DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-026131
Date Inspected: 03-Aug-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 1500
OSM Departure Time: 300
Location: Shanghai, China

CWI Name:
Inspected CWI report: ☐ Yes ☐ No ☑ N/A
Electrode to specification: ☐ Yes ☐ No ☑ N/A
Qualified Welders: ☐ Yes ☐ No ☑ N/A
Approved Drawings: ☑ Yes ☐ No ☐ N/A

CWI Present: ☐ Yes ☑ No
Rod Oven in Use: ☐ Yes ☐ No ☑ N/A
Weld Procedures Followed: ☐ Yes ☐ No ☑ N/A
Verified Joint Fit-up: ☐ Yes ☐ No ☑ N/A
Approved WPS: ☐ Yes ☐ No ☑ N/A
Delayed / Cancelled: ☐ Yes ☐ No ☑ N/A

Bridge No: 34-0006
Component: OBG 13/14 E and 13/14 W

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector Robert A. DeArmond was present during the time noted above and conducted observations relative to the work being performed.

ZHENHUA SHIP #19

This QA Inspector witnessed the final bolt tension verification on 13BW and 13CW; bolts connecting the Rib Stiffener Splice at Bottom Plate located between PP 121~121.5 and 122~122.5, Crossbeam side. This 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. 00736; items 2 and 3 dated August 3, 2011. The following bolt assemblages were utilized:

PP121~121.5
M27 x 95 RC Lot # DHGM270035 and the final torque value established was 640 N-m.

PP122~122.5
M24 x 95 RC Lot # DHGM240021 and the final torque value established was 540 N-m.

The Manual Torque wrench used was Serial No. XO2-114.

This QA Inspector witnessed the final bolt tension verification on 13BW; bolts connecting the Rib Stiffener Splice at South Bottom and Edge Plate located between PP 122~122.5, Crossbeam side. This 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. 00736; items 2 and 3 dated August 3, 2011. The following bolt assemblages were utilized:

PP122~122.5
M24 x 95 RC Lot # DHGM240021 and the final torque value established was 540 N-m.
M24 x 90 RC Lot # DHGM240123 and the final torque value established was 467 N-m.

The Manual Torque wrench used was Serial No. XO2-114.

This QA Inspector witnessed the final bolt tension verification on 13BW bolts; connecting the Rib Stiffener Splice at South Side Plate and Bottom Plate located between PP 123~123.5 and 124~124.5, Crossbeam side. This 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. 00736; items 4 and 5 dated August 3, 2011. The following bolt assemblages were utilized:

PP 123~123.5 and 124~124.5
M24 x 90 RC Lot # DHGM240123 and the final torque value established was 467 N-m.

The Manual Torque wrench used was Serial No. XO2-114.

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

Summary of Conversations:

As mentioned above between QA and QC concerning this project

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, 150000422372, who represents the Office of Structural Materials for your project.

Inspected By:	DeArmond,Robert	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer