

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025145**Date Inspected:** 13-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**Location:** Shanghai**CWI Name:****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:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector R. Hernandez was present during the time noted above and conducted observations relative to the work being performed.

The QA Inspector randomly observed the following work in progress:

Trial Assembly 13W

This QA Inspector witnessed the in-process high strength bolt installation on bolts connecting the Rib Stiffeners to Rib Stiffeners at the transverse splice at bottom panels between Longitudinal Diaphragms and Side Plates at Cross Beam side at Panel Points PP120 to PP120.5, PP121 to PP121.5, PP122 to PP122.5, & PP123 to PP123.5, for Segment 13W. The QA Inspector verified installation of the high strength bolts on a random basis and the results appeared to be in general compliance.

The bolt sizes used were M24-3.0 x 90 RC Lot # DHGM240123.

Heavy Dock 14E

This inspector entered segment 14E to access the amount of high strength bolting completed in accordance with project plans. At the time of inspection it has been noted that only the bottom plate of FL-3 at crossbeam CB19 has been fully tensioned. All other areas are missing miscellaneous bolts throughout the entire structure. Approximately 10% of bolts are installed but not tensioned.

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Unless otherwise noted above all items observed on this day appeared to be in general compliance with the applicable contract documents



Summary of Conversations:

Pertinent conversations are included in the body of the 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 Eric Tsang 1500-0042-02372, who represents the Office of Structural Materials for your project.

Inspected By:	Hernandez,Rene	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
