

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-004308**Date Inspected:** 01-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** C.M. 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:** OBG**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Tim McClendon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following.

Bay 1

- 1) GMAW welding in progress on DP545-001
- 2) Machining of edge on 12mm thick plate for U-rib stiffener prior bending in progress

Bay 2

- 3) Machining/beveling 60mm plate for stiffener on tower double diaphragm on going.
- 4) Rolling machine was idle and no Caltrans job at the cutting table

Bay 3

- 5) FCAW at gantry machine number one on SP762-001.
- 6) Gantry machine number two idle.
- 7) FCAW on CJP weld joint on flange (W21x57) splice butt joint on Bottom Panel.
- 8) Tack welding of (W18x46) rib stiffener to Side panel.

Bay 4

- 9) Flame bevel cutting of tower double diaphragm SSD1-SA27B/B continuing.
- 10) SAW (1G) of CJP weld on tower diaphragm plate splice.

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Bay 7

- 11) SAW (1G) of CJP weld on plate splice for Floor Beam assembly.
- 12) Tack/Fit-up of stiffener plates to web plate for Floor Beam assembly.

Bay 8

- 13) Tack/fit-up of 40/60mm web/stiffener to (top) tower double diaphragm NSD1-SA311B/B continues.
- 14) SMAW (3G) PJP welding root pass on 40mm web plate to 60mm stiffener plate.
- 15) SAW (1G) CJP welding root pass on 75mm thick tower diaphragm plate splice butt joint.

Summary of Conversations:

No relevant conversations spoken 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 Dautermann, Peter (707) 552-7715, who represents the Office of Structural Materials for your project.

Inspected By:	McClendon, Timothy	Quality Assurance Inspector
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Reviewed By:	Cuellar, Robert	QA Reviewer
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