

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-013100**Date Inspected:** 09-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See Below**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 at Yerba Buena Island in 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. OBG Field Inside Splice 3E/4E E1
2. OBG Inside Field Splice 3E/4E C1

Field Splice 3E/4E E1 (First side-inside)

The QA inspector periodically observed the in process Flux Cored Arc Welding (FCAW-G) being performed by ABF welding personnel Mitch Sittinger and Song Tao Huang. QC inspector Jessie Cayabyab was noted to be present in order to monitor the progress and ensure the welding was within the established Welding Procedure Specification (WPS) noted as ABF-WPS-D1.5-3042B-1 and supporting Procedure Qualification Records (PQR). Prior to initiating the welding QC inspector Bonafacio Daquinag was observed performing a visual inspection of the fit-up tolerances and determined them to be in compliance with the contract documents and the QA inspector concurred with the exception of the previously noted area of off-set located where the edge and side plates converge. The welder and helper increased the root opening by grinding in order to comply with the WPS requirements in areas identified by the QC inspector. The preheat and interpass temperature was verified by the QC and QA inspector to be greater than 65° Celsius (C) and the parameters were verified to be within the heat input for the established WPS for the root pass. The work progressed throughout the shift, was not completed by the end of the QA inspectors shift and appeared to be progressing in general conformance with the contract documents.

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Field Splice 3E/4E C-1 (First side-inside)

The QA inspector periodically observed QC inspector Jessie Cayabyab performing Magnetic Particle Testing (MT) at Y location identified as 0-350mm. The QC inspector marked several areas for minor grinding/blending and weld repair in which ABF welding personnel Chun Fai Tsui was present to address. The welder was observed performing SMAW utilizing E7018 H4R electrodes in accordance with WPS noted as ABF-WPS-D1.5-1040-A followed by grinding/blending. The pre heat and interpass temperature was verified by the QC inspector and the work progressed throughout the morning shift, was completed and appeared to be in general conformance with the contract documents.

The QA inspector spent a portion of the shift updating the tracking files, drawing diagrams, QCP addendums and RFI log for this contract.

Summary of Conversations:

No significant conversations held on this date for this contract.

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