

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1x.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012444**Date Inspected:** 02-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2130**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Bernie Docena**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:** 1E-2E Bottom plate field weld splice**Summary of Items Observed:**

At the start of the shift the Quality Assurance Inspector (QAI) traveled to the project site and observed the following work performed by American Bridge/Fluor (ABF) personnel at the 1E/2E Bottom plate field splice:

A: 1E-2E Field weld splice at bottom plate.

A) The (QA) inspector witnessed the post weld heat treatment on segments 1E-2E, D1 & D2 segment D11. The (QA) The welding was performed by ABF personnel Jordan Hazelaar (2135) and Rick Clayborn (2773). The QA Inspector also observed Quality Control (QC) inspector Bernie Docena verify the FCAW welding parameters and the surface temperatures during the welding process and the average readings were noted as follows: 263 amps, 23.5 volts with a travel speed measured between 340mm and 320mm per minute. The surface temperature was noted by the (QC) Inspector and was noted as follows. The minimum preheat temperature of 100°F and the maximum interpass temperature of 230°F. The welding was completed on the noted segment during the shift. A (VT) visual inspection was performed on the completed segments by ABF (QC) Inspector Bernie Docena.

QA inspector Gary Richmond spent the remaining portion of the shift reviewing the contract documents for this project that include the welding quality control plan, special provisions, standard specifications, contract drawings and office of structural materials practices and procedures (OSMPP).

Summary of Conversations:

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No relevant conversations noted at this time.

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 Mohammed Fatemi (916)-227-5298, who represents the Office of Structural Materials for your project.

Inspected By:	Richmond,Gary	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
