

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-004142**Date Inspected:** 01-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** CK Chan / Jeff Chen**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:**

On this date, Caltrans Office of Structure Materials (OSM) Quality Assurance Inspector (QA) Raymond Lara was present at jobsite in Zhenhua Port Machinery Company facility on Changxing island, China for the purpose of observing and monitoring the fabrication of the Tower.

Heavy Shop Bay 1

The Quality Assurance Inspector observed ZPMC utilizing a milling machine in the beveling process on longitudinal stiffener and skin plates.

The Quality Assurance Inspector observed ZPMC personnel in process of performing fit operations on skin plates P62(s) and P1040.

The Quality Assurance Inspector observed ZPMC in process of removing temporary attachments by grinding and torch cutting.

The Quality Assurance Inspector observed flux core arc welding on skin plate assemblies C and B.

Heavy Shop Bay 2**Skin D East Tower Assemblies**

The Quality Assurance Inspector observed ZPMC Caltrans approved welder 06675, utilizing the flux core arc

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welding (FCAW) process on longitudinal stiffener to skin plate D weld number ESDI-SA-296 A/E 15. The Quality Assurance Inspector observed ZPMC Quality Control Personnel record parameters and verify preheat temperatures. The welding parameters observed by the Quality Assurance Inspector appeared to be within welding procedure specification WPS-B-T-2231-B-U3-F.

The Quality Assurance Inspector observed ZPMC personnel in process of repairing by grinding on completed cover passes on longitudinal stiffener to skin plate A East Tower Assemblies.

The Quality Assurance Inspector observed American Bridge/Flour survey team perform a survey on longitudinal stiffeners to skin plate A south tower Assembly.

Bay 3

The Quality Assurance Inspector observed ZPMC grinding and performing flux core arc welding (FCAW) on visual weld repairs on Orthotropic Box Girders (OBG) DP 596-009 and DP 572-001.

Tower Mock up

The Quality Assurance Inspector observed ZMPC personnel perform fit up preparations on the 89 meter mock up.



Summary of Conversations:

No relevant conversations on this date.

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, (707) 649-5453, who represents the Office of Structural Materials for your project.

Inspected By: Lara, Raymond

Quality Assurance Inspector

Reviewed By: Lanz, Joe

QA Reviewer