

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-026026**Date Inspected:** 26-Jul-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 14 East (Catwalk)

This Quality Assurance (QA) Inspector witnessed final bolt tension verification for Catwalk structure which is connected to Bottom Panel I-Ribs for Segment 14 East at Bottom Panel. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00711 Dated July 26, 2011.

Inspected the bolts for Catwalk structures between the following Panel Points (PP).

PP 125 to PP 125.5.

PP 125.5 to PP 126

PP126 to PP 126.5

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

PP126.5 to PP 127

PP 127 to PP 127.3

PP 127.3 to PP 127.5

PP 127.5 to PP 128

PP 127.5 to PP 128

PP 128 to PP 128.3 and

PP 128.3 to PP 128.7

Bolt sizes used were M16 x 40 RC Set# DHGM160045 and final torque required was 180 N-m.

Bolt sizes used were M16 x 55 RC Set# DHGM160012 and final torque required was 200 N-m.

Bolt sizes used were M16 x 65 RC Set# DHGM160006 and final torque required was 180 N-m.

The Manual Torque wrench used was Serial No. XO2-426.

Please reference the pictures attached for more comprehensive details.

Segment 13AE (Catwalk at FL3)

This Quality Assurance (QA) Inspector witnessed final bolt tension verification for Catwalk structure which is connected to Bottom Plate I-Ribs at FL3 area between Panel Points (PP) 118 and PP 119.35 for Segment 13AE. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00711 Dated July 26, 2011.

Bolt sizes used were M16 x 45 RC Set# DHGM160010 and final torque required was 200 N-m.

Bolt sizes used were M16 x 50 RC Set# DHGM160011 and final torque required was 200 N-m.

The Manual Torque wrench used was Serial No. XO2-426.

Segment 13CE (Transverse Splice I-Ribs)

This QA Inspector witnessed final bolt tension verification on bolts connecting I-Rib to I-Rib for Transverse Splice at Bottom Panel, Cross Beam side (from work point E4 towards E14) and Cross Beam side (from work point E14 to E16) between Panel Point (PP) 124 to PP 124.5 for Segment 13CE. Inspected the bolt tensioning on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

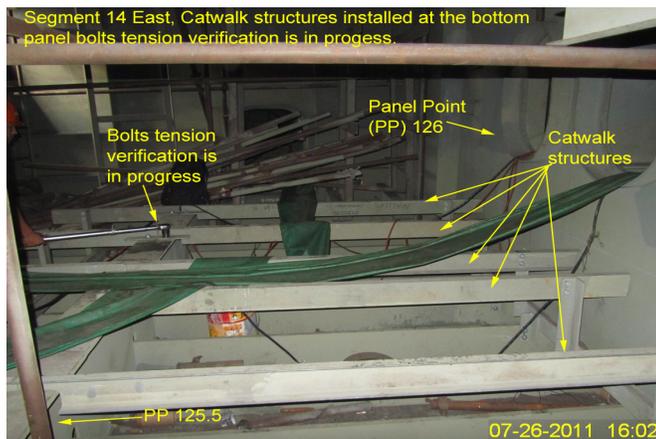
No. 00711 Dated July 26, 2011.

Work Point E4 towards Work Point E14 (Bottom Panel) total 6 T-Ribs.

Work Point E14 towards Work Point E16 (Side Panel Cross Beam Side) total 17 T-Ribs.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

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.

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

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