

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 #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012228**Date Inspected:** 19-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name:	Mike Johnson, Steve McConnell, Jesse Cayab	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:	SAS OBG 1E/2E	

Summary of Items Observed:

The Quality Assurance (QA) Inspector, Rick Bettencourt was on site at the job site between the times noted above. The QA Inspector was on site to randomly observe the in process fit up of the 1E/2E-D and 1E/2E-A. The following observations were made.

- 1.) 1E/2E-D QA preliminary VT and installation of the temporary steel backing bar
- 2.) ABF QCM conversation with QA Inspector detailing the buttering and joint Restoration.
- 3.) Joint prep and paint removal of 2E/3E-A

1E/2E-D

The QA Inspector randomly observed the steel backing was previously installed on the outside of the joint. The QA Inspector randomly observed the ABF welder Rory Hogan and helper continuing to perform fit up tasks to bring the bring the above identified complete joint penetration (CJP) groove weld within the tolerances of the contract requirements. The QA Inspector observed the Smith Emery (SE) Quality Control (QC) Inspectors Tom Pasqualone, Jesse Cayab and Mike Johnson performing visual testing (VT) and dimensional verifications of the above identified weld joint. The QA Inspector randomly observed and performed additional QA verifications of the QC Inspectors findings. It was randomly observed and noted by the QA Inspector the off set of the above identified weld joint appeared to be no more than 3mm in various locations and appeared to be with the tolerances of the contract requirements. The QA Inspector randomly observed ABF welders Jordan Hazelaar and Mitch

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Sittinger setting up the FCAW machines and gas lines in preparation of future welding.

The Welding Quality Control Manager (WQCM) Jim Bowers was on site to observe the fit up of the above identified weld joint. Mr. Bowers informed the QA Inspector, ABF will be utilizing the approved ABF WPS identified as ABF-WPS-D1.5-3040A-1 rev. 0. Mr. Bowers went on to inform the QA Inspector the 1E/2E-D will require joint restoration and buttering prior to conforming to the above identified WPS. The QA Inspector was informed by Mr. Bowers flux cored arc welding dual shield or FCAW-G will be utilized and welded along the bevel face with bridging the root gap or tying in the root. Mr. Bowers went on to inform the QA Inspector once the root gap and bevel angle meet the requirements of the joint detail B-U2a-GF, the fit up will be inspected and accepted by SE QC and production welding will begin.

The QA Inspector observed the SE QC Inspectors have broken down the 1E/2E-D weld joint into 19 sections or weld identifications. It was observed the above identified weld joint is identified as 1E/2E-D-1 – 1E/2E-D-19. The QA Inspector was informed by the SE QC Inspector Mike Johnson the above identified weld joint fit up, root and completed weld will be inspected and identified as D1-D19 separate welds. It was noted no welding was performed on this date.

2E/3E-A

The QA Inspector randomly observed the above identified CJP weld joint is being prepared prior to completing the pushing together of the two OBG's. The QA Inspector noted the two OBG's appeared to be approximately 2' apart and ABF personnel utilizing flapper discs removing the paint from the bevel and root face along with the paint up to approximately 3" from the edge of the joint (pictured below).



Summary of Conversations:

As noted above.

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.

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Inspected By:	Bettencourt,Rick	Quality Assurance Inspector
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Reviewed By:	Levell,Bill	QA Reviewer
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