

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-026035**Date Inspected:** 23-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
Bridge No:	34-0006	Delayed / Cancelled:	Yes	No N/A
		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 13AW (FL3 to Bottom Plate)

This QA Inspector witnessed the final bolt tension verification on bolts connecting the Bottom Plate to FL3 Flange and Bottom Panel to Bottom Plate at Panel Points (PP) 118 (west side), 118.35 (east and west side), 119 (east and west side) and 119.65 (east and west side) for Segment 13AW. 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. 00704 dated July 23, 2011.

The bolt sizes used were M24 x 95 RC Lot # DHGM240021 and the final torque value established was 540 N-m.

The bolt sizes used were M24 x 130 RC Lot # DHGM240128 and the final torque value established was 787 N-m.

The bolt sizes used were M24 x 170 RC Lot # DHGM240098 and the final torque value established was 807 N-m.

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The bolt sizes used were M30 x 100 RC Lot # DHGM300012 and the final torque value established was 967 N-m.

The Manual Torque wrench used was Serial No. XO2-666.

Lift 14 East (Catwalk)

This Quality Assurance (QA) Inspector witnessed final bolt tension verification for Catwalk structure installed at FL3 Bottom Plate between Panel Point (PP) 125 and PP 126. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00706 dated July 23, 2011.

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

Bolt sizes used were M16 x 50 RC Set# DHGM160004 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.

The Manual Torque wrench used was Serial No. XO2-666.

Please reference the pictures attached for more comprehensive details.

Lift 13 East

This Quality Assurance (QA) Inspector observed Lift 13 East (comprising Segments 13AE, 13BE and 13CE) is lifted from the OBG Trail Assembly to place it on the ZPMC ship # 19, which is berth at jetty # 5.

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.

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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
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Reviewed By:	Miller,Mark	QA Reviewer
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