

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025701**Date Inspected:** 25-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	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 Components	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Vessel Zhenghua #19

This QA Inspector also randomly observed the following on the Vessel Zhenghua #19 in response to Bolting Inspection Notification Sheet No. 00710:

Item 1 - OBG Segment 13AE/13BE, DP U-rib splice #1~25 (#26 and #27 were not at the job site as listed): ZPMC workers performed final ASTM A325M bolt tightening verification of bolt sets noted below at the direction of ZPMC QC Zhang Lin (QC1) using ZPMC calibrated wrench #X02-600. No less than 10% of the ASTM A325 bolt sets at each connection were torque tested. QC1 provided this QA Inspector with the following information regarding the bolt sets installed at this location. This QA Inspector observed ZPMC's Bolt Test Log for SFOBB (RoCap list), listing the RoCap Set numbers, bolt set size, and the NM test result for torque tightening purposes. The information presented by QC1 and listed below appeared to this QA Inspector to match the RoCap list as follows:

Bolt sets - RC Set No. DHGM220128 – M22x65 – test result 357NM

Bolt sets - RC Set No. DHGM220140 – M22x80 – test result 380NM

Bolt sets - RC Set No. DHGM220121 – M22x85 – test result 393NM

The torque of the above noted bolt sets was verified by torque testing with the above noted calibrated wrench with

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the wrench setting displayed as 360NM for the M22x65 bolt sets and 400NM for the M22x80 and M22x85 bolt sets at the direction of QC1. Based on the information above this concurred with QC1 for the issuance of green tag numbers.

Item 2 - OBG Segment 13BE, DP U-rib splice #1~25 (#26 and #27 were not at the job site as listed): ZPMC workers performed final ASTM A325M bolt tightening verification of bolt sets noted below at the direction of QC1 using ZPMC calibrated wrench #X02-600. No less than 10% of the ASTM A325 bolt sets at each connection were torque tested. QC1 provided this QA Inspector with the following information regarding the bolt sets installed at this location. This QA Inspector observed ZPMC's Bolt Test Log for SFOBB (RoCap list), listing the RoCap Set numbers, bolt set size, and the NM test result for torque tightening purposes. The information presented by QC1 and listed below appeared to this QA Inspector to match the RoCap list as follows:

Bolt sets - RC Set No. DHGM220128 – M22x65 – test result 357NM

The torque of the above noted bolt sets was verified by torque testing with the above noted calibrated wrench with the wrench setting displayed as 360NM at the direction of QC1. Based on the information above this concurred with QC1 for the issuance of green tag numbers.

Items 3 and 4 were cancelled by ZPMC QA Zhang Wei by phone to this QA Inspector.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted above.

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, 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet,George	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
