

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-004087**Date Inspected:** 09-Oct-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:** Liu Yang**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**Summary of Items Observed:**

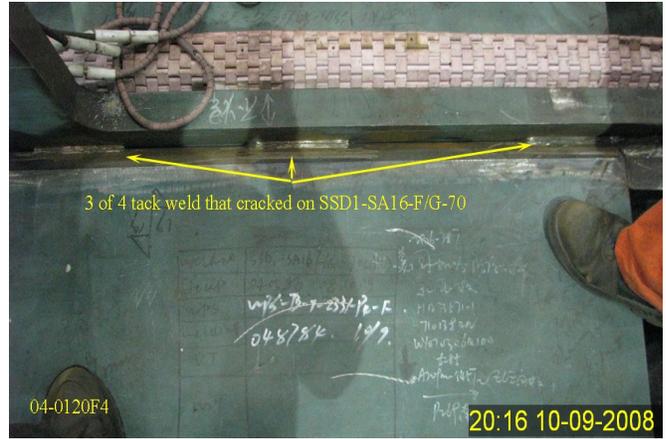
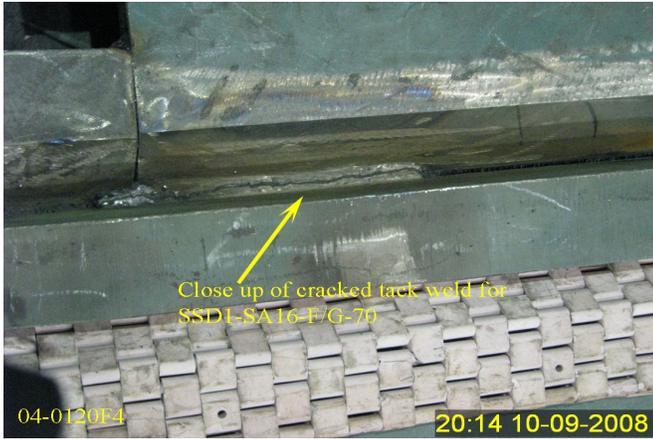
Visual and MT inspection Verification

This QA inspector received verbal notification from ZPMC QC department that tower Skin plate SSD1-skin B for the first 3 meters was ready for Caltrans QA verification. This QA inspector arrived in tower shop 1 to perform the verification and observed several visual indications at the welds. These included slag pocket open to the surface, undercut greater than 1mm and weld profile were ZPMC had performed excessive grinding creating a dishing profile on the weld. This QA inspector turned this component back to ABF and informed Mike Williams of findings. ABF then proceeded to re-inspect these welds marking multiple locations for ZPMC to address with welding and grinding. ABF and ZPMC personnel were informed by this QA inspector that once these weldments were completed that the QA verification would proceed. ZPMC and ABF completed their VT for SSD1-skin B and performed MT for these weldments linear indications were found on weld 22 and ground out, 1 indication at this location during the grinding a slag pocket was found and removed. Due to the depth of the grind the area was welded and ground. This QA inspector performed 10% QA MT with no rejectable indications noted. At the time of the QA review the weldments appeared to be within compliance.

Skin plate E cover plates located within the first 3 meters were being tack welded and root passes applied. During the pre-heat process all 4 tack welds broke at once at weld number ESD1-SA. ZPMC then removed these welds by grinding down to sound weld metal and MT each area to verify base metal soundness. This QA inspector observed this process and agreed that the cracks had been removed. ZPMC will replace these tack welds and proceed with production welding.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

As noted 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 Josh Ishibashi 1-376-471-0411, who represents the Office of Structural Materials for your project.

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