

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-004352**Date Inspected:** 09-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 continue to perform fit up and tack welding operations between Skin Plate C and the adjacent diaphragm plate partial joint penetration welds.

South Shaft, Lift 1

The Quality Assurance Inspector observed ZPMC continue to perform fit up and tack welding of the 9M, 23M, 28M, 33M, 43M and 47.6M Diaphragm Plate assemblies to the South Shaft, Skin A, assembly partial joint penetration welds.

South Shaft, Skin E, Lift 1

The Quality Assurance Inspector performed a survey measuring the South Tower, Skin Plate E, Lift 1 doubler plate to skin plate windows. The fit-up between the two members does not allow for the detailed 8 mm fillet weld. The detailed land requires 10 mm and the as built condition is as small as 6 mm. A detailed sketch was provided to T.Y. Lin representative Carrol Choi in regards to the exact measurements and locations. The Quality Assurance Inspector generated an incident report pertaining to the discrepancy.

Please note the same condition occurs on Skin Plate A of the South Tower Lift 1, however due to access the measurements have not been completed.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

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
