

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 #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012663**Date Inspected:** 15-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:	William Norris, Bonifacio Daquinag			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:

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 repairing a damaged section of the OBG Lift 2W. The QAI noted that the original plate has been cut out and the 675mm tall x 530mm wide replacement plate is being spliced into longitudinal connection plate, line W3, panel point 13. The QAI noted that the repair is being performed with repair procedure specification (ABF weld repair report #201002-001, dated 2-15-2010). The QAI noted that the Quality Control (QC) Inspectors William Norris and Bonifacio Daquinag Jr are monitoring the repair welding in progress. The QAI was informed that shielded metal arc welding (SMAW) with 1/8" E7018 electrodes is being 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 and John Rosas, ID 1480, will be making the repair welds. See the attached photo. The QAI made random observations of welding parameters and preheat temperature which were noted as 120 DC amps and a minimum temperature of 70°F. The QAI was informed that this work will continue tomorrow, 3-12-2010. After the 1st side of the double bevel CJP splice welds were completed, the QAI observed the back-gouged side being inspected in preparation for welding. The QAI witnessed the QC Inspector Bonifacio Daquinag Jr conducting Magnetic Particle Testing (MT). The QAI was informed that the back-gouged joint was ready for additional welding and that no relevant

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indications were observed. The QAI conducted verification MT on the back-gouge. See the TL-6028 report for additional information. See the attached photo. The QAI noted that the welding was in progress at the end of the work shift and the repair was approximately 70% complete.

During this shift, the QAI reviewed the most recent approved addenda to the contractor's Welding Quality Control Plan (WQCP) ABF submittal 1106 rev. 16. The QAI was compiling the updated list of approved welders and noted that the welder Al McDaniel, ID 2690, does not appear to be listed as approved for SMAW process. The QAI brought this to the attention of the QC Manager Jim Bowers. The QAI was informed that the welder has the necessary documentation and it will be submitted for approval by the Engineer, as he has been certified to weld by the contractor. The QAI noted that the welder is not welding at this time.



Summary of Conversations:

As noted above, the QAI had conversations with the QC Inspector regarding the repair welding and MT of the back-gouge. There were also general conversations regarding the status of the work in progress. Also as noted above, upon discovery of the un-approved welder, the QAI brought that information to the attention of the QC Inspectors and the QC Manager. 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
