

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-025509**Date Inspected:** 04-Aug-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:

Boat Lift 14E

This QA Inspector witnessed the in-process high strength bolt installation on bolts connecting the following connections:

- Horizontal connection plates between Longitudinal Diaphragms and Floor Beams on E3 and E4 lines from bottom plate elevation to Deck plate elevation between PP125 and PP128.3. Pretensioning and installation in progress.

Bolting on the above named areas is in progress and still requires final tension verification prior to final acceptance. The QA Inspector verified installation of the high strength bolts on a random basis and the results appeared to be in general compliance. No notifications have been issued for these installations.

Boat Lift 13E

This QA Inspector witnessed the final bolt tension verification on bolts connecting connection plates as described

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below and at the locations listed below, 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. 00737 dated August 4, 2011.

- PP120~PP120.5 I-rib at bottom plate E4 to E14.
- PP120~PP120.5 I-rib at bottom plate 13AE + 13BE BK side.
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The bolt sizes used were M27 x 95 RC Lot # DHGM270034 and the final torque value established was 640 N-m, M27 x 110 RC Lot # DHGM270035 and the final torque value established was 650 N-m, M27 x 95 RC Lot # DHGM270023 and the final torque value established was 673 N-m, M27 x 95 RC Lot # DHGM270035 and the final torque value established was 647 N-m, & M27 x 100 RC Lot # DHGM270039 and the final torque value established was 673 N-m.

The Manual Torque wrench used was Serial No. XO2-777.

Boat Lift 13W

This QA Inspector witnessed the final bolt tension verification on bolts connecting connection plates as described below and at the locations listed below, 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. 00738 dated August 4, 2011.

- PP120.5~PP124.5 Diagonal angles between I-rib and Floor Beams @ side plates & bottom plates.
- PP117.5~PP118 Edge Beam at BK and CB sides.

The bolt sizes used were M22 x 55 RC Lot # DHGM220044 and the final torque value established was 473 N-m, M22 x 60 RC Lot # DHGM220046 and the final torque value established was 483 N-m, M22 x 65 RC Lot # DHGM220128 and the final torque value established was 357 N-m & M27 x 95 RC Lot # DHGM270034 and the final torque value established was 647 N-m.

Torque wrench used was Serial No. XO2-777 & X02-676.

Boat Lift 14W

This QA Inspector witnessed the final bolt tension verification on bolts connecting connection plates as described below and at the locations listed below, 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. 00738 dated August 4, 2011.

- PP125~PP128.3 Diagonal angles between I-rib and Floor Beams @ side plates & bottom plates.

The bolt sizes used were M22 x 55 RC Lot # DHGM220044 and the final torque value established was 473 N-m, M22 x 60 RC Lot # DHGM220046 and the final torque value established was 483 N-m, & M22 x 65 RC Lot #

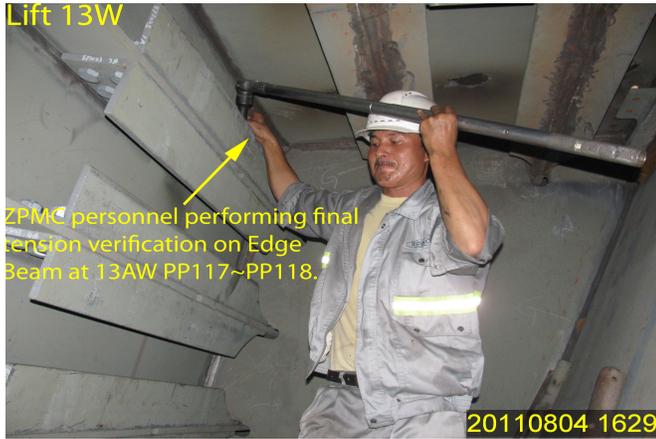
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DHGM220128 and the final torque value established was 357 N-m.

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

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
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Reviewed By:	Hall,Steven	QA Reviewer
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