

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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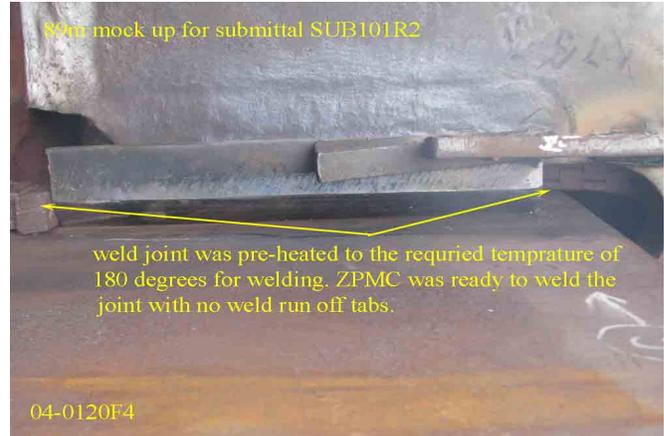
Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003485**Date Inspected:** 16-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime 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:** Tower**Summary of Items Observed:**

89m mock up

This Quality Assurance (QA) inspector arrived at ZPMC in Shanghai China for observations of the Orthotropic Bridge Girders (OBG) and Self Anchored Suspension (SAS) Bridge. During this QA inspector observation of the 89m partial mock up under Submittal SUB101R2 it was noted that ZPMC had fit up the lug plate to stiffener and diaphragm plate. ZPMC was observed pre heating this location for welding. It was noted that under the above noted submittal that ZPMC did not follow the procedures which stated in item 3 "Weld new PJP root pass between longitudinal stiffener and diaphragm according to approved WPS including preheat to between 180 and 240 degrees C. Submit welding data" the diaphragm to stiffener was to be welded first in sequence which ZPMC did not do. ZPMC elected to perform item 9 "Weld Fit lug to stiffener using equivalent PJP weld each side" which was the fit lug to stiffener and diaphragm. Welding was halted due to not enough time to perform the welding and cool down operations but was to continue on the day shift 7-17-08. Also noted was ZPMC did not attach weld run off tabs for the PJP weldments. The PJP weld joints were preheated to 180 degrees and ready for welding which showed intent of not using run off tabs due to the requirements of preheating run off tabs along with the weld joint together. The above issues were outside the procedure outlined in the approved submittal and a TL-15 incident report was issued.

WELDING INSPECTION REPORT

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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 , 1-376-471-0411, who represents the Office of Structural Materials for your project.

Inspected By:	Riley, Ken	Quality Assurance Inspector
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Reviewed By:	Carreon, Albert	QA Reviewer
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