

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-026021**Date Inspected:** 06-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

Lift 13 CW (Manhole Angle)

This QA Inspector witnessed final bolt tension verification on bolts connecting Angle plate to full height Longitudinal Diaphragm below the manhole at work point W4 (Cross Beam side) and at work point W3 (Counter Weight side) between Panel Points (PP) 122.5 to PP 123 for Segment 13 CW. Inspected the bolt tensioning on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00670 Dated May 02, 2011.

The bolt sizes used were M22 x 75 RC Lot # DHGM220014 and the final torque value established was 473 N-m.

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

Lift 13 AW (Rectangular Hollow Bar)

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This QA Inspector witnessed final bolt tension verification on bolts connecting Angle plate to Floor Beam below the Rectangular Hollow Bar at work point W4 (Cross Beam side) and at work point W3 (Counter Weight side) at Panel Points (PP) 119(+1500) and PP 119(-1500) for Segment 13 AW. Inspected the bolt tensioning on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00746 Dated August 7, 2011.

The bolt sizes used were M20 x 65 RC Lot # DHGM200031 and the final torque value established was 393 N-m.

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

Please reference the pictures attached for more comprehensive details.

Lift 13 West

This QA Inspector along with Caltrans QA Inspector Mr. Christopher Ferruci photographed the Partial interior for the paint issues at various locations prior to the shipment of (Voyage 9) en-route to Yerba Buena Island, California, USA. The Segment 13AW, Segment 13BW and Segment 13CW is located on ZPMC Ship Zhenhua # 19 berth at jetty # 5.

The Segments are identified as following.

Segment 13 West at Panel Points (PP) 117.5, 118.35, 119(-1500) west side, PP 119(+1500) east side, PP 120, PP 120.5, PP 121, PP 121.5, PP 122, PP 122.5, PP 123, PP 123.5, PP 124 and PP 124.5 between work point W3 and W4.

And

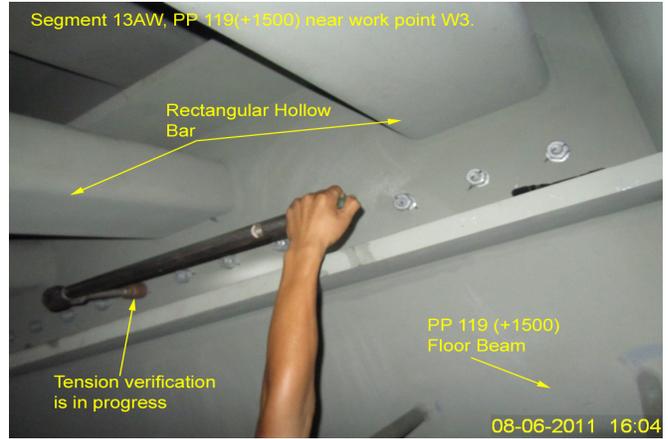
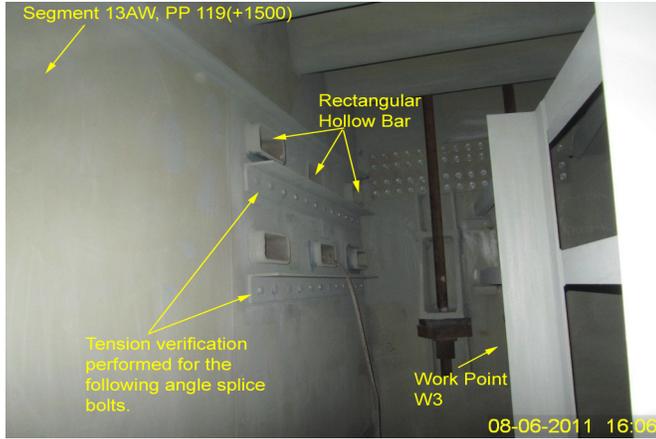
Segment 13 West at Panel Points (PP) PP 120, PP 120.5, PP 121, PP 121.5, PP 122, PP 122.5, PP 123, PP 123.5, PP 124 and PP 124.5 between work point W4 and W16.

The following locations are where the photographs were taken and the photographs are available for review upon request.

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 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