

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-003478**Date Inspected:** 21-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:** Huang Wen Pang**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, rib to bottom plate weld**Summary of Items Observed:**

Tower Shop – Bay 1

Caltrans Quality Assurance Inspector George Goulet (QA Inspector) observed ZPMC personnel aligning skin plates SSD1-SA176 and SSD1-SA179 for fit-up of SAW weld.

Other work randomly observed being performed heat straightening of skin plates and grinding of welds on skin stiffeners.

QA Inspector randomly observed one very large skin plate on a raised assembly table with four skin stiffener fit-up and tacked and held in place with mechanical and hydraulic alignment devices. See photo below of the skin plate and four stiffeners on assembly table.

Approximately 62 workers were present in this shop. No welding was being performed.

Tower Shop – Bay 2

QA Inspector observed ZPMC personnel performing the following:

Three workers grinding on skin plate.

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

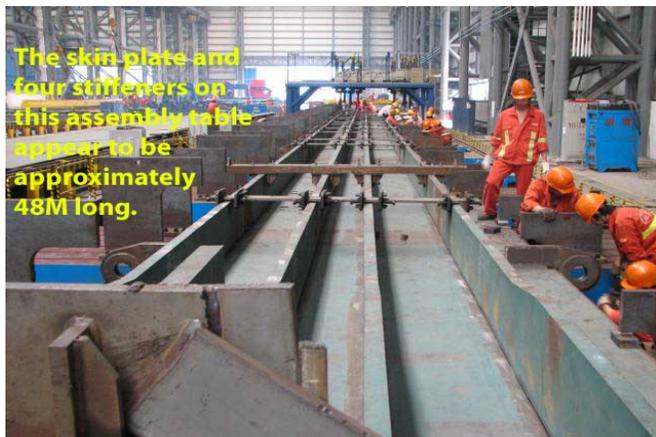
Sub-assembly Shop – Bay 3:

QA Inspector observed the grinding out and removal of a cracked tack weld at BP306-001-08. See photo below of cracked tack before grinding. QA Inspector observed ZPMC MT operator perform MT on the ground out tack and

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report to QA Inspector that no indications were observed. QA Inspector concurred. Also present and observing the operation was ZPMC CWI Huang Wen Pang who also concurred with no observance of an indication. Approximately 60 ZPMC workers were present in the bay.



Summary of Conversations:

As noted above. No additional significant conversations 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 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
