

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-025284**Date Inspected:** 21-Jul-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:

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

- Rib stiffeners to Rib stiffeners between E3 and E4 at PP120 to 124.5. Full Tensioning in progress.
- U-rib stiffeners to U-rib stiffeners between E3 and E4 lines at PP120 to PP124.5. Full tensioning 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.

This inspector conducted review of the following high strength bolts brought out to Segment 13 W for installation at connections requiring the size and length required as specified on contract drawings. All bolts were found to have been sampled and tested in accordance with AISC standards and in accordance RCSC 2000 edition:

M24x75 - Set No. DHGM240020, Lot No.(s) PR991Z, PS121Z, & C2442Z.

M27x120 - Set No. DHGM270020, Lot No.(s) SB571Z, PR731Z, & C1371Z.

M27x95 - Set No. DHGM270035, Lot No.(s) PR991Z, PS121Z, & C2442Z.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA Inspector witnessed the final bolt tension verification on bolts connecting the Bottom Plate to FL-3 at Panel Point (PP) 118 to Panel Point (PP) 120 Segment 13AE. The QA Inspector verified the bolt tension on a random basis and the results appeared to be in general compliance. The Inspection was performed in against Notification No. 00702 dated July 21, 2011.

The bolt sizes used were M24 x 95 RC Lot # DHGM240021 and the final torque value established was 540 N-m.
The bolt sizes used were M24 x 130 RC Lot # DHGM240128 and the final torque value established was 470 N-m.
The bolt sizes used were M24 x 170 RC Lot # DHGM240098 and the final torque value established was 620 N-m.

The Manual Torque wrench used was Serial No. XO2-600.

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
Reviewed By:	Hall,Steven	QA Reviewer
