW in progress on skin plate at SSD1-SA173A/K-20B. Approximately 20 workers were present in this shop including one ZPMC CWI. No other welding was being performed. QA Inspector observed oxy-fuel cutting of edge bevel on skin plate SA179 and various skin stiffener plates.

Tower Shop – Bay 2

QA Inspector observed personnel performing the following:

Movement of skin stiffener plates with gantry crane.

Air-arc and flame cutting removal of run-off tabs on skin stiffener plates.

FCAW-G and heat straightening on various skin stiffener plates.

Sixteen workers were present in this shop as well as ZPMC CWI An Qing Xiang.

Summary of Conversations:

ABF QC Chung Keung Chan assured QA Inspector that no subsequent welding would take place on the Mock-up 89 weld that had been ground out until the area was re-preheated.

WELDING INSPECTION REPORT

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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, 136-6471-0411, who represents the Office of Structural Materials for your project.

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| Inspected By: | Goulet,George | Quality Assurance Inspector |
| Reviewed By: | Carreon,Albert | QA Reviewer |
