

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-023168**Date Inspected:** 01-May-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 12AW (FL3 to Bottom Plate)

This QA Inspector witnessed the final bolt tension verification on bolts connecting the Bottom Plate to FL3 Flange and Bottom Panel to Bottom Plate at Panel Points (PP) 110, PP 111 and PP 112 for Segment 12AW. 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. 00668 dated April 31, 2011.

The bolt sizes used were M24 x 60 RC Lot # DHGM240001 and the final torque value established was 633 N-m.

The bolt sizes used were M24 x 65 RC Lot # DHGM240013 and the final torque value established was 967 N-m.

The bolt sizes used were M24 x 65 RC Lot # DHGM240013 and the final torque value established was 540 N-m.

The bolt sizes used were M24 x 70 RC Lot # DHGM240119 and the final torque value established was 633 N-m.

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

Note: At work point W4, PP 110; PP 111 and PP 112 bolts not installed at Sea Fastening interference locations.

Please reference the pictures attached for more comprehensive details.

Lift 12 East (X37B Brackets)

This QA Inspector performed Dimension Control Inspection for the Segment 12AE, Segment 12BE and Segment 12CE and measured the distance between road barrier bolt hole drilled at X37B from deck panel to the cope hole at X37B bracket installed at Corner Assembly at east and west side of the X37B brackets at following locations and verified the locations where ZPMC has taken corrective action for rectifying the out of tolerance areas.

At Panel Point (PP) 109.75, Cross Beam side.

At Panel Points (PP) 110.25 and PP 110.75, Cross Beam side.

At Panel Points (PP) 111.25 and PP 111.75, Cross Beam side.

At Panel Points (PP) 112.25 and PP 112.75, Cross Beam side.

At Panel Points (PP) 113.25 and PP 113.75, Cross Beam side.

At Panel Points (PP) 114.25 and PP 114.75, Cross Beam side.

At Panel Points (PP) 115.25 and PP 115.75, Cross Beam side.

Note: At PP 109.25 and PP 116.75, X37A bracket not installed due to manhole entry opening, thus not dimensional inspection performed.

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.

Traveler Rail behind Paint Shop # 1

This QA Inspector witnessed the final bolt tension verification on bolts connecting the Traveler Rail at Paint Shop # 2. The QA Inspector checked the gap between the faying surface of Angle piece which is installed at Traveler Rail web to the Traveler Rail flange by using 6" machinist ruler with 1mm thick and the results appeared to be in general compliance. The Inspection was performed against Inspection request of ZPMC QA Mr. Zhong Wei.

The following Traveler Rails were inspected in Paint Shop # 2 during the course of inspection Mr. Tian Lei (ZPMC QC) was available along with QA Inspector.

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Traveler Rail # 11TR2-003

Traveler Rail # 11TR2-014

Traveler Rail # 11TR1-027

Traveler Rail # 10TR3-001

Traveler Rail # 10TR2-015

Traveler Rail # 11TR1-006

Traveler Rail # 10TR1-002

Traveler Rail # 10TR2-003

Traveler Rail # 11TR3-023

Traveler Rail # 11TR3-005

Traveler Rail # 11TR2-002

Traveler Rail # 11TR3-028

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

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your project.

Inspected By: Math,Manjunath

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer