

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-004034**Date Inspected:** 08-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China

CWI Name:	Wu Ming Kai	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	

Summary of Items Observed:

Tower Shop Bay 3 Deck Panel repairs

The QA Inspector randomly observed ZPMC personnel performing grinding of repairs for the Orthotropic Box Girder (OBG) deck panel Partial Joint Penetration (PJP) welds. During initial observations it was noted that twenty-three (23 ea) deck panels are inside the shop. This QA inspector observed ZPMC MT technician performing inspection on the following deck panels; DP546-002, DP562-001, DP579-001 and DP552-001 this QA inspector performed the 10% QA review after ZPMC had accepted the weldments and found that at the time of the review the weldments appeared to be within compliance. Also noted that ZPMC had six (6) Deck Panel plates located in bay 3 performing CJP weld splicing using the FCAW process for the root pass on DP600-001-300, DP610-001-300, DP590-001-300, DP555-001-300, DP560--1-300 and DP570-001-300 under WPS-B-T-2231-B-U2-F by welder Hu Yongcang ID#-203805. Certified Welding Inspector for ZPMC Li Yan Hua was present at this location for the monitoring of the deck repairs and inspection. Also noted in bay 3 to monitor deck panel repairs were ABF personnel Kevin Chen, Wang Zhong Yuan and Ding Bao Hua.

Bay 3

This Quality Assurance (QA) inspector arrived at ZPMC in Shanghai China for observation of Orthotropic Bridge Girders (OBG) and Self Anchored Suspension (SAS) Bridge. During this QA inspector's observation in bay 3 it was noted that ZPMC was in process for fit-up at multiple stages on side and bottom plates. ZPMC Certified Welding Inspector Wu Ming Kai was present at the time of observation and this QA inspector spoke with Mr. Kai on the work in process for bay 3. It was stated that tack welding for side, bottom and edge plates were in different stages of fit up. Component numbers EP30A and EP36A stiffeners being fit to the flat plates with tack welds in process using the Shielded Metal Arc Welding (SMAW) process. Also noted at the gantry's in this bay was SP152A (gantry-1) a 9.6 mm fillet welds using the Flux Cored Arc Welding (FCAW) was observed for the above

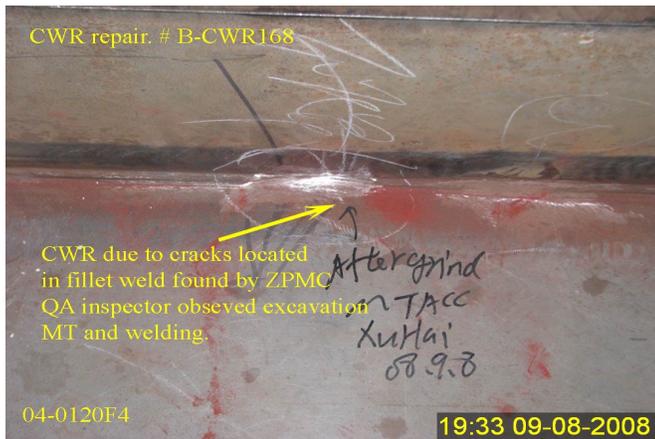
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location being utilized by ZPMC welders. The CWI was monitoring the welding parameters and in process welding throughout this bay assisted by ZPMC Quality Control personnel.

CWR Bay 4

This QA inspector observed ZPMC in bay 4 performing a repair on component number BP309A under Critical Weld Repair (CWR) number B-CWR-168 due to cracks located in the fillet weld. The material thickness was 30 mm to 18 mm at the locations for the CWR. The excavation depth performed was 30mm and length of 122 mm by 4mm depth of excavation. ZPMC welded this repair location as per the approved CWR which was monitored by this QA inspector and ZPMC CWI Wu Ming Kai. Welder Wang Zhongcang used the SMAW welding process under WPS-345-SMAW-2-G (2F)-repair. ZPMC's CWI Wu Ming Kai was present during the welding repair operations in this bay monitoring parameters and procedure progression.



Summary of Conversations:

As stated above.

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 , 1-381-694-2685, who represents the Office of Structural Materials for your project.

Inspected By:	Riley, Ken	Quality Assurance Inspector
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Reviewed By:	Carreon, Albert	QA Reviewer
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