

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-003880**Date Inspected:** 22-Aug-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Wei, Chen Chih Chien**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:** deck panels, lap plates, side panels**Summary of Items Observed:****OBG Sub-assembly – Bay 1**

Caltrans Quality Assurance Inspector George Goulet (QA Inspector) randomly observed deck panels in various stages of fabrication and approximately 75 ZPMC workers performing the following: GMAW root welding on both sides of two of four ribs to DP114-001. Also present in this bay and monitoring the above noted welding were ZPMC CWI Sun Wei as well as ABF QC's Chang Bao Qian and Man-Kit Li. Items observed appeared to comply with project specifications.

Sub-assembly - Bay 2

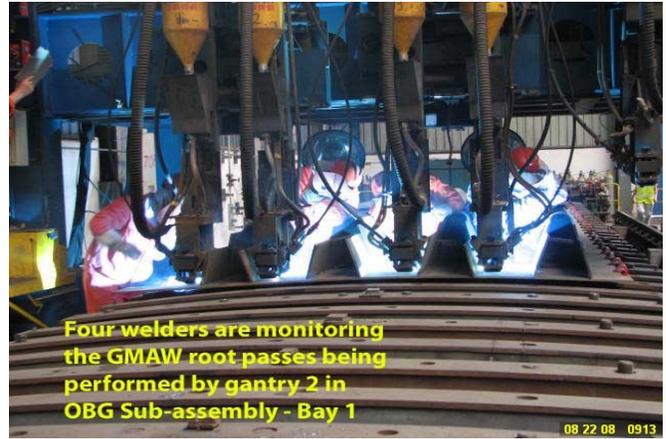
QA Inspector randomly observed approximately 10 ZPMC workers using drill presses to drill patterned holes into various size and thickness lap plates. No welding was observed being performed in this bay.

Sub-assembly - Bay 3

QA Inspector randomly observed approximately 55 ZPMC workers performing the following: two welders fitting and SMAW tacking of ribs to SP097-001; one welder each fitting and SMAW tacking of ribs to SP151-001 and SP310-001; one welder fitting and SMAW tacking of ribs to unidentified edge panel; approximate 24mm patterned holes being drilled in T-rib ends. Also present in this bay were ZPMC CWI Chen Chih Chien and ABF QC Yu Kunming. Items observed appeared to comply with project specifications.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

No significant conversations on 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