

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-026017**Date Inspected:** 02-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, 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 Trial Assembly	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) at Trial Assembly Areas

Segment 13AE to Segment 13BE (U-Rib to U-Rib)

This QA Inspector witnessed the final bolt tension verification on bolts connecting the U-Rib to U-Rib at the transverse splice between Panel Points (PP) 120 and PP 120.5 for Segment 13AE to Segment 13BE. 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. 000732 dated August 02, 2011.

The bolt sizes used were M22 x 65 RC Lot # DHGM220128 and the final torque value established was 357 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 393 N-m.

The Manual Torque wrench used was Serial No. XO2-777.

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Note: U-Rib located at 28, 29, 30, 31, 32, 33, 34, 35, 36, 37, 38 and 39 (between work point E3 towards E20) was only offered for inspection.

Segment 13BE to Segment 13CE (U-Rib to U-Rib)

This QA Inspector witnessed the final bolt tension verification on bolts connecting the U-Rib to U-Rib at the transverse splice between Panel Points (PP) 122 and PP 122.5 for Segment 13AE to Segment 13BE. 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. 000732 dated August 02, 2011.

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. XO2-777.

Note: U-Rib located at 28, 29 and 30 (between work point E3 towards E20) was only offered for inspection.

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

Summary of Conversations:

No relevant conversations were reported on this date.

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:	Math,Manjunath	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
