

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 #: 1x.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013957**Date Inspected:** 10-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1130**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Bonifacio Daquinag Jr.**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:** OBG Sections**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Craig Hager was on site at the job site between the times noted above. This QA Inspector was on site to randomly observe Quality Control (QC) personnel perform Non-Destructive Testing (NDT) and to monitor American Bridge/Fluor (ABF) welding operations.

The following observations were made:

1) Production welding was being performed at E4/E5 – A1 thru A5; ABF welding personnel James Zhen (#6001) and Chun Fai Tsui (#3426) with QC Inspector Bonifacio Daquinag Jr. present.

2) Production welding was being performed at E4/E5 – D1 thru D2-inside; ABF welding personnel Jordan Hazelaar (#2135) and Mitch Sittinger (#0315) with QC Inspector Jim Cunningham present.

At weld joint E4/E5 – A1 thru A5 this QA Inspector randomly observed ABF welding personnel James Zhen (#6001) and Chun Fai Tsui (#3426) using the Shielded Manual Arc Welding (SMAW) process in the root area of the weld joint. An SMAW welding pass was being placed on each side of weld joint. This QA Inspector randomly observed QC Inspector Bonifacio Daquinag Jr. monitoring the welding. This QA Inspector observed QC Inspector Bonifacio Daquinag Jr. verify the following welding parameters: 158 amperes for James Zhen (#6001) using a 4 mm diameter E7018 electrode and 151 amperes for Chun Fai Tsui (#3426) using a 3.2 mm diameter E7018 electrode. The welding observed appeared to comply with WPS - ABF-WPS-D15-F1200A. While performing verifications this QA Inspector observed the first 120 mm of weld joint E4/E5 – A1, the last 120 mm of weld joint E4/E5 – A5 and approximately 120 mm on both edge plates (B and F) had been welded using the

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SMAW process. QC Inspector Bonifacio Daquinag Jr. informed this QA Inspector that ABF personnel had elected not to use weld run off tabs and cascade the Submerged Arc Welding (SAW) passes at each end later filling in any areas with the SMAW process if needed. Please see photo below.

At weld joint E4/E5 – D1 and D2 this QA Inspector randomly observed ABF welding personnel Jordan Hazelaar (#2135) and Mitch Sittinger (#0315) using the SAW process for production welding. This QA Inspector randomly observed QC Inspector Jim Cunningham monitoring the welding and verify the following welding parameters; 550 amperes and 30.8 volts with a 432 mm per minute travel speed. The welding observed appeared to comply with WPS - ABF-WPS-D15-4042B-1.

This QA Inspector observed welding was in progress at the end of the shift and providing this information in a turnover to the next shift.



Summary of Conversations:

As noted above.

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:	Hager,Craig	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
