

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-012374**Date Inspected:** 27-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Mike Johnson, Jesse Cayabayab**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-D**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 joint restoration and welding of the 1E/2E-D.

The following observations were made:

1E/2E-D3/D4

The QA Inspector noted the above identified areas of the weld joint are areas that fall under weld repair report number 201002-002. The area to be welded was preheat to the minimum required preheat of 200°F prior to the ABF welder performing the FCAW butter pass and joining the two member by welding. After the FCAW butter pass was completed the QA Inspector randomly observed the QC Inspector perform magnetic particle testing (MT).

The QA Inspector noted the QC Inspector did not locate any relevant indications at the time of the testing. The QA Inspector randomly observed the ABF welder identified as Jordan Hazelaar begin performing flux cored arc welding (FCAW) root/fill passes at the above identified section of the complete joint penetration (CJP) groove weld. The QA Inspector randomly verified the minimum required preheat utilizing a temperature indicating marker. It was noted the minimum required preheat was maintained above 200°F at the commencement of welding.

The QA Inspector randomly observed the SE QC Inspector set the FCAW machine to 264 Amps, 23.4 Volts and a travel speed of 318mm/min. The QA Inspector noted the ABF welder was utilizing the established welding parameters from the ABF WPS designated D1.5-3110-1.

1E/2E-D13

The QA Inspector randomly observed the ABF welder identified as Jeremy Doleman begin performing FCAW of the above identified section of the CJP groove weld. The QA Inspector randomly verified the minimum required

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preheat utilizing a temperature indicating marker. It was noted the minimum required preheat was maintained above 200°F at the commencement of welding. The QA Inspector randomly observed the SE QC Inspector set the FCAW machine to 247 Amps, 23.7 Volts and a travel speed of 375mm/min. The QA Inspector noted the ABF welder was utilizing the established welding parameters from the ABF WPS designated D1.5-3140-B-1.

The QA Inspector noted the ABF welding personnel was a skeleton crew of two welders once foreman and two QC Inspectors.

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.

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