

**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-025513**Date Inspected:** 31-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:

Boat Lift 14E

This QA Inspector witnessed the final bolt tension verification on bolts connecting connection plates to Anchorage Plates and Deck 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. 00722 dated July 31, 2011.

- PP125 to PP127, AP3008A~AP3011A connected to DP3162A~DP3166A.

The bolt sizes used were M24 x 80 RC Lot # DHGM240121 and the final torque value established was 487 N-m.  
The bolt sizes used were M24 x 85 RC Lot # DHGM240015 and the final torque value established was 517 N-m.  
The bolt sizes used were M24 x 85 RC Lot # DHGM240016 and the final torque value established was 490 N-m.  
The bolt sizes used were M24 x 95 RC Lot # DHGM240007 and the final torque value established was 540 N-m.  
The Manual Torque wrench used was Serial No. XO2-600.

Boat Lift 14W

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# WELDING INSPECTION REPORT

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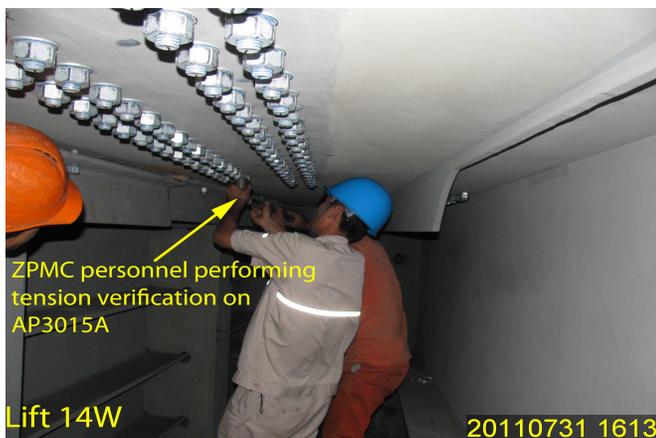
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This QA Inspector witnessed the final bolt tension verification on bolts connecting connection plates to Anchorage Plates and Deck Plates as described below and at the locations listed below, The QA Inspector verified the bolt tension on a random basis and the results appeared to be in general compliance. The Inspection was performed against Notification No. 00723 dated July 31, 2011.

- PP125 to PP127, AP3013A~AP3016A connected to DP3168A~DP3171A.

The bolt sizes used were M24 x 95 RC Lot # DHGM240124 and the final torque value established was 453 N-m.  
The bolt sizes used were M24 x 85 RC Lot # DHGM240019 and the final torque value established was 550 N-m.  
The bolt sizes used were M24 x 80 RC Lot # DHGM240121 and the final torque value established was 487 N-m.  
The Manual Torque wrench used was Serial No. XO2-777.

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.

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<b>Inspected By:</b>	Hernandez,Rene	Quality Assurance Inspector
<b>Reviewed By:</b>	Hall,Steven	QA Reviewer

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