

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-012276**Date Inspected:** 23-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Tom Pasqualone**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 Girders (OBG)**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project. The following observations were made:

- 1) OBG Suspender Bracket Installation
- 2) OBG field splice fit-up

1) The QAI observed ABF personnel placing the suspender bracket shims on the North side (Counterweight side) of the OBG. At the time of observations, the OBG lift was located on a barge at pier 7. The QAI was unable to access the top deck to make observations of the fit of the suspender brackets. See the attached photo. The QAI noted that other personnel are working on the barge and it appeared that they were performing general duties. There were no observations of ABF personnel welding or bolting at pier 7.

2) The QAI observed the installation and fillet welding of temporary fit up aids on side plate C, OBG lifts 1E/2E field splice. The temporary fillet welding was performed by ABF welder James Zhen, ID 6001. The QAI observed the Quality Control (QC) Inspector Tom Pasqualone monitoring the welding of the fit up aids at this location. The QAI was informed that shielded metal arc welding (SMAW) with 1/8" E7018 electrodes and Welding Procedure Specification (WPS) ABF-WPS-D15-F1200A-1 is being used for the temporary fillet welds. The QAI made random observations of welding parameters and preheat temperature which were noted as 135 DC amps and a minimum temperature of 70°F. The QAI noted that the workmanship appeared to be generally conforming to the contract requirements. The QAI was informed that the outside will be tack welded with fit up

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

gear and that the backing bar will be installed. This work was in progress at the end of the QAI shift. See the attached photo.



Summary of Conversations:

The QAI relayed the observations of shim plate installation and OBG fit up / temporary welding to the QAIs Bill Levell and Rick Bettencourt. There were general discussions of the work schedule and the status of welding on OBG lifts 1E/2E D plate splice. There were no other notable observations or conversations during this shift.

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: Croff, Scott

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer
