

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-003481**Date Inspected:** 09-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**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:** Tower**Summary of Items Observed:**

Tower Shop Bay 2

This Quality Assurance (QA) inspector arrived at ZPMC in Shanghai China for observation of Orthotropic Bridge Girders (OBG) and Self Anchored Suspension (SAS) Bridge. During this QA inspector's observation in Tower Shop bay 2 it was noted that ZPMC was in the process of tack welding for the Partial Joint Penetration (CJP) weld joints for the tower skin plates to stiffeners under WPS-B-P-2212-TC-U5b. Also noted was the Submerged Arc welding Process (SAW) for CJP weld splice ESD1-SA49 A/D- 22A under WPS-B-T-2221-B-u3c-S with welder Cao Xiau Hua. ZPMC had their Certified Welding Inspector Zhu Zhong Hai monitoring the welding along with ZPMC QC personnel for assistance at this location.

Tower Shop Bay 1

This Quality Assurance (QA) inspector arrived at ZPMC in Shanghai China for observation of Orthotropic Bridge Girders (OBG) and Self Anchored Suspension (SAS) Bridge. During this QA inspector's observation in Tower Shop bay 2 it was noted that ZPMC was in the process of tack welding for the Partial Joint Penetration (CJP) weld joints for the tower skin plates to stiffeners under WPS-B-P-2212-TC-U5b. This QA inspector requested the documentation from ZPMC QC and CWI for this location to verify the welding parameters and WPS being applied but was told by the QC and CWI that they were not performing the documentation due to on the "Mock-Up" they did not do it. This QA inspector informed ZPMC that as per the special provisions Sect 8 that all welding including tack welding was to be documented on a daily basis. A TL-15 (incident report) will be generated for this occurrence. ZPMC had their Certified Welding Inspector Zhu Zhong Hai monitoring the welding along with ZPMC QC personnel for assistance at this location.

Summary of Conversations:

WELDING INSPECTION REPORT

(*Continued Page 2 of 2*)

As noted in contents 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
