

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-018451**Date Inspected:** 30-Nov-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:** Li Yang and Zhu Zhong Hai**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

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

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 determine 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).

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Tested bolt sizes were identified as M30x200 RC Set# DH4DM300032.

Tested bolt sizes were identified as M30x200 RC Set# DH4DM300033.

Tested bolt sizes were identified as M30x230 RC Set# DH4DM300035.

Tested bolt sizes were identified as M30x240 RC Set# DH4DM300034.

Tested bolt sizes were identified as M30x240 RC Set# DH4DM300036.

Tested bolt sizes were identified as M30x260 RC Set# DH4DM30017.

5 bolt assemblies were tested per lot.

After testing the bolt size M30x200, RC Set# DH4DM300032, Report # 32 was generated for Nut Rotation from Snug-Tight condition for Turn-of-Nut Pre-tensioning and Report # 262 was generated for High Tension bolt capability verification test. Pertinent Reports was generated by ZPMC QC Mr. Zou Jian.

After testing the bolt size M30x200, RC Set# DH4DM300033, Report # 33 was generated for Nut Rotation from Snug-Tight condition for Turn-of-Nut Pre-tensioning and Report # 261 was generated for High Tension bolt capability verification test. Pertinent Reports was generated by ZPMC QC Mr. Zou Jian.

After testing the bolt size M30x230, RC Set# DH4DM300035, Report # 35 was generated for Nut Rotation from Snug-Tight condition for Turn-of-Nut Pre-tensioning and Report # 258 was generated for High Tension bolt capability verification test. Pertinent Reports was generated by ZPMC QC Mr. Zou Jian.

After testing the bolt size M30x240, RC Set# DH4DM300034, Report # 34 was generated for Nut Rotation from Snug-Tight condition for Turn-of-Nut Pre-tensioning and Report # 257 was generated for High Tension bolt capability verification test. Pertinent Reports was generated by ZPMC QC Mr. Zou Jian.

After testing the bolt size M30x260, RC Set# DH4DM300036, Report # 36 was generated for Nut Rotation from Snug-Tight condition for Turn-of-Nut Pre-tensioning and Report # 259 was generated for High Tension bolt capability verification test. Pertinent Reports was generated by ZPMC QC Mr. Zou Jian.

After testing the bolt size M30x260, RC Set# DH4DM300017, Report # 17 was generated for Nut Rotation from Snug-Tight condition for Turn-of-Nut Pre-tensioning and Report # 260 was generated for High Tension bolt capability verification test. Pertinent Reports was generated by ZPMC QC Mr. Zou Jian.

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

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

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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.

Inspected By: Math,Manjunath

Quality Assurance Inspector

Reviewed By: Dsouza,Christopher

QA Reviewer