

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-025888**Date Inspected:** 06-Aug-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2100**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** ShangHai, China

CWI Name:	Sha Zi	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:

Summary of Items Observed: On this date Caltrans OSM Quality Assurance(QA) Inspector, DJ Shin was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress for ZPMC testing lab.

ZPMCQC Inspector has performed rotational capacity testing for M24 x 70 (Lot No 240110), M24 x120 (Lot No220145) with use skidmore Wilhelm Model: HT Serial No: 1014, Model No: MS, Serial No: 15866 These two bolt tension calibrator was out of calibration date. Calibration due date was 04-29-2011 on calibration sticker. ZPMC Used dial type torque wrench serial No: 2.

This date QA inspector was issued incidental report for ZPMC used out of calibration bolt tension calibrator.

Description of Incident: During Quality Assurance (QA) witness of rotational capacity and torque value testing at ZPMC, this QA Inspector discovered the following issue:

-Skidmore dial gage (Model MS/Serial number 15866) exceeded its one year re-calibration date which expired on 4-29-2011.

-The following rotational capacity set numbers had been tested with this non-calibrated equipment on 08-07-11: for DHGM200145. These are bolts to be used in Lifts 13 and 14.

-Skidmore dial gage (Model HT/Serial number 1014) exceeded its one year re-calibration date which expired on

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4-29-2011.

-The following rotational capacity set numbers had been tested with this non-calibrated equipment on 08-07-11: for DHGM240110. These are bolts to be used in Lifts 13 and 14.

- The QA inspector asked ZPMC QC Zhang Hai Jun for the documentation of the calibration for Model HT/Serial number 1014. ZPMC was not able to provide the Skidmore-Wilhelm calibration documentation for the date shown as expiring 8/2011.

-Tests mentioned above were satisfactory based on this out of calibration Skidmore.

-The Skidmore is located in the ZPMC testing facility.

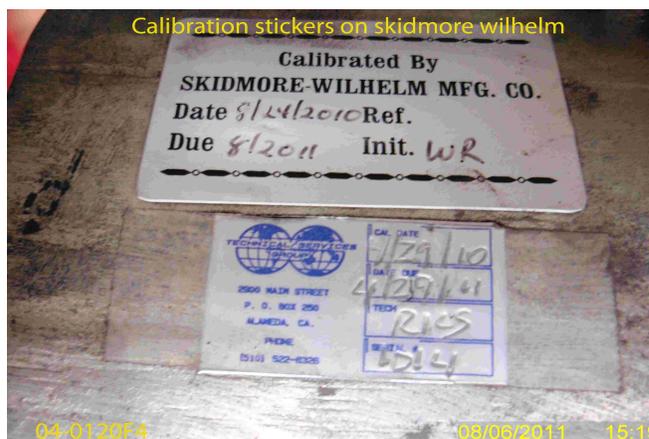
Applicable reference:

Standard Specifications July, 1999 Steel Structures, Section 55-3.14 Bolted Connections:

“The Contractor shall provide, calibrate and maintain the equipment and tools necessary for the preliminary testing, installation and inspection of all fasteners. Bolt tension measuring devices and calibrated wrenches shall be calibrated within one year prior to first being used on the job, and a minimum of once each year thereafter. This calibration shall be done by a qualified independent laboratory or authorized warranty repair and calibration center recognized by the tool manufacturer”.

“Prior to the use of bolt tension measuring devices or calibrated wrenches, the Contractor shall furnish to the Engineer certificates of calibration with plots of verification readings for each device or wrench”.

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



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Summary of Conversations:

No relevant conversations

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 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Shin,DJ	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
