

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-012937**Date Inspected:** 07-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1515**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 L2E/L3E - plate D QC inspection
- 2) OBG L1W/L2W - plate A field splice welding

1) The QAI observed ABF Quality Control (QC) Inspectors Jesus Cayabyab and James Cunningham conducting Ultrasonic Testing (UT) of the completed field splice welds at plate D on OBG lifts 2E/3E. The QAI noted that the UT was being performed on the bottom of the plate and that the weld has been ground to a generally flush and smooth contour. The QAI was informed that there were rejectable indications that have been identified by the QC Inspectors. The QAI was informed that the repairs will not be performed during this shift.

2) The QAI observed ABF personnel welding plate A at OBG lifts 1W/2W field splice. The QAI noted that this complete joint penetration (CJP) weld is being made in segment A1, A2, A3, A4 & A5. The QAI noted that the QC Inspector Tom Pasqualone is monitoring this welding. The QAI observed ABF workers Jordan Hazelaar, ID 2135, and Bryce Howell, ID 5591, making the welds with submerged arc welding (SAW). The QAI noted that the weld has been documented to have non-conforming misalignment and was accepted as being fit-up by ABF QC personnel. The QAI was informed that additional mis-alignment has become visible during the welding. The QC Inspector also informed the QAI that they have not been given direction on restoring the mis-aligned areas of weld.

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The QAI was informed that welding procedure specification (WPS) ABF-WPS-D15-4040A-1 is being used for this welding. The QAI noted that Mr. Hazelaar is welding from the end of segment A5 to the middle of segment A3 and the opposite end is being welded by Mr. Howell. During the shift, the QAI randomly measured the preheat, interpass temperature and welding parameters and noted that they appeared to be conforming to the WPS requirements. This welding was in progress at the end of the QAI's shift.

Summary of Conversations:

As noted above, the QAI had conversations with the QC Inspectors performing UT. The QAI had other general conversations with the QC Inspectors regarding the observed work in progress. The QAI relayed the observations of OBG splice welding to the QAI Danny Reyes and the QAI Lead 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
