

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-003969**Date Inspected:** 27-Aug-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:	Chen Chih Chien, Sha Zhi, & others			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 panels; double diaphragm assemblies**Summary of Items Observed:**

Sub-assembly - Bay 3

QA Inspector randomly observed approximately 60 ZPMC workers performing the following: fitting, preheating, and tack welding of ribs to BP143 and BP170A using SMAW; FCAW-G attaching run-off tabs to flange groove butt welds adjoining W21 x 57 beams to eventually become side panel ribs; grinding of longitudinally flame cut W21 x 57 beams; installation of electrical heaters onto tack welded only bottom plate and DPS-13A. Also present in this bay were ZPMC Chen Chih Chien and ABF QC Li Jin Bo. Items observed appeared to comply with project specifications.

Sub-assembly - Bay 4

QA Inspector randomly observed approximately 65 ZPMC workers performing the following: preheating and SMAW of NSD1-SA27B/B-5 as part of NSD1-43M double diaphragm assembly; SMAW of SSD1-SA322B/B-12 as part of SSD1-33M double diaphragm assembly; electric heating pads installed on NSD1-33M double diaphragm assembly; grinding of rib to plate cover pass on DP630A. Also present in this bay and monitoring the above noted welding were ZPMC CWI's Sha Zhi, Li Shi You, and Yu Dong Ping, and ABF QC's Li Jing Bo, Deng Wen Jun, Dai Qing Wen, and Mike Williams. Items observed appeared to comply with project specifications.

WELDING INSPECTION REPORT

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Summary of Conversations:

ABF QC Mike Williams explained the double diaphragm assemblies and the weld notations used thereon.

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, 136-6471-0411, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
