

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-018450**Date Inspected:** 01-Dec-2010**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)**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 11EW to Segment 12AW (U-Rib to U-Rib at Field Splice)

This QA Inspector performed Dimension Control Inspection for measuring offset along with Caltrans QA Inspector Mr. Murugan Manikandan on the U-Rib to U-Rib from Counter Weight side towards Cross Beam side at a total of 39 locations on Segment 11EW to Segment 12AW (Field Splice) between Panel Points (PP) 108 to PP 109 at the following locations:

The offset was measured within 50mm from the Deck Panel on U-Rib on the South and North side. The QA Inspector measured the Offset using 1(One) Meter Straight Edge.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

ASTM A 490M Bolts for Tower's (Dacromet 320 Coated), Skid More Test at BAY 11

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This QA Inspector witnessed Bolt Testing for ASTM A490 Grade. Observed ZPMC QC Mr. Zou Jian performing bolts testing and ZPMC QA Inspector Mr. Zhao Jianeng was present during the course of Bolt Testing.

The testing of bolts was performed to determining Nut Rotation from Snug-Tight condition for Turn-of-Nut Pre-tensioning and High Tension bolt capability verification test.

Bolt assembly identified as ASTM A490 (High Strength Bolt), Bolt Assembly comprises of (a Bolt, a Nut and a Washer).

Bolt testing was performed on a Unit: Skidmore-Wilhelm; Model: HT; Serial Number: 1014 (Calibration Expiration due date on April 29, 2011) and Torque Wrench identified as XO-326 and Torque Wrench with Dial gauge on it is identified as XO-2 (Calibration Expiration due date on April 14, 2011).

Tested bolt sizes were identified as M30x280 RC Set# DH4DM300037.

Tested bolt sizes were identified as M30x320 RC Set# DH4DM30016.

Tested bolt sizes were identified as M30x320 RC Set# DH4DM300038.

Tested bolt sizes were identified as M30x320 RC Set# DH4DM300039.

5 bolt assemblies were tested per lot.

After testing the bolt size M30x280, RC Set# DH4DM300037, Report # 37 was generated for Nut Rotation from Snug-Tight condition for Turn-of-Nut Pre-tensioning and Report # 263 was generated for High Tension bolt capability verification test. Pertinent Reports was generated by ZPMC QC Mr. Hu Hua Cheng.

After testing the bolt size M30x320, RC Set# DH4DM30016, Report # 16 was generated for Nut Rotation from Snug-Tight condition for Turn-of-Nut Pre-tensioning and Report # 264 was generated for High Tension bolt capability verification test. Pertinent Reports was generated by ZPMC QC Mr. Hu Hua Cheng.

After testing the bolt size M30x320, RC Set# DH4DM300038, Report # 38 was generated for Nut Rotation from Snug-Tight condition for Turn-of-Nut Pre-tensioning and Report # 265 was generated for High Tension bolt capability verification test. Pertinent Reports was generated by ZPMC QC Mr. Hu Hua Cheng.

After testing the bolt size M30x320, RC Set# DH4DM300034, Report # 39 was generated for Nut Rotation from Snug-Tight condition for Turn-of-Nut Pre-tensioning and Report # 266 was generated for High Tension bolt capability verification test. Pertinent Reports was generated by ZPMC QC Mr. Hu Hua Cheng.

The generated reports were submitted to the Caltrans Lead Inspector Mr. Mark Miller and Caltrans Engineer Mr. Aaron Prchlik for review and disposition.

Please reference the pictures attached for more comprehensive details.

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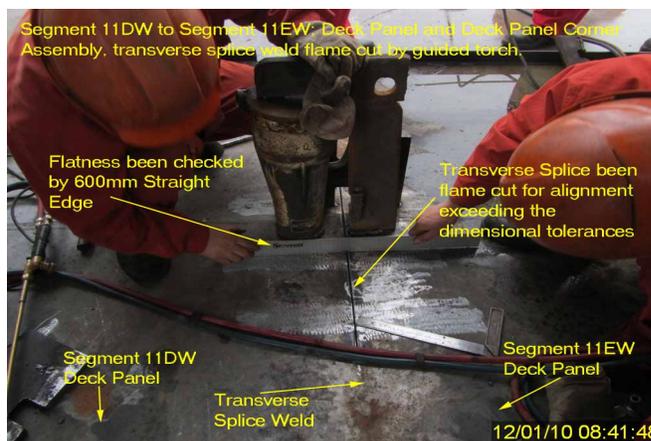
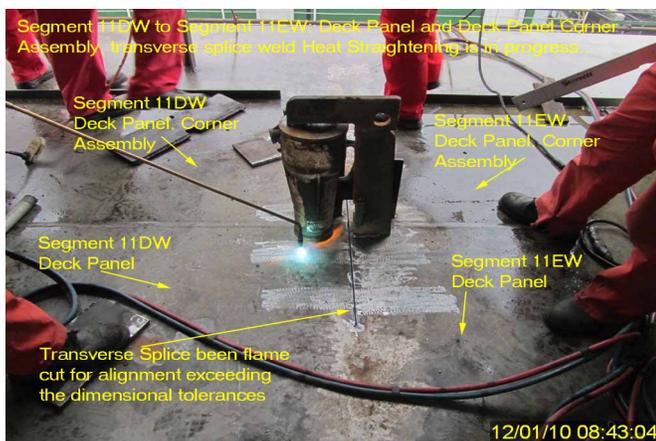
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Segment 11DW to Segment 11EW (Deck Panel Transverse Splice)

This QA Inspector observed transverse splice weld connecting Deck Panel to Deck Panel and Deck Panel Corner Assembly to Deck Panel Corner Assembly, Counter Weight side was flame cut using mechanical guided cutting torch between Segment 11DW to Segment 11EW. The weld joint was designated as OBW11C-007 and OBW11C-008. ZPMC personnel were performing the work against the Welding Repair Report B-WR16610 dated Nov 27, 2010.

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 150000422372, who represents the Office of Structural Materials for your project.

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Inspected By:	Math,Manjunath	Quality Assurance Inspector
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Reviewed By:	Dsouza,Christopher	QA Reviewer
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