

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-012449**Date Inspected:** 05-Mar-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, Tom Pasqualone, JCWI, JCSmith	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-A	

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-A, The following observations were made:

1E/2E-A3-5

Upon the arrival of the QA Inspector it was randomly observed the ABF welding operators Jeremy Doleman and Rory Hogan were setting up the submerged arc welding (SAW) machines in preparation of continuing the SAW fill pass. The QA Inspector randomly observed the ABF welding operator Jeremy Doleman continue welding the SAW fill passes in the center of A3 and weld to the end of section A5. The QA Inspector randomly observed the SAW parameters and they were 560 Amps, 32.5 Volts and a travel speed of 381mm/min. The QA Inspector noted the SAW parameters appeared to be in general compliance with ABF-WPS-D1.5-4042B-1.

1E/2E-A3-1

The QA Inspector noted the ABF welder Rory Hogan continued performing the SAW fill passes from the center of A3-A1. The QA Inspector randomly observed the SAW parameters and they were 565 Amps, 32.5 Volts and a travel speed of 381mm/min. The QA Inspector noted the SAW parameters appeared to be in general compliance with ABF-WPS-D1.5-4042B-1. The QA Inspector noted both of the above identified welders had filled the weld joint to approximately 30% at 0930. The QA Inspector noted the Smith Emery (SE) Quality Control (QC) Inspectors Jim Cunningham and Tom Pasqualone were on site to monitor the in process SAW through out the duration of the shift. The QA Inspector noted the SAW parameters did not vary from the above noted SAW parameters.

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The QA Inspector Mike Foerder replaced the QA Inspector Rick Bettencourt on the job site at approximately 1000. The QA Inspector sent the remainder of the shift performing WQCP review and organization of the submittal 1106 revisions 1-13. The QA Inspector was updating and performing organizational duties in of the original submittal and all approved revisions up to today's date of 3/5/10. The QA Inspector continued creating the QA reference guide for QA duties, weld tracking and traceability, extent and frequency of non destructive testing and all approved welding procedures submitted by ABF.

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
