

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-004323**Date Inspected:** 28-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. Approximately 20 ZPMC employees were observed in the shaft. ZPMC safety officer was observed using an air monitor within the shaft. Below is a digital photograph. ABF Representative Mike Williams informed the Quality Assurance Inspector that ZPMC and ABF have performed final visual and applicable non destructive testing on Skin Plates A and B. The Quality Assurance Inspector relayed that once we have approval to enter the confined space the inspections would be completed at that time. No work was observed being performed on the exterior of the shaft today.

East Shaft, Skin A, Lift 2

ZPMC was observed continuing to perform fit up and tack welding operations to the longitudinal stiffener to skin plate partial and complete joint penetration weld connections utilizing the shielded metal arc welding process.

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 including seven welders. 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

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

completed between Skin A, E and B.

South Shaft, Skin D, Lift 1

No ZPMC employees were observed working on the assembly today.

South Shaft, Skin A, Lift 2

ZPMC was observed performing in process flux cored arc welding the complete joint penetration connection between the longitudinal stiffeners and the skin plate on the vertical jig.

89M Mock-up

ZPMC was observed grinding an approximate 5 millimeter radius on the corners of the lugs. Heating elements were being installed. ABF Representative Mike Williams informed the Quality Assurance Inspector that ZPMC is planning on beginning welding this afternoon.



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
