

**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-022214**Date Inspected:** 31-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** 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 Segments**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dan Hernandez was present during the times noted above to observe the fit up, welding and related activities associated with the fabrication of the San Francisco Oakland Bay Self Anchored Suspension Bridge at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

OBG Trial Assembly Yard

Segment 12BE

This QA Inspector observed the installation of cantilever box bracket at panel point 113 for fit up.

Segment 13AW

This QA Inspector observed ABF personnel performing Ultrasonic Testing on the Side Plate to Bottom Plate longitudinal splice, cross beam side.

This QA Inspector observed back gouging of the root pass on the Bottom Plate I-rib to Floor Beam connection.

Segment 12BW

This QA Inspector observed ABF personnel performing Magnetic Particle Testing on the Cantilever Bracket to

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Edge Plate connection at top and bottom flange and web.

QA Verification

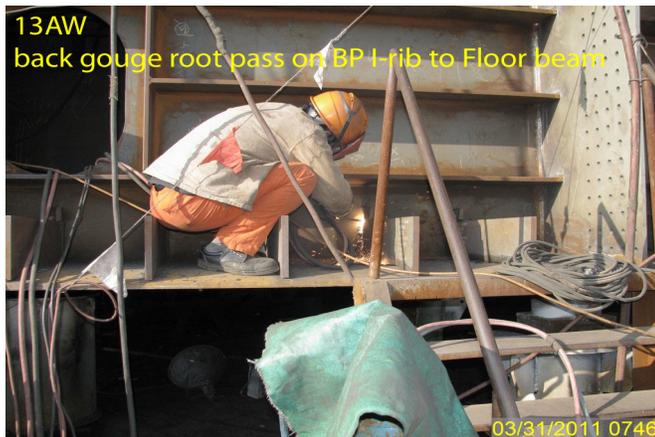
BAY 11 - Bolt Testing Room

This QA Inspector observed ZPMC personnel performing Rotational Capacity testing and Pre-installation verification of required torque for A325 High Strength Bolt assemblies (bolt, nut, washer) with a Skidmore-Wilhelm Model: MS, serial number: 15866 (calibration expiration date 4/29/11) and torque wrench identified as #2 (calibration expiration date 4/14/11) on the following bolts:

- M22x65 Lot Number # DHGM 220128
- M22x65 Lot Number # DHGM 220130
- M22x65 Lot Number # DHGM 220129
- M22x65 Lot Number # DHGM 220131
- M22x65 Lot Number # DHGM 220132
- M22x70 Lot Number # DHGM 220137
- M22x80 Lot Number # DHGM 220140

5 bolt assemblies were tested per lot

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.

## 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, 150-0042-2372 , who represents the Office of Structural Materials for your project.

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**Inspected By:** Hernandez, Dan

Quality Assurance Inspector

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**Reviewed By:** Miller, Mark

QA Reviewer