

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-003972**Date Inspected:** 30-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:** not observed**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 assembly, lap plates**Summary of Items Observed:****OBG Sub Assembly - Bay 1**

QA Inspector randomly observed deck panels in various stages of fabrication and approximately 45 ZPMC workers performing the following: FCAW - G of three - 19mm stiffener plates inboard of the 8mm stiffeners previously observed inside the U-ribs (see photo below); cleaning of deck plates in layout pattern where the U-rib welds will be; grinding of root pass of U-rib to deck plate welds on DP357-001. Present in this bay was ABF QC Chang Bao Qian (ABF QC-1). No CWI was observed in this bay. Items observed appeared to comply with project specifications.

OBG Sub Assembly - Bay 2

QA Inspector randomly observed approximately 9 ZPMC workers using drill presses to drill patterned approximately 30mm holes into lap plates of approximately 50mm x 400mm x 1200mm and approximately 24mm holes into lap plates of approximately 23mm x 160mm x 1200. No welding was observed being performed in this bay.

OBG Assembly Shop

QA Inspector randomly observed approximately 20 ZPMC workers in the 5 segments in the east end of this bay performing the following: 2 welders on segment 020A, welds 017 and 018 - FCAW-G of floor beam assembly to side panels plate using WPS B-T-2233-TC-U4b-F, per ABF QC Wang Heng (ABF QC-2); installation of lap plates onto side panel T-ribs. No ZPMC CWI was observed in this bay.

QA Inspector randomly observed approximately 15 ZPMC workers in the 6 segments in the west end of this bay

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performing the following: air-arcing of the tacked joint between DP35A and EP15A. Both of these panels had been green tag released by ABF QC Kevin Dye on 8/21/08. No welding was observed being performed. Items observed appeared to comply with project specifications.



Summary of Conversations:

OBG Sub Assembly – Bay 1: QA Inspector asked ABF QC-1 who the ZPMC CWI was that was on duty. ABF QC-1 replied that the ZPMC CWI was Sun Bo and that he was in the office which is outside of Bay 1.

OBG Assembly Shop: QA Inspector asked ABF QC-2 where the ZPMC CWI was that was on duty. ABF QC-2 replied that the ZPMC CWI had been in the shop, but was on the move to cover all stations performing welding.

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
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Reviewed By:	Carreon, Albert	QA Reviewer
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