

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-012628**Date Inspected:** 11-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name:	William Norris		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	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 Lift 2W repairs

1) The QAI arrived at the ABF facilities at Pier 7 to observe repairs of components on OBG L2W. The QAI observed ABF personnel preparing the replacement plate to be spliced into longitudinal connection plate, line W3, panel point 13. The QAI noted that there was a damaged plate that has been cut out and the base metal is being beveled for the repair splice welding. The QAI also noted that the 18.5mm thick, 675mm tall x 530mm wide replacement plate is cut, beveled and appears to be conforming to the repair procedure specification (ABF weld repair report #201002-001, dated 2-15-2010). The QAI noted that the Quality Control (QC) Inspector William Norris is monitoring the work in progress. The QAI was informed that shielded metal arc welding (SMAW) with 1/8" E7018 electrodes will be used with Welding Procedure Specification (WPS) ABF-WPS-D15-F1200A-1 for the fillet welds and ABF-WPS-D15-1010 for the complete joint penetration (CJP) splice welds. The QAI noted that Al McDaniel, ID 2690, will be making the repair welds. The QAI was shown the repair as it was fit up and was informed by the QC Inspector that it's fit-up is acceptable and will be welded. The QAI noted that the fit-up appeared to be generally conforming to the repair procedure specification. See the attached photo. The QAI made random observations of welding parameters and preheat temperature which were noted as 110 DC amps and a minimum temperature of 70°F. The QAI noted that the fillet welding was in progress at the end of the work shift and the repair was approximately 20% complete. The QAI was informed that this work will continue tomorrow,

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3-12-2010.

During the fit up of the replacement plate, the QAI noted that a 37mm radius weld access hole (cope) was cut into the corner of the plate where it will intersect the OBG L1W/L2W plate D field splice. The QAI was informed that this cope will also be cut into the existing longitudinal connection plate at the opposite side of the OBG segment. See the attached photo. The QAI noted that on OBG L2E there is a similar condition that has been previously reported. The QC Inspector informed the QAI that ABF will cut those copes at a later time.



Summary of Conversations:

As noted above, the QAI had conversations with the QC Inspector regarding the fit-up, repair and weld cope modifications that were observed. There were also general conversations regarding the status of the work in progress. The QAI relayed the observations of OBG repair welding QAI Bill Levell. 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
