

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-003483**Date Inspected:** 13-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:	Jiang Jian Fei	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:	OBG / Tower	

Summary of Items Observed:

Tower shop Bay 3 Dec Panel repairs

This Quality Assurance (QA) inspector arrived at ZPMC in Shanghai China for observation of Orthotropic Bridge Girders (OBG) and Self Anchored Suspension (SAS) Bridge. The QA Inspector randomly observed ZPMC personnel performing grinding and welding of repairs for the Orthotropic Box Girder (OBG) deck panel Partial Joint Penetration (PJP) welds. During initial observations it was noted that twenty-five (25 ea) deck panels are inside the shop. This QA inspector observed deck panels DP-110-002, DP488-001 and DP049-001 under repair work that was in-process. Deck panels DP049-001 DP001-001 and DP050-001 was in process for UT repairs due to inefficient Depth Of Penetration (DOP) ZPMC had excavated these areas only with no welding performed on this shift. The following is the repair quantity for each panel; DP-049-001 one location weld number 5, DP001-001 six locations welds 1, 3, 4 and 6, 1 excavation for each weld. Weld number 2 – 2 excavations. DP050-001 one location weld 4. No initial or final inspections were requested on this shift today. Certified Welding Inspector for ZPMC Li Yan Hua was present at this location for the monitoring of the deck repairs and inspection. Also noted in bay 3 to monitor deck panel repairs were 2 - ABF personnel and 3 ZPMC QC personnel.

Tower Shop Bay 2

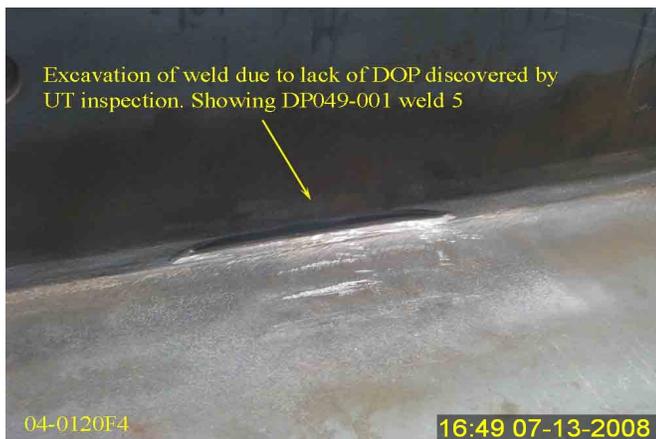
This Quality Assurance (QA) inspector arrived at ZPMC in Shanghai China for observation of Orthotropic Bridge Girders (OBG) and Self Anchored Suspension (SAS) Bridge. During this QA inspector's observation in Tower Shop bay 2 it was noted that ZPMC was in the process of tack welding for the Partial Joint Penetration (CJP) weld joints for the tower skin plates to stiffeners weld number ESD1-SA107 E/J 11B under WPS-B-P-2212-TC-U5b. Also noted was the Submerged Arc welding Process (SAW) for CJP weld splice ESD1-SA216 G/K- 22A under WPS-B-T-2221-B-U3c-S with welder Sun Ping. ZPMC had their Certified Welding Inspector Jiang Jian Fei monitoring the welding along with ZPMC QC personnel for assistance at this location.

WELDING INSPECTION REPORT

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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 1 it was noted that ZPMC was in the process of the Flux Cored Arc welding process (FCAW) for CJP weld splice SSD1-SA178 A/D- 18A under WPS-B-T-2231-B-u3-F with welder Bai Wenming. It was noted that the welder was in the flat position (1G) performing this process manually. ZPMC was also performing the Submerged Arc Welding (SAW) process for tower skin plate SSD1-SA178 C/D – 3A with welding operator Xin Xiu Shui under WPS-B-T-2221-B-U3c-S. ZPMC's Certified Welding Inspector Zhu Zhong Hai was observed by this QA inspector as being present during this observation for the purpose of monitoring the welding along with ZPMC QC personnel for assistance at this location.



Summary of Conversations:

As noted 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
