

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-004351**Date Inspected:** 30-Sep-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.

South Shaft, Skin E, Lift 1

The Quality Assurance Inspector observed where ZPMC had built up the interior of several of the strut windows at Skin E, of the South Shaft, Lift 1. It appears the shielded metal arc welding process was utilized to perform the build up in the horizontal position. When questioned about the build up, ABF Representative Mike Williams relayed it was due to the fact that the window was cut in the wrong location. Mr. Williams added in order to achieve the required fillet weld size of the doubler plate to skin plate connection it was necessary. Below is a digital photograph illustrating the build up.

South Shaft, Skin B, Lift 1

The Quality Assurance Inspector witnessed ZPMC magnetic particle technician perform magnetic particle testing to the longitudinal stiffeners to skin plate connections. Several areas were marked for repair and were promptly repaired by grinding and retesting. The Quality Assurance Inspector randomly observed several weld access holes with sharp notches that appear to be torch notches. ZPMC Quality Control had previously accepted the part visually. ABF Representative Mike Williams was informed of the discrepancies. After observing the access holes for himself, Mr. Williams stated ZPMC would repair the areas in question. Below is a digital photograph of a weld access with what appears to be a torch notch.

WELDING INSPECTION REPORT

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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.

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| Inspected By: | Bertlesman,Greg | Quality Assurance Inspector |
| Reviewed By: | Wright,Mark | QA Reviewer |
