

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-003477**Date Inspected:** 19-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:** Chen Xi**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:** skin plate, closed rib to deck plate welds**Summary of Items Observed:**

Tower Shop – Bay 1

QA Inspector observed ZPMC personnel flame-cutting bevels on a skin plate. Ten workers were present in this shop. No welding was being performed.

Tower Shop – Bay 2

QA Inspector observed personnel performing the following:

Layout and marking on skin plate approximately 4M x 48M. See photo below of layout.

Tower diaphragm plate being cut out on burn table.

Twenty workers were present in this shop and no welding was observed being performed.

Heavy Duty Machine Shop – Bay 3:

Caltrans Quality Assurance Inspector George Goulet (QA Inspector) performed VT after first repairs had been performed on DP042-002. QA Inspector concurred with ZPMC CWI Chen Xi and ABF QC Ding Bao Hua on apparent indications involving mostly grinding. However, QA Inspector observed two concave shaped divets in the flat side of U-rib #U126 above weld #004. Each of the divets was 1.5mm deep x approximately 7mm in diameter and longitudinally 160mm apart. See photo below. The center point between the two divets was 8480mm from the starting point of the weld at the end of the U-rib. QA Inspector Ken Riley was present and observed the divets. No welding was observed being performed.

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Summary of Conversations:

QA Inspector Ken Riley informed ZPMC QC Shen Xue Jun, ZPMC CWI Chen XI, and ABF QC Ding Bao Hua that the above noted two divets in the deck panel were being reported to the engineer as critical weld repairs.

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, 138-1694-2685, who represents the Office of Structural Materials for your project.

Inspected By: Goulet, George

Quality Assurance Inspector

Reviewed By: Carreon, Albert

QA Reviewer