

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026034**Date Inspected:** 30-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

Segment 13AE (Catwalk)

This Quality Assurance (QA) Inspector witnessed final bolt tension verification for Catwalk structure which is connected to Bottom Panel T-Stiffeners and I-Stiffeners for Segment 13AE at Bottom Panel. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00714.

Inspected the bolts for Catwalk structures between the following Panel Points (PP).

PP 117.5 to PP 118.

PP 119.65 to PP 120

Bolt sizes used were M16 x 40 RC Set# DHGM160045 and final torque required was 180 N-m.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Bolt sizes used were M16 x 45 RC Set# DHGM160021 and final torque required was 180 N-m.

Bolt sizes used were M16 x 50 RC Set# DHGM160004 and final torque required was 180 N-m.

Bolt sizes used were M16 x 55 RC Set# DHGM160012 and final torque required was 200 N-m.

Bolt sizes used were M16 x 60 RC Set# DHGM160052 and final torque required was 173 N-m.

Bolt sizes used were M22 x 55 RC Set# DHGM220011 and final torque required was 457 N-m.

Bolt sizes used were M22 x 100 RC Set# DHGM220049 and final torque required was 493 N-m.

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

Segment 13BE (Catwalk)

This Quality Assurance (QA) Inspector witnessed final bolt tension verification for Catwalk structure which is connected to Bottom Panel I-Stiffeners for Segment 13BE at Bottom Panel. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00714.

Inspected the bolts for Catwalk structures between the following Panel Points (PP).

PP 120 to PP 120.5.

PP 120.5 to PP 121.

PP121 to PP 121.5.

PP121.5 to PP 122.

Bolt sizes used were M16 x 40 RC Set# DHGM160045 and final torque required was 180 N-m.

Bolt sizes used were M16 x 45 RC Set# DHGM160021 and final torque required was 180 N-m.

Bolt sizes used were M16 x 50 RC Set# DHGM160004 and final torque required was 180 N-m.

Bolt sizes used were M16 x 55 RC Set# DHGM160012 and final torque required was 200 N-m.

Bolt sizes used were M16 x 60 RC Set# DHGM160052 and final torque required was 173 N-m.

Bolt sizes used were M22 x 55 RC Set# DHGM220011 and final torque required was 457 N-m.

Bolt sizes used were M22 x 100 RC Set# DHGM220049 and final torque required was 493 N-m.

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

Segment 13CE (Catwalk)

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

This Quality Assurance (QA) Inspector witnessed final bolt tension verification for Catwalk structure which is connected to Bottom Panel I-Stiffeners for Segment 13CE at Bottom Panel. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00714.

Inspected the bolts for Catwalk structures between the following Panel Points (PP).

PP 122.5 to PP 123.

PP 123 to PP 123.5.

PP123.5 to PP 124.

PP124 to PP 124.5.

Bolt sizes used were M16 x 40 RC Set# DHGM160045 and final torque required was 180 N-m.

Bolt sizes used were M16 x 45 RC Set# DHGM160021 and final torque required was 180 N-m.

Bolt sizes used were M16 x 50 RC Set# DHGM160004 and final torque required was 180 N-m.

Bolt sizes used were M16 x 55 RC Set# DHGM160012 and final torque required was 200 N-m.

Bolt sizes used were M16 x 60 RC Set# DHGM160052 and final torque required was 173 N-m.

Bolt sizes used were M22 x 55 RC Set# DHGM220011 and final torque required was 457 N-m.

Bolt sizes used were M22 x 100 RC Set# DHGM220049 and final torque required was 493 N-m.

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

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
---------------------	-------------	-------------