

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-025514**Date Inspected:** 01-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 14E

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. 00726 dated August 1, 2011.

- PP125 to PP126, SEG 3019E to SEG3019Z.

The bolt sizes used were M22 x 75 RC Lot # DHGM220014 and the final torque value established was 473 N-m.
The bolt sizes used were M22 x 80 RC Lot # DHGM220140 and the final torque value established was 380 N-m.
The bolt sizes used were M22 x 85 RC Lot # DHGM220121 and the final torque value established was 383 N-m.
The bolt sizes used were M22 x 90 RC Lot # DHGM220141 and the final torque value established was 353 N-m.
The bolt sizes used were M22 x 110 RC Lot # DHGM220067 and the final torque value established was 500 N-m.
The Manual Torque wrench used was Serial No. XO2-600.

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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. 00726 dated August 1, 2011.

- PP121 to PP121.5 @ W14 inside Architectural Housing.
- PP122 to PP122.5 @ W14 inside Architectural Housing.
- PP125 Anchorage Plate elevation access holes.

The bolt sizes used were M24 x 75 RC Lot # DHGM240020 and the final torque value established was 600 N-m. The bolt sizes used were M27 x 95 RC Lot # DHGM270095 and the final torque value established was 641 N-m. 21 and the final torque value established was 383 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

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Reviewed By: Hall,Steven

QA Reviewer