

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-025507**Date Inspected:** 06-Aug-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:

Boat Lift 13AE

This QA Inspector witnessed the final bolt tension verification on bolts connecting connection plates as described below and at the locations listed below, 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. 00744, 00745, & 00748 dated August 6, 2011.

- MEP angles at 13AE PP119 + 1500.
- Angles for steel barrier rails at bottom side of deck plate PP117.5~PP124.5.
- Catwalk Platform and Ladder at PP120.
- Traveler Rail support sub assemblies PP118~PP123.

The bolt sizes used were M20 x 60 RC Lot # DHGM200021 and the final torque value established was 373 N-m, M22 x 120 RC Lot # DHGM220090 and the final torque value established was 451 N-m, M22 x 100 RC Lot # DHGM220049 and the final torque value established was 493 N-m, M22 x 55 RC Lot # DHGM220044 and the final torque value established was 473 N-m, M20 x 160 RC Lot # DHGM200006 and the final torque value

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established was 340 N-m, & M20 x 150 RC Lot # DHGM200023 and the final torque value established was 340 N-m, M22 x 120 RC Lot # DHGM220145 and the final torque value established was 497 N-m, M20 x 100 RC Lot # DHGM200044 and the final torque value established was 277 N-m, & M20 x 70 RC Lot # DHGM200034 and the final torque value established was 267 N-m.

Torque wrench used was Serial No. XO2-666.

Boat Lift 13W

This QA Inspector witnessed the final bolt tension verification on bolts connecting connection plates as described below and at the locations listed below, 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. 00749 dated August 6, 2011.

- Architectural housing heavy flange connections at grillage area.

The bolt sizes used were M22 x 80 RC Lot # DHGM220140 and the final torque value established was 380 N-m, M22 x 90 RC Lot # DHGM220141 and the final torque value established was 353 N-m, M22 x 75 RC Lot # DHGM220111 and the final torque value established was 340 N-m, M22 x 85 RC Lot # DHGM220014 and the final torque value established was 473 N-m & M22x110 RC Lot#DHGM2200067 and the final torque established was 500 N-m.

The Manual Torque wrench used was Serial No. X02-666.

Boat Lift 14W

This QA Inspector witnessed the final bolt tension verification on bolts connecting connection plates as described below and at the locations listed below, 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. 00749 & 00750 dated August 6, 2011.

- Diaphragm Angle at PP125 CB side.
- Longitudinal Diaphragm anchor plate W3 to W4 lines.

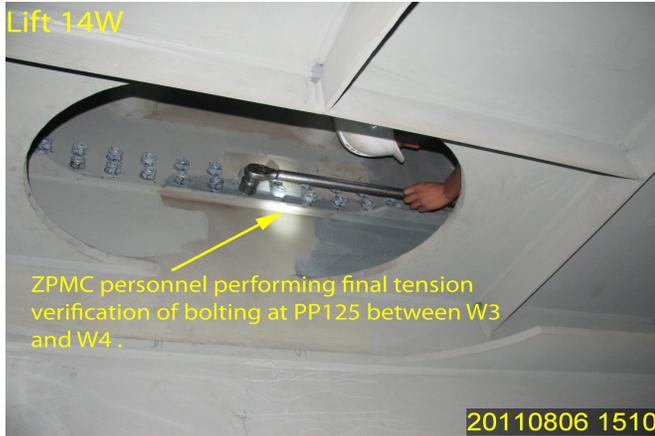
The bolt sizes used were M22 x 65 RC Lot # DHGM220128 and the final torque value established was 357 N-m, M22 x 70 RC Lot # DHGM220137 and the final torque value established was 400 N-m, M22 x 80 RC Lot # DHGM220140 and the final torque value established was 380 N-m, & M22 x 95 RC Lot # DHGM220142 and the final torque value established was 367 N-m.

The Manual Torque wrench used was Serial No. X02-666.

Unless otherwise noted above all items observed on this day appeared to be in general compliance with the applicable contract documents

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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
