

DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge Program

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September 15, 2009

Contract No. 04-0120F4
04-SF-80-13.2 / 13.9
Self-Anchored Suspension Bridge
Letter No. 05.03.08-000028

Michael Flowers
Project Executive
American Bridge/Fluor, A JV
375 Burma Road
Oakland, CA 94607

Dear Michael Flowers,

Lift-One Segment to Segment Transverse Splice Weld with Transverse Linear Indications

On September 14, 2009, the Department detected numerous transverse indications in the OBG Lift 1AAW – 1AW segment splice welds utilizing visual inspection, magnetic particle testing (MT) and ultrasonic testing (UT). Several of these indications were confirmed to be crack defects with magnetic particle testing or visual inspection in the excavated repair area. Additional transverse indications have also been detected in the welds that do not exceed the threshold of the code for rejection, but are characteristic of crack indications nonetheless. Those indications were detected by the Department utilizing UT with a 45-degree shear waver transducer in accordance with the requirements of AWS D1.5 Section 6.26.3. The Department would like to collaborate with ABF to jointly examine and confirm that these welds do not contain cracks.

Therefore, the Department directs ABF to further explore Lift 1AAW – 1AW segment splice welds. Please provide grinders to excavate portions of the welds, removing no more than 2mm per pass, followed by MT of each excavated groove, as directed by the Engineer. All work shall be performed in the presence of the Engineer.

Additionally, until such excavations occur, the Engineer deems transverse indications as a “welding problem” without an approved repair procedure in the Contractors approved WQCP. Until the above assessment is completed, the Contractor shall follow the provisions in Section 8-3.01 to request approval to repair transverse indications. The Contractor is reminded, “No remedial work shall begin until the repair procedures are approved in writing by the Engineer.

Please contact Doug Coe if you would like to discuss this matter further or have any questions.

Sincerely,

GARY PURSELL
Resident Engineer

cc: R. Morrow, P. Siegenthaler, M. Wahbeh, J. Tom, P. Lowry
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