

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026030**Date Inspected:** 18-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, China

CWI Name:	N/A	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 Trial Assembly	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) at Trial Assembly Areas

Lift 14 West (Splice Plates)

This QA Inspector witnessed the final bolt tension verification on bolts connecting the Splice Plates to Deck Panel Diaphragm and full height Longitudinal Diaphragm at elevation 4750mm (from Bottom Panel) for Lift 14 East at work point W3 and W4. The QA Inspector verified the bolt tension on a random basis and the results appeared to be in general compliance. The Inspection was performed against Notification No. 00695.

The Splice plates are installed between the following Panel Points at work point E3.

Between PP 125 to PP 125.5 at work point W3.

The bolt sizes used were M24 x 85 RC Lot # DHGM240019 and the final torque value established was 550 N-m.

The bolt sizes used were M24 x 110 RC Lot # DHGM240078 and the final torque value established was 640 N-m.

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Between PP 125 to PP 125.5 at work point W4.

The bolt sizes used were M27 x 95 RC Lot # DHGM270035 and the final torque value established was 647 N-m.

The bolt sizes used were M27 x 120 RC Lot # DHGM270007 and the final torque value established was 863 N-m.

The Manual Torque wrench used was Serial No. XO2-666.

Please reference the pictures attached for more comprehensive details.

Lift 14 East (U-Rib to U-Rib)

This QA Inspector witnessed the final bolt tension verification on bolts connecting the U-Rib to U-Rib at the transverse splice between Panel Points (PP) 127.3 and PP 127.5 for Lift 14 East. The QA Inspector verified the bolt tension on a random basis and the results appeared to be in general compliance. The Inspection was performed against Notification No. 00696 dated July 18, 2011.

The bolt sizes used were M27 x 65 RC Lot # DHGM240037 and the final torque value established was 653 N-m.

The Manual Torque wrench used was Serial No. XO2-676.

Note:

1. Tension verification were only offered at the following locations i.e., 1, 2, 3, 4, 5, 6, 8, 10, 11, 12, 15, 16, 17, 18, 19, 21, 23, 24, 26, 28, 29, 30, and 33 (Total 23 locations) between work point E5 to E20.

2. Tension verification were not offered at the following locations i.e., 7, 9, 14, 22, 25, 31, 32, 34, 35, 36, 37, 38 and 39 (Total 13 locations) between work point E5 to E20.

Lift 14 West (Splice Plates)

This QA Inspector witnessed the final bolt tension verification on bolts connecting the Splice Plates to Anchoring Plate to full height Longitudinal Diaphragm at elevation 4750mm (from Bottom Panel) for Lift 14 West. The QA Inspector verified the bolt tension on a random basis and the results appeared to be in general compliance.

The Splice plates are installed between the following Panel Points at work point W3.

Between PP 125 to PP 126.

The bolt sizes used were M22 x 140 RC Lot # DHGM220140 and the final torque value established was 380 N-m.

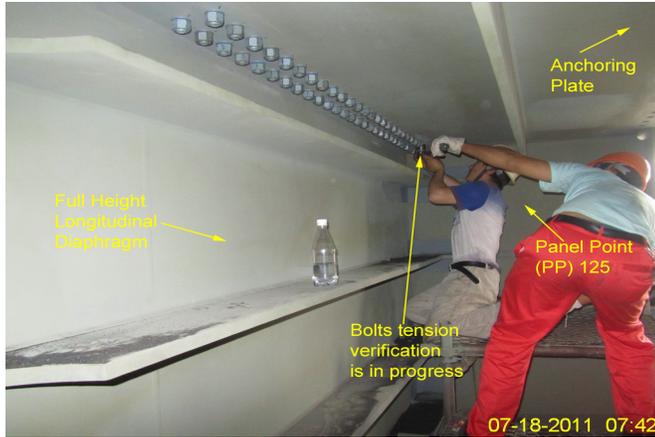
The Manual Torque wrench used was Serial No. XO2-666.

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Please reference the pictures attached for more comprehensive details.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations were reported 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 Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Math,Manjunath

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer
