

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-012766**Date Inspected:** 22-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name:	Listed below.		
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
Component:	Orthotropic Box Girders (OBG)		

Bridge No: 34-0006**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 L1E/L2E - field splice back gouging
- 2) OBG L2E/L3E - deck plate A clean-up and inspection.
- 3) OBG L1E/L2E - back welding

1) The QAI observed ABF personnel using plasma arc torches and grinders to remove the backing bars from the bottom of OBG L1E/L2E plate D field splice. The QAI observed that the plasma arc torch is set onto a semi-automatic track and is in the process of cutting through / gouging off the backing bars. This work was in progress at the end of the work shift. The QAI also observed ABF personnel grinding the inside of edge plate B field splice. The QAI noted that welding is completed and the work is being done before final inspection of the weld.

2) The QAI observed ABF personnel using grinders to remove the weld reinforcement of L2E/L3E deck plate A field splice. The QAI noted that welding is completed, the grinding work is being done before the final inspection of the weld and Quality Control (QC) Inspectors are conducting Ultrasonic Testing (UT) on the sections of weld that have been ground smooth. The QAI also noted that ABF personnel are re-positioning welding equipment, induction heaters and generally preparing for welding of other field splices. The QAI noted that rejectable indications have been identified by the QC Inspectors during their UT inspection. This work was in progress at

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the end of the shift.

3) The QAI observed ABF personnel welding plate F at L1E/L2E field splice. The QAI noted that this CJP weld is being completed after the backing bar has been removed. The QAI noted that the QC Inspector James Cunningham is monitoring this welding. The QAI observed ABF worker Chun Fai Tsui, ID 3426, making the welds with gas shielded flux cored arc welding (FCAW-G). The QAI was informed that welding procedure specification (WPS) ABF-WPS-D15-3040B-3 rev.0 is being used for this welding. The QAI randomly measured the preheat, interpass temperature and welding parameters and noted that they appeared to be conforming to the WPS requirements. The QAI noted that the welding is completed and being ground flush and smooth before final inspection.

Summary of Conversations:

As noted above, the QAI had general conversations with the QC Inspectors and ABF personnel regarding the work in progress. The QAI was informed that rejectable indications have been identified during inspection of the L2E/L3E deck A field splice weld. The QAI relayed the status of work to the QAI Bill Levell. The QAI also generated a shift turn-over report with this information. 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
