

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-003584**Date Inspected:** 22-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Wei**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 and OBG**Summary of Items Observed:**

The Quality Assurance (QA) Inspector Gregory Bertlesman arrived on site at the Zhenhua Port Machinery Company facility on Changxing island, China to periodically monitor welding and Quality Control functions. While on site the Quality Assurance Inspector observed and/or discovered the following.

Tower Bay 1

The Quality Assurance Inspector was informed by ABF representative Don Walton that several of the fabrication tables cracked during the fabricators attempt to pre-camber the South tower, skin "A", lift 1, sub-assembly. QA observed that 10 of the 12 tables were cracked. ZPMC had placed a steel plate down the centerline of the skin measuring approximately 40 millimeters in thickness and 100 millimeters in width. ZPMC forced one side of the skin plate down with the use of steel wedges while jacking the other side with approximately 12, 30 ton hydraulic jacks. It is assumed by ABF representative Mr. Walton; the cracks took place while jacking. Below are digital photographs illustrating the process.

Tower Bay 2

The Quality Assurance Inspector observed ZPMC performing heat straightening operations to Skin Plate "D", identification numbers P601 and P602. Quality Control was observed measuring the heat with an infra-red temperature indicating device.

The Quality Assurance Inspector observed ZPMC continuing to grind the tack welds joining the longitudinal stiffeners to the East tower, Skin "A", lift 1, sub-assembly in preparation for magnetic particle testing.

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Deck Panel Repair Bay 3

The Quality Assurance Inspector observed ZPMC performing weld repairs to Deck Panel DP-031-001 utilizing the flux cored arc welding process and performing grinding repairs to Deck Panels DP-245-001, DP-432-001 and DP-407-001.



Summary of Conversations:

As stated in the contents of the above report.

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(707) 552 7715, who represents the Office of Structural Materials for your project.

Inspected By: Bertlesman,Greg

Quality Assurance Inspector

Reviewed By: Lanz,Joe

QA Reviewer
