

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-004636**Date Inspected:** 30-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 and OBG**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 15 to 20 ZPMC employees were observed in the shaft. ABF Safety employee was present at the badge tracking board. CT is approved to enter confined space. Mactec and sub contractors are not approved. Diaphragm partial joint penetration welds are continuing to be welded to Skins A and B. No work was observed being performed on the exterior of the shaft today.

South Shaft Lift 1

ZPMC was observed fitting up and tack welding Skin C to the diaphragm plates and in the process of welding temporary fitting aids to Skin C where it joins with skin D. Temporary fitting aids and hydraulic jacking devices being installed on Skin E to aid in the fit-up with Skin D.

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.

East Shaft Skin C Splice Plate

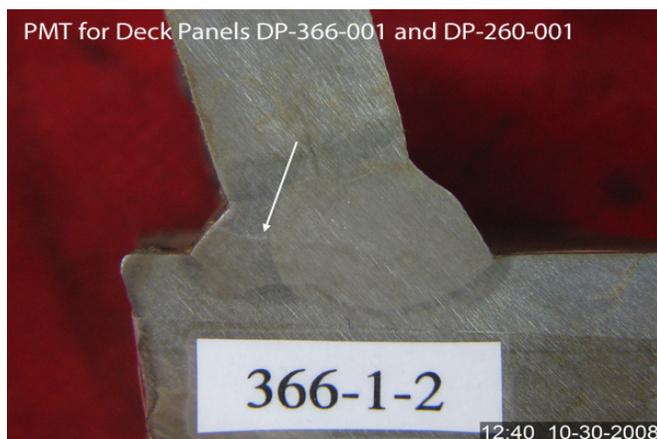
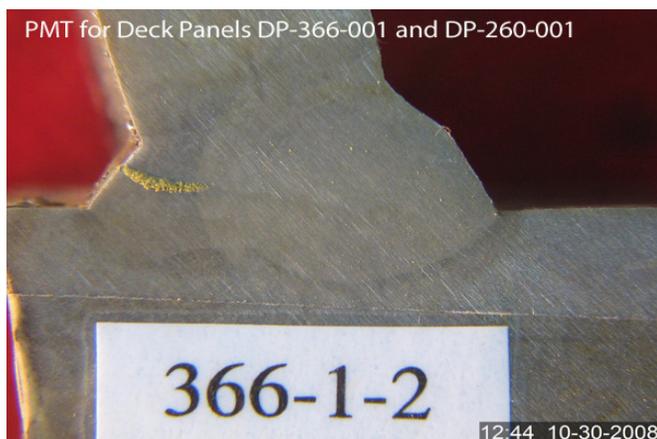
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Two welders were observed performing in process welding of the stiffener to skin plate complete joint penetration welds utilizing the flux cored arc welding process.

Production Monitoring Test Macro Etch Samples

The Quality Assurance Inspector was instructed to perform a second review of the macro etch samples from the PMT welded this morning after it was found compliant by ZPMC, ABF and Caltrans. The PMT was for Deck Panels DP-366-001 and DP-260-001. In addition the instructions were to perform magnetic particle testing to all fifteen samples. The Quality Assurance Inspector observed a crack in sample 366-1-2. Mr. John Kinsey and Structures Materials Representative were made aware of the findings and requested the two digital photographs below.



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