

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-004024**Date Inspected:** 22-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:** Jicheng Zou, Ye Yong Jun**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 skin assemblies, deck panels**Summary of Items Observed:**

89M Tower Mockup

Caltrans Quality Assurance Inspector George Goulet (QA Inspector) was informed that ZPMC was applying electric preheat to the fit lug to tower diaphragm weld on the 89M Tower Mockup and planned to proceed with welding when preheat reached the required temperature. QA Inspector observed thermal blankets installed at and near the weld area.

Tower shop - Bay 1

QA Inspector randomly observed approximately 40 ZPMC workers performing the following: grinding of cover pass and flame cutting of approximately 70mm x 120mm half-round holes in stiffeners at the skin plate on SSD1 – skin D assembly; flame heat straightening of plates; flame heat straightening of welded stiffeners on SSD1-skin C assembly. Also present in this bay were ZPMC CWI Sun Yan Fei and ABF QC Yang Yi Heng. Items observed appeared to comply with project specifications.

Tower shop - Bay 2

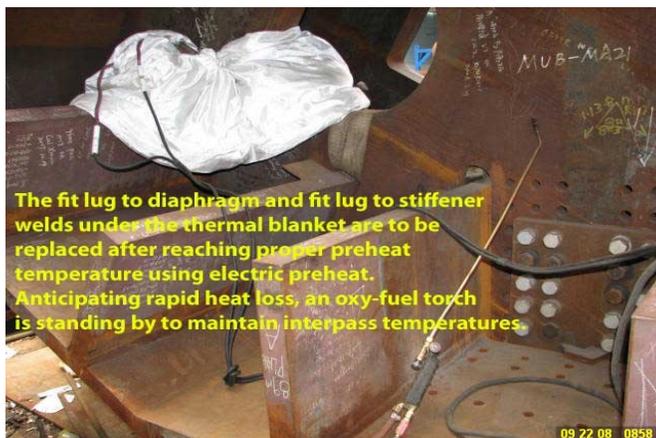
QA Inspector randomly observed approximately 75 ZPMC workers performing the following: grinding of cover pass on ESD1-skin C assembly; FCAW-G of root and fill passes of doubler plates to ESD1-skin E assembly; performance of Critical Weld Repair #T-CWR025 using SMAW per WPS-485-SMAW-3G(3F)-repair. Also present in this bay were ZPMC CWI Ye Yong Jun as well as ABF QC's Zhang Da Ming, David Wu, Mike Williams, Wang Chen Jun, Don Walton, and C.K. Chan. Items observed appeared to comply with project specifications.

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Heavy Duty Machine Shop - Bay 3

QA Inspector randomly observed 13 ZPMC workers in this bay. There were 14 full size panels and several unidentified deck plates in various stages of butt welding present in the bay. QA inspector performed initial VT on DP581-001 and DP164-001 with ZPMC CWI Sun Yan Fei and ABF QC Kevin Chen (ABF QC). QA Inspector later observed the yellow tag on both deck panels to display the names of ABF QC and ZPMC CWI Sun Bo (CWI). QA Inspector also notated initial VT indication concurrence with ABF QC and CWI on the yellow tag. Items observed appeared to comply with project specifications.



Summary of Conversations:

QA Inspector was informed at 1355 by ZPMC CWI Jicheng Zou that the welding repair would begin with welding in about 10 minutes.

QA Inspector coordinated the initial inspection of deck panels with ABF QC and CWI.

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
