

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-012458**Date Inspected:** 02-Mar-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:** Jim Bowers**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:**

Quality Assurance inspector (QA) Michael Foerder was at the American Bridge/Flour (ABF) job site lay down yard at Pier 7 in Oakland, California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

1. Lift 2 West Erection Preparation
2. Lift 3 West Erection Preparation
3. Project Files

Item 1 Lift 2 West

The QA inspector periodically observed a four man crew of ABF personnel performing the grinding/buffing and removal of the coating from the bevel edges and weld hold back areas of faces A, B, D and E on this date. In addition, ABF personnel are in the process of periodically placing components for scaffolding, welding, lighting, walkways, temporary bolts and other miscellaneous items in preparation of mobilizing the lift to the erection site.

Lift 3 West Erection Preparation

The QA inspector noted ABF personnel are in the process of periodically placing the components for scaffolding, welding, lighting, walkways, temporary bolts and other miscellaneous items in preparation of mobilizing this lift to the erection site. This work progressed periodically throughout the shift.

Project Files

The QA inspector spent a portion of the shift updating the contract files and tracking logs for QA reports, welder

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qualification records, welding procedure specifications, procedure qualification records, state letters and submittals on this date.

Summary of Conversations:

Early in the shift the QA inspector spoke with Welding Quality Control Manager (WQCM) Jim Bowers in which Mr. Bowers requested the QA inspector to review and green tag release a plate for further processing. The specific plate was to be utilized for the insert at lift 2 West for the vertical full height shear plate repair. The QA inspector requested the Mill Test Report (MTR) for the plate in question and Mr. Bowers relayed the information will be forthcoming.

At approximately 1000 Mr. Bowers relayed to the QA inspector the MTR was missing required information for the use of the plate, specifically the Charpy impact values and the use of fine grain practice and therefore would not need the plate tagged for further processing. The QA inspector reviewed the plate and verified the heat number prior to this information and noted it to be M13724 with the dimensions noted as $\frac{3}{4}$ x 48 x 96.

After this conversation the QCM spoke to QA inspectors Mike Foerder and Robert Mertz in regards to the pre heat and interpass requirements for the 20mm deck plate (face A) at field splice 1. Mr. Bowers relayed due to the thickness, heat input, the welding procedure specification and AWS D1.5 the contractor understood maintaining the pre heat and interpass temperature and hold time detailed in the special provisions did not apply for this thickness of weld. The QA inspectors reviewed the information, the WPS, AWS D1.5 section 12, filler metal documentation for hydrogen percentage and concurred with this assessment based on the review and the special provisions and relayed this information to the Structure Materials Representative Pat Lowry. A short while later the WQCM relayed the contractor was not planning on working throughout the night on face A and the QA inspector informed Assistant Structure Representative Jason Wilcox and the METS personnel schedule for the 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.

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| Inspected By: | Foerder, Mike | Quality Assurance Inspector |
| Reviewed By: | Levell, Bill | QA Reviewer |
