

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011996**Date Inspected:** 11-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name:	Bernard Docena/Steve McConnell			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:	Orthotropic Box Girder (OBG) 4 East		

Summary of Items Observed:

Quality Assurance (QA) Inspector Michael Foerder was on site between the times noted above at the job site as part of the arrival inspection team to perform a general arrival inspection and review of the exterior of lift 4 East. In addition the QA inspector performed periodic reviews of the in process work being performed by Quality Control (QC) and ABF personnel. The following is a list of the items observed; see individual item numbers in the body of this report for further details.

1. Exterior Sea Fastening Support Locations.
2. Top Deck Plate Wood Support Frame.
3. Bottom Plate Wood Support Frame.
4. Transverse Tie Locations.
5. W OBG Connection Points.
6. In process work at Pier 7.

The QA inspectors arrived at the pier at 0800 and met with ABF personnel, Caltrans Structure personnel, the Structure Material Representative (SMR) and the QC inspection team for a brief general safety and orientation meeting prior to entering and accessing OBG Lift 4 East. The South side of lift 4 East has been previously reviewed by QA with no significant issues observed on 2/1/10. The following areas and observations were reviewed and noted:

LIFT 4 EAST

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Item 1 Exterior Sea Fastening Support Locations.

Access to the exterior of the OBG for the North side was not possible at the time of review due to the positioning of the North side being towards the water and not the pier.

Item 2 Top Deck Plate Wood Support Frame - No apparent issues observed. It was noted the lifting block attachments will stay in place on the top deck plate until the OBG is erected in the field. The contact points of the attachments will need to be reviewed at these locations at a later date. No apparent issues were observed in the general area surrounding them at this time.

Item 3 Bottom Plate Wood Support Frame

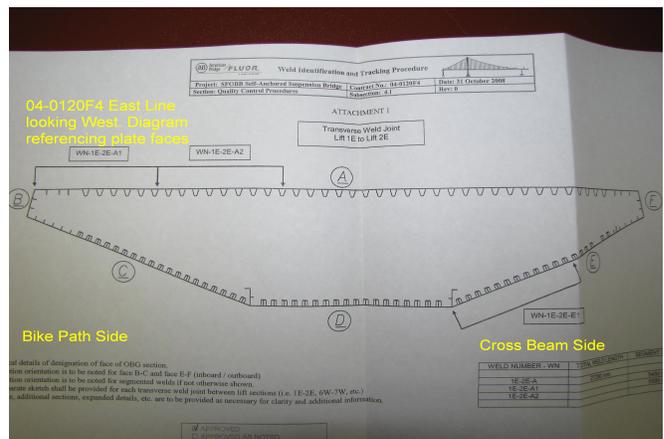
No apparent issues observed. The contact points from the barge and the OBG currently have bearing pads in place with no apparent issues observed in the general area.

Item 4 Transverse Tie Locations – No apparent issues observed.

Item 5 W OBG connection point – No apparent issues observed.

Item 6

The QA inspector noted ABF personnel are in the process of periodically placing the components for scaffolding, welding, lighting, walkways, temporary bolts and other miscellaneous items in preparation of mobilizing lift 4 East to the erection site. QC personnel Steve McConnell, Jesus Cayabyab and Bernard Docena were noted to be present at the West and East end of the OBG verifying and documenting the bevel preparation for the transverse field splice locations for each plate face. See the diagram in this report for the face designations. The QC personnel were observed measuring and documenting the field measurement locations for future Ultrasonic Testing purposes in regards to how the location of the closed ribs, fillet weld at the closed ribs and the root face will all interact with one another during ultrasonic testing after field welding. This item is being performed at the request of QCM Jim Bowers with the intent to assist in the interpretation of the multiple UT reflectors anticipated to be present during future testing. The QA inspector spoke with the QC inspectors and the QC lead Leonard Cross briefly in regards to how this process will be documented and initiated in the field. The items observed appeared to be in general conformance with the contract documents.



Summary of Conversations:

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As noted above in summary of items observed.

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 Mohammad Fatemi (916)813-3677, who represents the Office of Structural Materials for your project.

Inspected By:	Foerder, Mike	Quality Assurance Inspector
Reviewed By:	Levell, Bill	QA Reviewer
