

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-004281**Date Inspected:** 27-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Wei**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:**

The Quality Assurance (QA) Inspector Gregory Bertlesman arrived on site at the Zhenhua Port Machinery Company facility on Changxing island, China to periodically monitor welding and Quality Control functions. While on site the Quality Assurance Inspector observed and/or discovered the following.

East Shaft Lift 1

The Quality Assurance Inspector observed ZPMC continuing to work in the confined spaces. ZPMC relayed that all the tack welds between the skins have been completed. Approximately 20 ZPMC employees were observed in the shaft.

There still appears to be some distortion in skin plate E. ABF Representative Don Walton stated ABF survey team has surveyed the skin in question and it appears to meet tolerances.

East Shaft, Skin A, Splice Plate

ZPMC had installed two 10 ton hydraulic jacking devices between the interior longitudinal bolted connection plates. No heat was being applied to the part.

South Shaft Lift 1

ZPMC observed fitting up and tack welding Skin C to the diaphragm plates. Approximately 20 ZPMC employees were in the shaft.

ABF Representative Don Walton informed QA that ZPMC was planning on erecting the last skin plate (Skin D) this afternoon.

It was observed that the tacks have been completed between Skin A, E and B.

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South Shaft, Skin D, Lift 1

ZPMC was observed performing base metal repairs to the base metal where temporary lifting aids were removed without prior approval from the Engineer. An incident report was generated pertaining to the discrepancy. Below are digital photographs of the repairs in progress.

South Shaft, Skin A, Lift 2

ZPMC was observed performing in process flux cored arc welding on the semi automated gantry.

Tower Base Plate template

ZPMC was observed removing tarps covering the four templates for the T1 footing.



Summary of Conversations:

As stated in the contents of the above report.

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 137.6471.0411 , who represents the Office of Structural Materials for your project.

Inspected By: Bertlesman, Greg

Quality Assurance Inspector

Reviewed By: Wright, Mark

QA Reviewer