DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 99.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-025511
Date Inspected: 29-Jul-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
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 13E

This QA Inspector witnessed the final bolt tension verification on bolts connecting the U-rib stiffeners at deck panels and Longitudinal diaphragms at deck panels 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. 00718 dated July 29, 2011.

- PP124 to PP124.5, U-rib stiffeners at deck panel to deck panel (counter weight side).
- PP121 to PP121.5, U-rib stiffeners at deck panel to deck panel (counter weight side).
- PP123 to PP123.5, U-rib stiffeners at deck panel to deck panel (counter weight side).

The bolt sizes used were M22 x 65 RC Lot # DHGM220128 and the final torque value established was 357 N-m. The Manual Torque wrench used was Serial No. XO2-600.

Boat Lift 14E

This QA Inspector witnessed the final bolt tension verification on bolts connecting the U-rib stiffeners 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. 00718 dated July 29, 2011.

- PP127 to PP127.5, U-rib stiffeners at deck panel to deck panel (counter weight side).

The bolt sizes used were M27 x 65 RC Lot # DHGM270037 and the final torque value established was 653 N-m.
The bolt sizes used were M27 x 75 RC Lot # DHGM270030 and the final torque value established was 587 N-m.
The Manual Torque wrench used was Serial No. XO2-600.

This QA Inspector witnessed the final bolt tension verification on bolts connecting the Cable tray & ITS base Supports 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. 00719 dated July 29, 2011.

- PP125 to PP126 @ W3 to W4, Cable Tray & ITS Base Supports.

The bolt sizes used were M27 x 65 RC Lot # DHGM270037 and the final torque value established was 653 N-m.
The bolt sizes used were M27 x 75 RC Lot # DHGM270030 and the final torque value established was 587 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.

WELDING INSPECTION REPORT

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Inspected By:	Hernandez,Rene	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer