

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-004013**Date Inspected:** 05-Sep-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:** Li Yang / An Qing Xian**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:** skin plate assembly, deck plate**Summary of Items Observed:**

Tower shop - Bay 1

QA Inspector randomly observed approximately 40 ZPMC workers performing the following: flame heat straightening and flame cutting of beveled edge on plates; FCAW-G of cover passes of stiffener to SSD1 – skin E assembly in the tilted up position; FCAW-G, manual and automatic, of fill passes of stiffener to SSD1 – skin C assembly. Also present in this bay were ZPMC CWI Li Yang as well as ABF QC's Yang Yi Heng and Zhang Qin Jian. Items observed appeared to comply with project specifications. See conversations below.

Tower shop - Bay 2

QA Inspector randomly observed approximately 40 ZPMC workers performing the following: fitting, preheating, tacking, and grinding of tacks of stiffeners to ESD1 – skin C; grinding into cover, then FCAW-G of fill passes of 500mm at the end of stiffener B-3 to ESD1 – skin B; SAW of skin plate butt weld ESD1-SA300A/F-3A; flame heat straightening and flame cutting of beveled edge on plates. Also present in this bay were ZPMC CWI An Qing Xian, ZPMC CAWI Liu Dao Feng and ABF QC Luo Lai Quan. Items observed appeared to comply with project specifications.

Heavy Duty Machine Shop – Bay 3

QA Inspector randomly observed 11 ZPMC workers performing the following: air-arc gouging of deck plate (no ribs attached) unidentified butt weld; grinding of U-rib to deck panels DP502-001, DP552-001, DP586-002, and DP572-001. There were 11 full size panels, 4 half size panels, and 1 panel that had been cut into and samples taken from. Another panel in the same general condition was under the cut panel and did not appear to be a panel in current production. Also present in this bay were ABF QC's Wang Zhong Yuan and Ding Bao Hua. Items

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observed appeared to comply with project specifications.



Summary of Conversations:

C.K. Chan presented QA Inspector with Welding Repair Report T-WR182 revised to show SMAW as an alternative process and 4 stiffener plates.

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
