

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-004384**Date Inspected:** 20-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xie Yan**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/OBG**Summary of Items Observed:**

On this date, Caltrans Office of Structure Materials (OSM) Quality Assurance Inspector (QA) Raymond Lara was present at jobsite in Zhenhua Port Machinery Company facility on Changxing island, China for the purpose of observing and monitoring the fabrication of the tower and OBG.

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The QA performed 25% ultrasonic verification on the Tower double diaphragm plates; SSDI SA 244 1 A/B (65 meter upper diaphragm plate)and ESDI SA 414 1 A/B (65 meter upper diaphragm plate). See Caltrans report TL-6027 Ultrasonic Testing Report, dated October 20, 2008 for additional information.

The QA performed a fit up verification on the PJP joint connections for double diaphragm plate assemblies north 38 meter and north 18 meter. Bevel angles measured 45 to 48 degrees typically on both assemblies. The root gap on both assemblies measured less than a 1 mm.

The QA observed an in process weld repair on weld number SSDI SA 325 1A. The gouged weld repair area measured 35mm in depth and 210mm in length. The weld indication was discovered by ultrasonic testing. And the gouged area appeared to have been found acceptable by ZPMC magnetic particle technicians.

The QA observed ZPMC welders and fitters in process of assembling diaphragm plate flanges.

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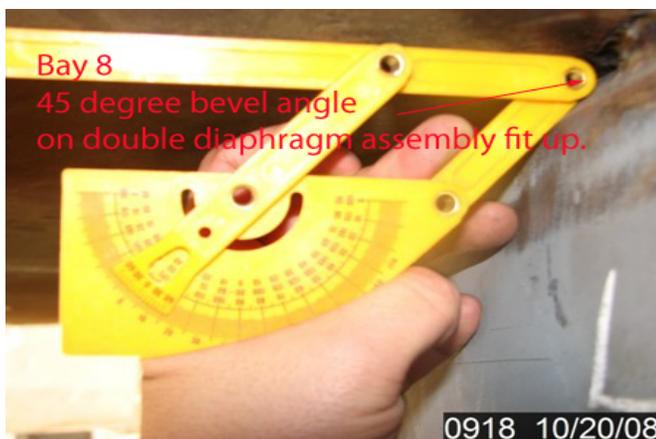
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The QA observed ZPMC personnel repairing by grinding on cover passes on several floor beam assemblies.

The Quality Assurance Inspector observed ZPMC welder 068501, utilizing the flux cored arc welding process on a fillet weld joint on floor beam assembly weld FB-011-020. The Quality Assurance Inspector observed ZPMC Quality Control Personnel record parameters and verify preheat temperatures. The welding parameters observed by the Quality Assurance Inspector appeared to be within welding procedure specification WPS-B-T-2133.

The Quality Assurance Inspector observed ZPMC welder 066687, utilizing the flux cored arc welding process on a fillet weld joint on floor beam assembly weld FB-012-019. The Quality Assurance Inspector observed ZPMC Quality Control Personnel record parameters and verify preheat temperatures. The welding parameters observed by the Quality Assurance Inspector appeared to be within welding procedure specification WPS-B-T-2133.

The Quality Assurance Inspector observed ZPMC welder 044824, utilizing the flux cored arc welding process on a fillet weld joint on floor beam assembly weld FB-004-020. The Quality Assurance Inspector observed ZPMC Quality Control Personnel record parameters and verify preheat temperatures. The welding parameters observed by the Quality Assurance Inspector appeared to be within welding procedure specification WPS-B-T-2133.



Summary of Conversations:

No relevant conversations 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 Joshua Ishibashi, (707) 649-5453, who represents the Office of Structural Materials for your project.

Inspected By: Lara, Raymond

Quality Assurance Inspector

Reviewed By: Wright, Mark

QA Reviewer